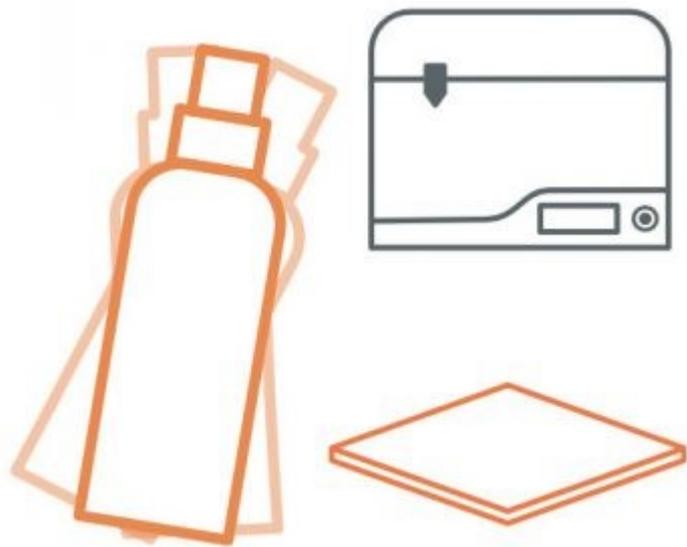


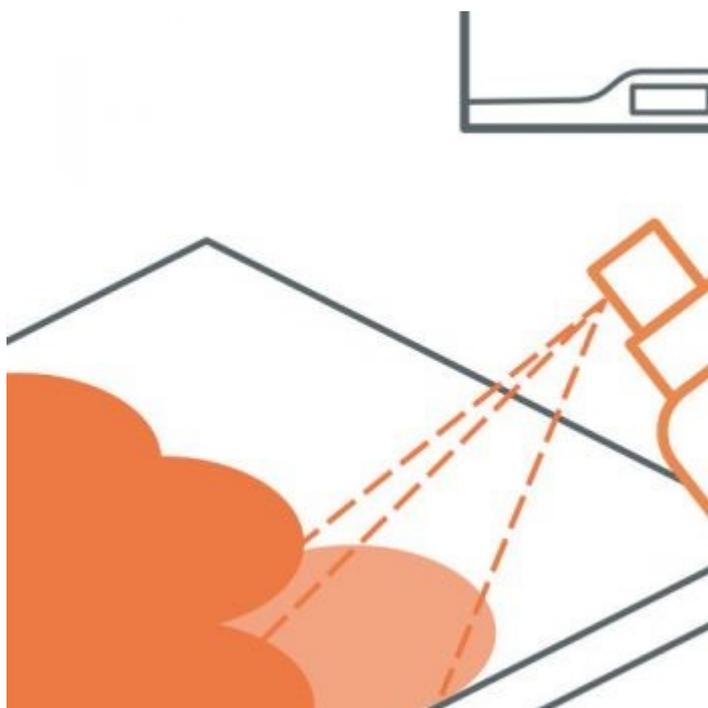
## PrintaFix

# Manual



## Preparation

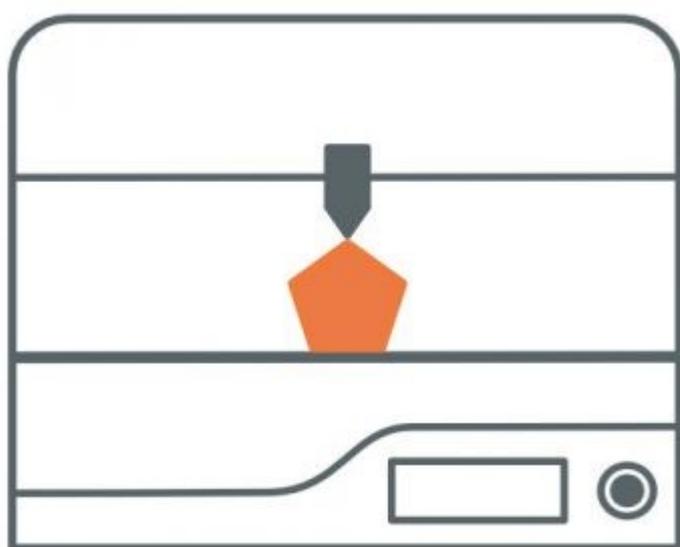
Remove the printbed from the printer. The printbed should be at room temperature and without damage. Remove all dust and residue from previous prints from the printbed. Place it on a table and shake the PrintaFix bottle well for 5 seconds.



