

3D printing guide

Fillamentum OBC 905

(Olefin Block Copolymer)

Printing temperature: 215–195 °C

Hotbed temperature: 90–105 °C

Speed: 20–40 mm/s

Part cooling fan: 25–50 %

Hotbed surface: Glass/Mirror, Lockpad, (PEI)

Adhesive: Magigoo PP (packaging pp tape)

Raft/skirt/brim: Brim 10 mm / raft

Heated chamber/enclosure: not required, but it helps

Adhesion – We recommend to use Magigoo PP for the bed preparation, wide brim is also recommended

Cooling – for standart models maximum part cooling fan speed is 25 to 50 % from 5th layer. If you are printing difficult parts/models with overhangs and supports, you can go up to 75 %. Be careful with the part cooling fan speed – too much flow can increase warping effect.

Speed - Around 30-35mm/s is good starting point as this material is flexible. Depending on the printer and the settings.

Extrusion – Recommended settings is 1.05 - 1.1 for extrusion multiplier due to flexibility of the filament. This gave us the best results.