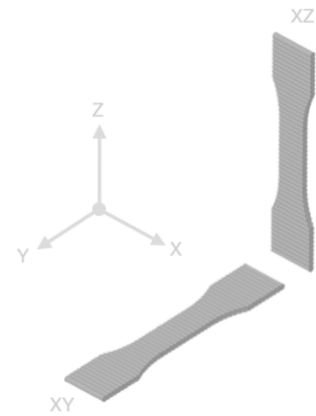


### FL400PP-S

Xtellar PP Support Breakaway Filament is an elite filament, specifically engineered to be the perfect support material for polypropylene (PP) applications. It boasts a remarkable ability to leave a clean, smooth surface on your prints once the support structure is removed. Renowned for its ease of printing, this filament ensures a hassle-free experience, making it ideal even for complex structures. Xtellar PP Support Breakaway Filament is the go-to choice for professionals seeking precision and quality in their PP projects.

### Printing Conditions

Nozzle Temperature	265°C
Bed Temperature (1 <sup>st</sup> layer)	80°C (90°C)
Printing Speed	20-60 mm/s
Fan Speed	25-75%
Nozzle Type	Brass
Bed Material	Garolite or Glass
Bed Adhesion Method	Magigoo PP or HT
Support Interface Print Speed	10-20 mm/s
Part to Support Gap Spacing	No Gap



### Property

Property	Standard	XY
Density @ 23°C, g/cm <sup>3</sup>	ASTM D792	1.19
Tensile Strength @ Break, MPa	ASTM D638	40.1 ± 1.5
Tensile Elongation @ Break, %	ASTM D638	20.0 ± 10.3
Tensile (Young's) Modulus, MPa	ASTM D638	1,562 ± 78

### Printing Notes

When using our PP support 3D printing material, it is crucial to print it directly onto the primary material without any Z height gaps for optimal adhesion. To further enhance this bond, use solid interface layers with the PP support material, maximizing the surface area contact with the primary material. During the printing process, it's important to maintain a slow print speed for both the support material and the primary material, ensuring better precision and stronger attachment. Additionally, avoid using fan cooling when printing interface layers, as this will help to maximize the interfacial area, leading to a more robust bond between the materials.