

# Fillamentum PP 2320

(Polypropylene)

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**Printing temperature:** 225 - 245 °C

**Heated bed temperature:** 90 - 105 °C

**Speed:** 20 - 40 mm/s

**Part cooling fan:** 0 - 50 %

**Hotbed surface:** Polypropylene plate, mirror / glass

**Adhesive:** Magigoo PP

**Raft / skirt / brim:** Brim 10 mm / raft

**Heated chamber / enclosure:** recommended

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### Adhesion

- You can also print PP on the packing tape. In that case we recommend using with raft, because PP can easily adhere to well to packing tape.

### Storing

- Airtight bag with silica gel.

### Cooling

- For standard maximum part cooling fan speed is 15 % from 10th layer. If you are printing difficult parts/ models with overhangs and supports, you can go up to 50 %. Be careful with the part cooling fan speed - too much flow can increase warping effect.

### Printing

- Printing bridges with PP could be challenging, for standard use we recommend using supports as it really helps and avoids print fails.
- Stronger parts can be achieved by increasing the temperature up to 240-245 °C, where layers adhere more.
- Printing very small features is hard. We recommend avoiding them in the models, as they could deform/ print not well.
- Printing in vase mode is almost impossible without heated chamber. Material shrinks very much.