## Application

## Application

Hold the PrintaFix bottle 10cm (4") away from the printbed. Use enough spray strokes to cover the entire printbed with a thin film of the solution. Overlap spray strokes to prevent uncovered areas that could affect the adhesion. Let it dry for 30 seconds.



## Print

Put the printbed back into the 3D printer and level it. Start the print process with our recommended settings. We have tested our product with many materials and settings (see below).



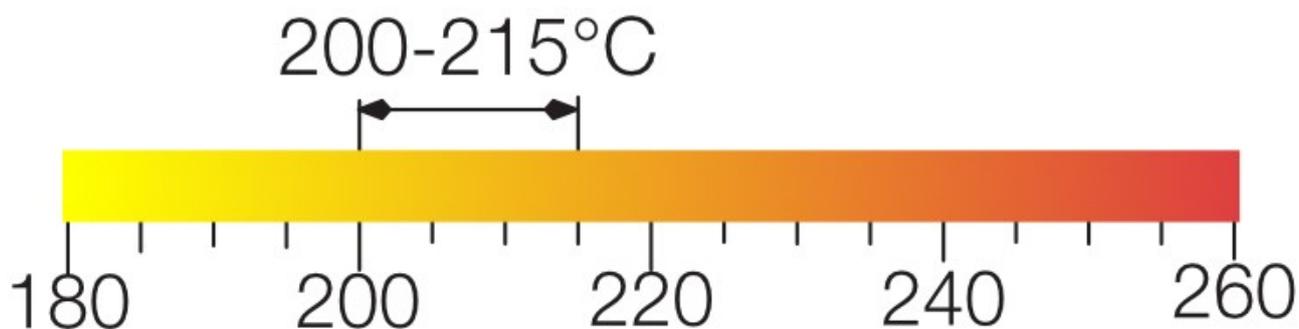
## Clean up

When your print has finished remove it carefully with a spatula. Clean up of PrintaFix can be done with warm water, PrintaClean or an alcoholic solution. Window cleaner might also work – please check if they contain ethanol.

