magigoo

Instructions Metal

How does Magigoo work ?

MAGIGOO® Metal for Ultrafuse® 316L is designed to to be used with Ultrafuse® 316L FDM filament on heated build surfaces.
The adhesive provides reliable adhesion and prevents warping during the FDM printing process.

MAGIGOO® Metal is also non-hazardous and enables the easy removal of the green parts by submersion in water.

How to apply

1. Shake the MAGIGOO ® Metal pen.
2. Press the nib (end of your pen) on the printing bed for MAGIGOO ® Metal to flow.
3. Spread a thin coat of the adhesive evenly on the printing area.

Apply adhesive 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, else the applicator might pop out. Application should be done on a cool bed which has been appropriately cleaned. **Warning:** Ensure proper bed calibration. Having nozzle too close to bed surface may cause excess adhesion leading to increased effort in the part removal process.

How to store

MAGIGOO® Metal is best stored upright, with the cap closed and away from direct sunlight.

Recommended printing settings

MAGIGOO ® Metal has been tested to give the best printing experience using the following settings on a glass build plate. Different printers and build surfaces might require that the printing settings are adjusted for optimal adhesion.

Settings
- Bed temperature: 90-110 °C.
- First layer extrusion width: 80-100%*
- Enclosed build-chamber: recommended.

* slightly lowering the first layer extrusion width facilitates the part removal process, this setting will also depend on the first layer calibration and might impair adhesion in cases where the nozzle is too far away from the build-plate

Part Removal

The easiest way to ensure safe removal of the green part from the build plate without damaging it is to submerge the build-plate in water. Depending on the size of the printed part, after 30 minutes - 2 hours, the part should become free from the build plate and be easy to remove with minimal effort. In cases where the buiild-plate cannot be submerged in water, one can soak around the part with water and wait for the water to make its way under the part before attempting removal. It is recommended to avoid the use of part removal tools or excess force since part can be easily damaged in the green state.

We love feedback

Where to send feedback or concerns
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**. Let's improve Magigoo together.

magigoo.com