Magigoo Pro 3D Printing Adhesive for TPEs

Technical Data Sheet*

Ver 1.0 September 2019

*This document has been conscribed to the best of our knowledge. Verifications should be made to confirm details when necessary.

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Description:

MAGIGOO® - Flex (Flexible filaments – TPUs, TPEs), is an all-in-one 3D printing adhesive that offers sure adhesion with easy removal for flexible materials. MAGIGOO® - Flex, has been specifically formulated for flexible filaments to ensure that it provides an easy to use solution to reduce warping in FDM/FFF 3D printers. Warping, among other factors, is caused by the differential cool of a print during a 3D printing process. MAGIGOO® - Flex is purposely developed to reliably and repeatably minimise warping during FDM/FFF printing of flexible materials.

Technical specifications:

- **Appearance:** clear-faint yellow liquid
- **Consistency:** low-med viscosity
- **Solvent:** water

Intended use:

To be used on FDM/FFF 3D printers with a heated bed on glass surfaces. Also works when applied on sheets e.g. Kapton, PEI and similar. To be used with flexible filaments.

Properties:

MAGIGOO® - Flex, acts as a thermally activated interfacial layer, allowing for better interactions, both at the micro and molecular level, between the printing bed and the printing materials. It is generally recommended to print according to the printing temperatures recommended by the filament supplier. The printing conditions vary between one printer and another.

To find the best temperature one could start from the lower end of the recommended settings and increase the bed temperature in 5 °C increments. This should be done with standardised calibration prints.

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An additional benefit of MAGIGOO® - Flex, being thermally activated, is that it will enable the print to be easily removed upon cooling. Keep in mind that different printers, print surfaces or filaments will behave differently. Some flexible materials can also be removed by applying water around the printed part – we recommend that you take the build surface out of the printer prior to this step! After waiting for the water to penetrate between the part and the build surface and one can easily remove the part

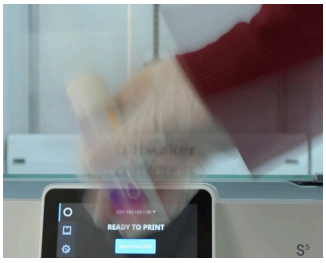
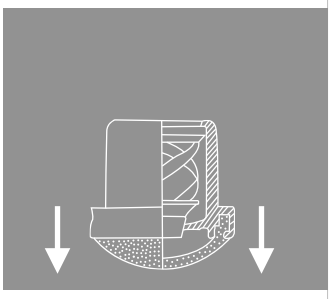
Cleaning and re-applying between prints is recommended especially on longer prints or hard to print with materials.

Storage and Handling:

MAGIGOO® - Flex, should be stored in a cool dry place away from direct sunlight. After use MAGIGOO® - Flex should be stored in an upright position and with the cap on.

Excess MAGIGOO® - Flex on the nib can cause the applicator adhering to the cap. To prevent this, make sure no excess MAGIGOO® - Flex remains on the rim of the applicator after use.

If not capped the MAGIGOO® - Flex applicator will dry up. In such a case just rinse with water.

Step 1: **Shake the bottle vigorously.** NB! Shaking too much might cause bubbling. This does not negatively affect adhesion but does not provide a mirror finish on the bottom of the print	
Step 2: **Press nib against the surface.** NB! The Magigoo – Flex container is spring activated. Pressing the bottle without pressing the nib against the bed may result in applicator popping off and product wastage.	
Step 3: **Apply liberally to desired area** NB! For better adhesion of challenging prints, apply one layer first. Let it dry and apply another layer on top.	
Step 4: **Print** NB! After print, wait until the build plate is cool to remove prints easily. Apply water around the part and wait for a few minutes before attempting removal if part is hard to remove.	
Step 5: **Clean** NB! Just wipe off with a damp cloth. Use just water.	

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