# Recommended Settings

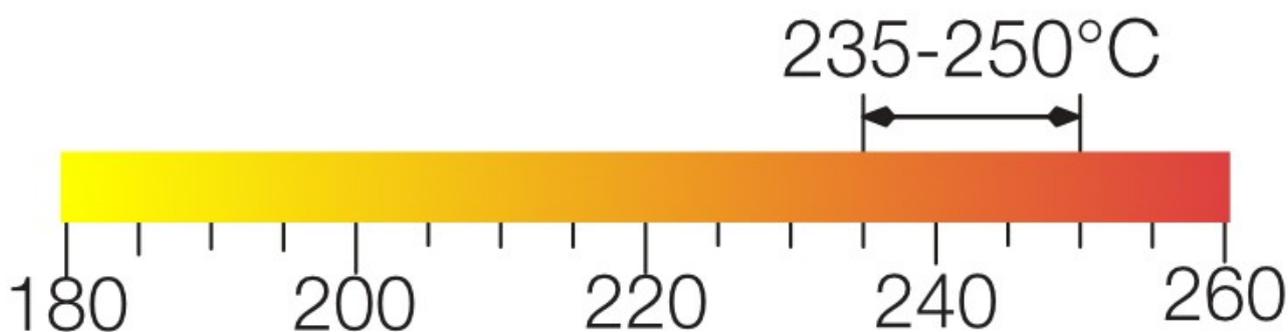
## PLA

### Printing temperatur °C



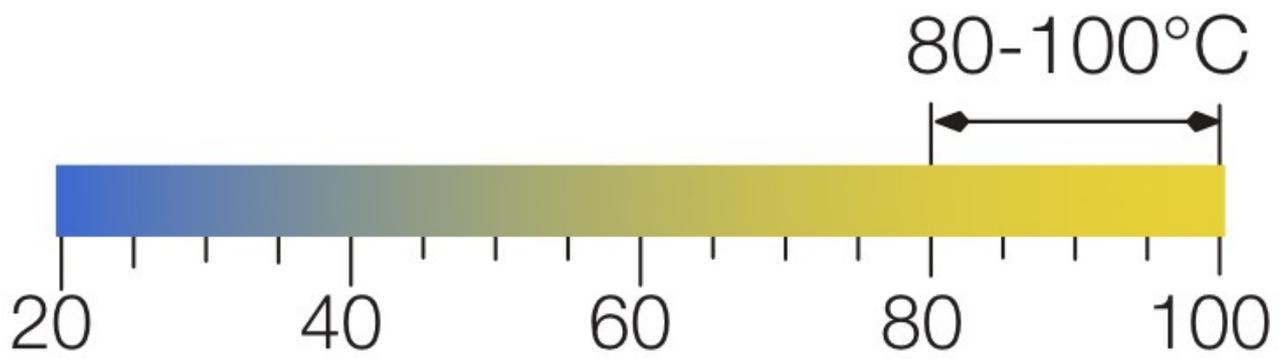
## ABS

### Printing temperatur °C



### Printbed temperature °C

80-100°C



**Buy now**

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**PrintaMent**

## Cheat Sheets

Find it hard to get good temperature settings for your 3D printer? That's why we provide you with the recommended settings for PrintaMent to achieve the best print quality on all major 3D printers.

### PrintaMent PLA

Printing T

Bed  
Temperature

Printing  
Speed

Fan Speed 2nd  
Layer

Flow  
Rate

	Printing T	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	195°-220°C	off*   >65°C	Up to 70 mm/s	100%	100%
Ultimaker 2	195°-220°C	off*   >65°C	Up to 80 mm/s	100%	100%
Ultimaker 2+	195°-220°C	off*   >65°C	Up to 80 mm/s	100%	100%
Ultimaker 3	195°-220°C	off*   >65°C	Up to 80 mm/s	100%	100%
BQ Wittbox 1	190°-215°C	n.A.*	Up to 60 mm/s	100%	100%
BQ Wittbox 2	190°-215°C	n.A.*	Up to 60 mm/s	100%	100%
BQ Hephestos	190°-215°C	n.A.*	Up to 60 mm/s	100%	100%
Prusa i3	190°-215°C	off*   >65°C	Up to 60 mm/s	100%	100%
Prusa i3 MK2	190°-215°C	off*   >65°C	Up to 60 mm/s	100%	100%

\*coated with [PrintaFix](#)

## PrintaMent PET-G

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	240°-250°C	65°-70°C*	Up to 50 mm/s	50%	104%
Ultimaker 2	240°-250°C	65°-70°C*	Up to 60	50%	104%

Ultimaker 2	240°-250°C	65°-70°C*	Up to 60 mm/s	50%	104%
Ultimaker 2+	240°-250°C	65°-70°C*	Up to 60 mm/s	50%	104%
Ultimaker 3	240°-250°C	65°-70°C*	Up to 60 mm/s	50%	104%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3	220°-240°C	65°-70°C*	Up to 50 mm/s	50%	104%
Prusa i3 MK2	220°-240°C	65°-70°C*	Up to 50 mm/s	50%	104%

\*coated with [PrintaFix](#)

## PrintaMent M-ABS

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	230°-250°C	65°C*	Up to 45 mm/s	20%	100%
Ultimaker 2	230°-250°C	65°C*	Up to 50 mm/s	20%	100%
Ultimaker 2+	230°-250°C	65°C*	Up to 50 mm/s	20%	100%
Ultimaker 3	230°-250°C	65°C*	Up to 50	20%	100%

Ultimaker 3	230°-250°C	65°C*	Up to 50 mm/s	20%	100%
BQ Wittbox 1	225-245°C	n.A.**	Up to 45 mm/s	20%	100%
BQ Wittbox 2	225-245°C	n.A.**	Up to 45 mm/s	20%	100%
BQ Hephestos	225-245°C	n.A.**	Up to 45 mm/s	20%	100%
Prusa i3	225-245°C	65°C*	Up to 45 mm/s	20%	100%
Prusa i3 MK2	225-245°C	65°C*	Up to 45 mm/s	20%	100%

\*coated with [PrintaFix](#)

\*\* we recommend to coat it with [PrintaFix](#) and use 20 perimeters of Brim

## PrintaMent METAL

We recommend to use a harden nozzle with a minimum of 0,5mm.

