

Instructions HT Material

## How does HT adhesive work

This product is designed to work with high-temperature material extrusion 3D printing filaments including Essentium PEEK, PEKK, and it is ideal for maximum adhesion of Essentium PCTG.

This adhesive is designed to ensure prints stick firmly when the print-bed is hot and that the part is easy to remove once cooled.

## How to apply

- 1 Shake the bottle
- 2 Press the nib (end of the glue pen) on the printing bed for glue to flow.
- 3 Spread the adhesive evenly on the printing area. A second application upon dried layer is recommended for large challenging prints.

Application should be done on a cool bed, which has been appropriately cleaned preferably with water and then with isopropyl alcohol. Apply the adhesive liberally to the bed by firmly pressing the nib against the bed and spreading evenly. **DO NOT** press the sides of the bottle until the actuator in the nib head has been properly activated. **Warning:** Do not apply when bed is hot.

## How to store

The product is best stored upright, with the cap closed and away from direct sunlight.

## Recommended printing settings

Ideal settings for different HT filaments may vary.

### Settings and recommendations:

- Bed and nozzle temperature: follow Essentium TDS recommendations. Bed temperatures up to 150 °C are common.
- Some prints may benefit from a 10-20mm single layer brim for optimal adhesion.

## Part Removal and Cleaning

After your prints have finished, cooled and been removed, clean the cool printing bed by wiping it with a damp cloth. Use plain water.

In case of excess adhesion, it is recommended to wet print bed with a small amount of water, and slowly work it below the part, this should make part removal easier.

## Feedback

We want to learn more about your experiences. We're here for good and bad. Get in touch by emailing us at [feedback@magigoo.com](mailto:feedback@magigoo.com).

