PRUSA
RESEARCH
by **JOSEF PRUSA**

Printing the plastic parts for the Original Prusa i3 MK3S/MK2.5S/MMU2S

Thank you for purchasing the Original Prusa i3 upgrade! Since it will be fully up to you to print the parts, we have decided to prepare a short guide explaining how to do it with ease.

PRINTING THE PLASTIC PARTS FOR THE UPGRADE

By default, you are supplied with a small spool of PETG, but if you are more used to printing with ABS, you can absolutely use it for printing the upgraded parts instead of PETG.

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

1. Clean the print surface with **Windex**.
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 ABS 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 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 PEI surface.
6. Once the parts are ready, you can just follow the manual for your printer upgrade available at manual.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**).
- Try to use the bundled glue stick, which increases PEI adhesion for PETG and creates a separation layer.
- Generate your own G-codes using **Slic3r PE**. S elect PETG or ABS 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**.

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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.

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