

RE CRE US

**PP3D THE UNIQUE
POLYPROPYLENE
FILAMENT FOR
"3D PRINTING"
WITH A
"3D PRIMER"
SPECIFIC TO
IMPROVE THE
RESULTS OF YOUR
PRINT.**

PP·3D

PRINTING PROPERTIES RECOMMENDED

- Printing temperatures - **235°C**
- Printing speed - **40 mm/s**
- Hot-bed temperature - **40°C with primer**
- Optimal layer height - **0.2 mm**
- Minimal nozzle diameter - **0.4 - 0.6 mm**
- Retraction parameters
 - in direct drive (DD) - **3.2 mm**
- Retraction parameters
 - in bowden type (BT) - **6 mm**
 - Retraction speed
 - in direct drive (DD) - **40 mm/s**
 - Retraction speed
 - in bowden type (BT) - **25 mm/s**
 - Travelling speed - **150 mm/s**
 - Outer perimeters - **25 mm/s**
 - Inner perimeters - **30 mm/s**
 - Layer fan regular - **0%**
 - Layer fan in layer
 - below 15 sec - **80%**
 - First layer adhesion brim
 - depending on the part dimensions - **5-10 mm**

Brass nozzle recommended - **Yes**

*Creativity
is Flexible*
RECREUS.COM

PP·3D PRIMER

INSTRUCTIONS TO USE RECREUS 3D PRIMER

To obtain the best results in your print, please, read with attention and follow the next instructions before use PP3D filament and Recreus 3D primer:



1º
Open the primer bottle and apply it in the printing area.



2º
Wait about 5 min. before print to let the primer dry.



3º
Set bed temp to 40°C (not more temperature if not the part will warp).



4º
When the part is finished, heat up the bed up to 85°C to release the printed part.



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