



PRINTING THE PLASTIC PARTS FOR ORIGINAL PRUSA PRINTERS

We have decided to prepare a short guide explaining how to print the printer parts with ease.

PRINTING THE PLASTIC PARTS FOR YOUR PRINTER

Almost all* of Prusa 3D printed parts are from PETG, but if you are more used to printing with ASA/PC, you can absolutely use it for printing the parts instead of PETG.

*for Fan-shroud part, please use ASA/PC

To print all the parts properly, please follow this guide:

1. Clean the print surface
2. Download G-codes or .stl files for the upgrade from prusa3d.com/prusa-i3-printable-parts. These G-codes are for PETG only! If you want to prepare your own G-codes, use PETG or similar material settings with at least 20% grid infill.
3. Start the print, wait and observe the first few layers.
4. If you suspect that the first layer does not stick properly, tweak the Live adjust Z value. You can do it from the menu while printing. Press the **Knob, select Live adjust Z and then lower the value slowly until the plastic sticks nicely**. If object is already detached from the print surface, clean up and start the print again.
5. Once the print is finished, wait until the heatbed cools down to ambient temperature. **Do not remove the printed objects right away**. Otherwise, you might damage the print surface.
6. Once the parts are ready, you can just follow the manual for your printer upgrade available at help.prusa3d.com.

TROUBLESHOOTING

If you struggle with printing plastic parts, here are some troubleshooting tips to help you out.

- Make sure the print surface is clean. If the Windex didn't work, try to clean the surface **with dish soap water** (dish soap water can actually **dissolve sugar residue**).
- For smooth PEI try to use the bundled glue stick, which increases adhesion for PETG and creates a separation layer.
- Generate your own G-codes using **PrusaSlicer**. Select PETG or similar material with at least 20% grid infill. Place only 2-3 objects around the center of the heated bed for each individual G-code.
- If none of that made any difference, try to start the print and slower the print speed to 70-80%. You can do that by **rotating the knob in the counterclockwise direction**.

If you have any issues with printing the plastic parts, do not hesitate to contact our support team through Live chat or e-mail info@prusa3d.com.