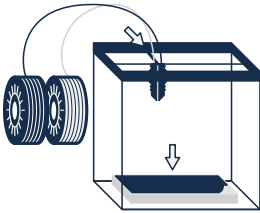
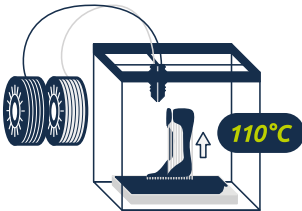


## How to use *P-support 279*

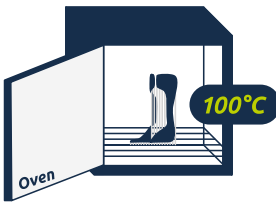


- 1 Place *P-filament 721*, *P-support 279*, and *P-surface 141* into your 3D printer. For *P-support 279*, use the **3D printing parameters** of soluble support materials, meaning use no vertical off set between support layer and PP layer. Furthermore, *P-support 279* is well suited for printing a raft.



- 2 In order to be able to remove the **finished printed part** together with the support structure non-destructively, you must heat the printing bed to **100 – 110°C** (protective gloves required).

**Caution hot**



- 3 In order to be able to **remove the support structure** from the printed part, the compound structure has to be heated in an oven to **100 – 110°C**. Alternatively immerse in boiling water.



- 4 Once *P-support 279* is **completely warmed up to 100 – 110°C**, it can be immediately peeled off manually from the 3D printed part in its warm chewing gum-like state (protective gloves required). Alternatively the support material can be removed after cooling and solidification.

## Recommended printing parameters

<b>3D printing surface</b>	<i>P-surface 141</i> (required)	
<b>Extruder temperature</b>	200 – 220°C (larger nozzle diameter higher temperature)	
<b>Printing bed temperature</b>	During the first layer	70 – 80°C
	During 3D printing	20°C
	Removal of printed parts	100 – 110°C
<b>Heated 3D printing chamber</b>	Not required	