

3D printing guide

Fillamentum CPE HG100

(Co-Polyester)

Printing temperature: 255-275 °C

Heated bed temperature: 70-85 °C

Speed: 40-60 mm/s

Part cooling fan: 0-15 %

Heated bed surface: PEI, mirror/glass

Adhesive: Magigoo, 3DLac, PVA glue

Raft/skirt/brim: Skirt, Brim 5mm

Heated chamber/enclosure: not needed

Cooling - It is not recommended to use more than 15 % of fan speed, as too much cooling could lead into improper layer bonding. We recommend to use no cooling for standard objects, which leads into stronger parts. For bridges and big overhangs, it is possible to go up to 50 % for the desired layer.

Storing - Airtight bag with desiccant.

In case of moist material, re-dry it in appropriate device. The conditions to achieve optimal level of moisture are 75 °C for 4 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing etc.