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate	Retraction
BCN3D Sigma	195°-220°C	off*   65°C	Up to 45 mm/s	100%	102%	4,4mm
Ultimaker 2	195°-220°C	off*   65°C	Up to 45 mm/s	100%	102%	4,4mm
Ultimaker 2+	195°-220°C	off*   65°C	Up to 45 mm/s	100%	102%	4,4mm
Ultimaker 3	195°-220°C	off*   65°C	Up to 45 mm/s	100%	102%	4,4mm

mm/s

BQ Wittbox 1	190°-215°C	n.A.*	Up to 40 mm/s	100%	102%	1,6mm
BQ Wittbox 2	190°-215°C	n.A.*	Up to 40 mm/s	100%	102%	1,6mm
BQ Hephestos	190°-215°C	n.A.*	Up to 40 mm/s	100%	102%	1,6mm
Prusa i3	190°-215°C	off*   65°C	Up to 45 mm/s	100%	102%	1,6mm
Prusa i3 MK2	190°-215°C	off*   65°C	Up to 45 mm/s	100%	102%	1,6mm

\*coated with [PrintaFix](#)

## PrintaMent WOOD

We recommend to use a harden nozzle with a minimum of 0,5mm.

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate	Retraction
BCN3D Sigma	205°-220°C	off*   65°C	Up to 35 mm/s	35%	103%	4,4mm
Ultimaker 2	205°-220°C	off*   65°C	Up to 35 mm/s	35%	103%	4,4mm
Ultimaker 2+	205°-220°C	off*   65°C	Up to 35 mm/s	35%	103%	4,4mm
Ultimaker 3	205°-220°C	off*   65°C	Up to 35 mm/s	35%	103%	4,4mm
BQ Wittbox 1	200°-215°C	n.A.*	Up to 30 mm/s	35%	103%	1,7mm
BQ Wittbox	200°-215°C	n.A.*	Up to 30	35%	103%	1,7mm

BQ Wittbox 2	200°-215°C	n.A.*	Up to 30 mm/s	35%	103%	1,7mm
BQ Hephestos	200°-215°C	n.A.*	Up to 30 mm/s	35%	103%	1,7mm
Prusa i3	200°-215°C	off*   65°C*	Up to 30 mm/s	35%	103%	1,7mm
Prusa i3 MK2	200°-215°C	off*   65°C	Up to 35 mm/s	35%	103%	1,7mm

\*coated [PrintaFix](#)

## PrintaMent PET-G CF20

We recommend to use a harden nozzle with a minimum of 0,5mm.

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate	Retraction
BCN3D Sigma	245°-260°C	65°-70°C*	Up to 45 mm/s	50%	100%	4,4mm
Ultimaker 2	245°-260°C	65°-70°C*	Up to 45 mm/s	50%	100%	4,4mm
Ultimaker 2+	245°-260°C	65°-70°C*	Up to 45 mm/s	50%	100%	4,4mm
Ultimaker 3	245°-260°C	65°-70°C*	Up to 45 mm/s	50%	100%	4,4mm
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	n.A.	n.A.
BQ	n.A.	n.A.	n.A.	n.A.	n.A.	n.A.

BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3	220°-240°C	65°-70°C*	Up to 40 mm/s	50%	100%	1,6mm
Prusa i3 MK2	220°-240°C	65°-70°C*	Up to 45 mm/s	50%	100%	1,6mm

\*coated with [PrintaFix](#)

## PrintaMent PVA-M

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	190°-210°C	>55°C*	Up to 30 mm/s	70%	105%
Ultimaker 2	n.A.	n.A.	n.A.	n.A.	n.A.
Ultimaker 2+	n.A.	n.A.	n.A.	n.A.	n.A.
Ultimaker 3	190°-210°C	>55°C*	Up to 30 mm/s	70%	105%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3 MK2	n.A.	n.A.	n.A.	n.A.	n.A.

\*coated with [PrintaFix](#)

\*coated with [PrintaFix](#)

## PrintaMent HIPS

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	240°-270°C	90°-110°C	Up to 40 mm/s	50%	100%
Ultimaker 2	240°-270°C	90°-110°C	Up to 45 mm/s	50%	100%
Ultimaker 2+	240°-270°C	90°-110°C	Up to 45 mm/s	50%	100%
Ultimaker 3	240°-270°C	90°-110°C	Up to 45 mm/s	50%	100%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3	225°-245°C	90°-110°C	Up to 45 mm/s	50%	100%
Prusa i3 MK2	225-245°C	90°-110°C	Up to 45 mm/s	50%	100%

## PrintaMent PC-ABS

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	275°-285°C	85°-95°C*	Up to 50 mm/s	max. 5%	103%

BCN3D Sigma	275°-285°C	85°-95°C*	Up to 50 mm/s	max. 5%	103%
Ultimaker 2	275°-285°C	85°-95°C*	Up to 50 mm/s	max. 5%	103%
Ultimaker 2+	275°-285°C	85°-95°C*	Up to 50 mm/s	max. 5%	103%
Ultimaker 3	275°-285°C	85°-95°C*	Up to 50 mm/s	max. 5%	103%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3	250°-265°C	85°-95°C*	Up to 50 mm/s	max. 5%	102%
Prusa i3 MK2	250°-265°C	85°-95°C*	Up to 50 mm/s	max. 5%	102%

\*coated with UHU Stick or 3DLac

\*\*works best with a freshly cleaned PEI surface

## PrintaMent PC-ABS V0 (Flame Retardant)

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	280°-290°C	85°-95°C*	Up to 50 mm/s	max. 5%	101%
Ultimaker 2	280°-290°C	85°-95°C*	Up to 50 mm/s	max. 5%	101%

mm/s

Ultimaker 2+	280°-290°C	85°-95°C*	Up to 50 mm/s	max. 5%	101%
Ultimaker 3	280°-290°C	85°-95°C*	Up to 50 mm/s	max. 5%	101%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	n.A.
BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.
Prusa i3	260°-270°C	85°-95°C*	Up to 50 mm/s	max. 5%	101%
Prusa i3 MK2	260°-270°C	85°-95°C**	Up to 50 mm/s	max. 5%	101%

\*coated with UHU Stick

\*\*works best with a freshly cleaned PEI surface

## PrintaMent PC

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	280°-290°C	100°-105°C*	Up to 50 mm/s	0%-10%	100%
Ultimaker 2	280°-290°C	100°-105°C*	Up to 50 mm/s	0%-10%	100%
Ultimaker 2+	280°-290°C	100°-105°C*	Up to 50 mm/s	0%-10%	100%

mm/s

Ultimaker 3	280°-290°C	100°-105°C*	Up to 50 mm/s	0%-10%	100%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	100%
BQ Wittbox 2	n.A.	n.A.	n.A.	n.A.	100%
BQ Hephestos	n.A.	n.A.	n.A.	n.A.	100%
Prusa i3	270°-280°C	100°-105°C*	Up to 45 mm/s	0%-10%	100%
Prusa i3 MK2	270°-280°C	100°-105°C*	Up to 45 mm/s	0%-10%	100%

\*coated with UHU Stick or 3DLac

## PrintaMent SEMIFLEX

	Printing Temperature	Bed Temperature	Printing Speed	Fan Speed 2nd Layer	Flow Rate
BCN3D Sigma	240°-250°C	85°-95°C**	Up to 45 mm/s	40%	100%
Ultimaker 2	240°-250°C	85°-90°C*	Up to 45 mm/s	40%	100%
Ultimaker 2+	240°-250°C	85°-95°C*	Up to 45 mm/s	40%	100%
Ultimaker 3	240°-250°C	85°-95°C*	Up to 45 mm/s	40%	100%
BQ Wittbox 1	n.A.	n.A.	n.A.	n.A.	n.A.

1

BQ Wittbox	n.A.	n.A.	n.A.	n.A.	n.A.
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2

BQ Hephestos	n.A.	n.A.	n.A.	n.A.	n.A.
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Prusa i3	235°-245°C	85°-95°C*	Up to 50 mm/s	40%	100%
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Prusa i3 MK2	235°-245°C	85°-95°C*	Up to 50 mm/s	40%	100%
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\*coated with UHU Stick or 3DLac