Table of Contents

How to post-process the printed parts

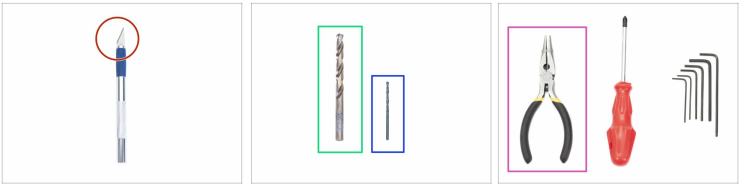
help.prusa3d.com/g18680

Scan the QR code to display the latest version of this chapter.

STEP 1 Why to post-process the printed parts?

- This guide will explain in detail, **how to post-process printed parts** used on Original Prusa i3 printers **to ensure easy assembly afterwards**.
- **Some printed parts** designed for Original Prusa printers **require post-processing**. Skipping this part might cause issues and damage to the parts during the assembly.
- 3D printing is a very accurate manufacturing process, but there are some factors, which can affect the final printed part:
  - **Temporary supports** - must be removed after the print
  - **Different material properties** - not all PETG or ABS are equal
  - **Defects in prints** - strings, imperfections due to the geometry

STEP 2 Tools used for the post-processing



⚠ **WARNING:** following tools can easily harm you. Make sure you read the manual from the tool manufacturer!

⚠ **ALWAYS** use protective equipment like safety glasses and gloves.

- **Recommended tools for this manual:**
  - **Sharp and thin cutting blade**, the best option is a scalpel, but utility knife is also possible to use.
  - **Twist drill bits, ideally with a flat head**, but those aren't easy to find. The lower the angle on the bit's head the better. For printed parts you need two sizes:
    - 8.1 mm / 0.3-inch drill bit (or slightly bigger, but not smaller)
    - 3 mm / 0.12-inch drill bit (or slightly bigger, but not smaller)
  - **Pliers with thin/slim jaw are the best**, you can also use the bundled ones, but you might not be able to reach certain places.

STEP 3 Optional tools for post-processing

- Following tools are not needed, though if you want to achieve the perfect shape and look we advise to use them:
  - **Curved/rounded scalpel** - some parts of the printed part are easier to clean with a curved blade.
  - **Heat gun** - certain materials tend to create strings during the print. Easiest way to remove them is by using a flow of hot air.

ⓘ Optimal temperature for the heat gun is 250 °C (482 °F) and blow on the parts from a distance of 10 - 15cm (4 - 6 inches).

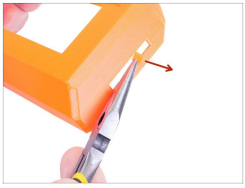
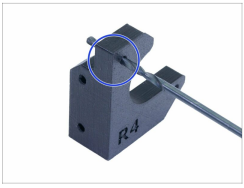
⚠ **WARNING:** Blowing **hot air** from a shorter distance **can damage even melt the part!**

⚠ **Do not touch the HOT PARTS** of the heat gun!!!

STEP 4 Printed parts for post-processing

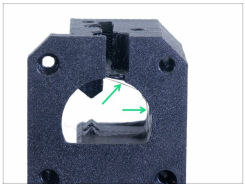
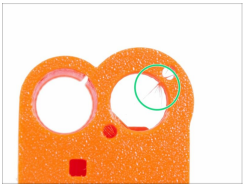
- After the print is finished, all parts should be checked for visible defects. Basic tips are given in:
  - General post processing (tips and tricks)
- Some printed parts require specific post-processing, use the steps listed below:
  - Y-axis parts post-processing
  - X-axis parts post-processing
  - E-axis parts post-processing
  - LCD parts post-processing

STEP 5 General post processing (tips and tricks)

- Use pliers to carefully remove the temporary supports.
- Clean the screw and rod holes using drill bits. Avoid increasing the diameter of the hole.
- Use a scalpel or utility knife and carefully remove the "elephant foot" (squished first layer) from the edges of the printed parts.

STEP 6 General post processing (tips and tricks)


- Use the heat gun to remove the strings on each printed parts.

ⓘ Set the heat gun temperature to 250 °C (482 °F)

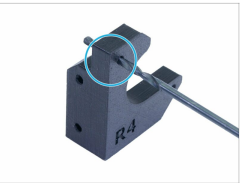
- Blow the printed part from a distance of 10 - 15 cm (4 inch - 6 inch) until the strings melt.

ⓘ Some strings may be thicker and may not simply melt. Remove them with the scalpel.

⚠ **WARNING:** Blowing **hot air** from a shorter distance **can damage the part.**

STEP 7 Y-axis parts post-processing

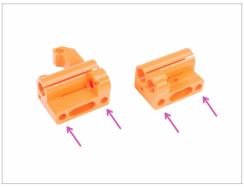
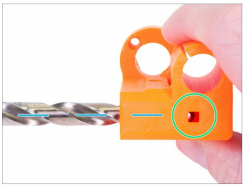
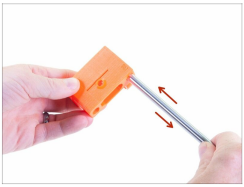




NOTE: This step is for the **MK3S** only

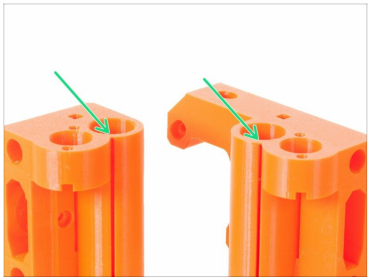
- Use a scalpel to remove debris in the screw groove on the Y-belt tensioner.
- Use a 3 mm (0.12 inch) drill bit to clean all screw holes on the Y-axis plastic parts.

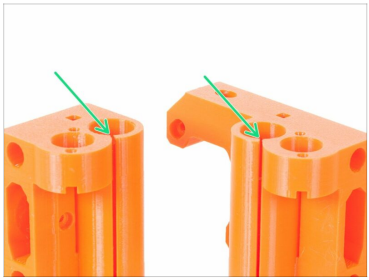
STEP 8 X-axis parts post-processing

- Clean the holes by drill bit 8.1 mm (0.3 inch) in the X-end-motor and the X-end-idler marked in the picture for easier insertion of the rods.
- **The drill bit must be parallel to the hole axis.**
- Check the drill tip position through the square hole. **Do not drill the bottom of the hole!**
- Insert the rod into each cleaned hole. Try to slightly pull in and pull out the rod. **The rod must not move freely in the printed part.**
- Use a 3 mm (0.12 inch) drill bit to clean all screw holes on the X-axis plastic parts.

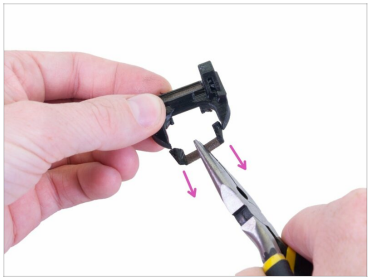
STEP 9 X-axis parts post-processing





- Cut the groove on the top surface of the X-end-motor and the X-end-idler for easier insertion of bearings into the holes.

STEP 10 E-axis parts post-processing



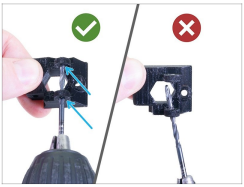
- Use pliers to remove the print support on the fan-shroud.

STEP 11 E-axis parts post-processing



- Cut the groove on the P.I.N.D.A. sensor holder with a scalpel on the extruder-body.
- Use a 3 mm (0.12 inch) drill bit to clean all screw holes on the E-axis plastic parts.

STEP 12 E-axis parts post-processing

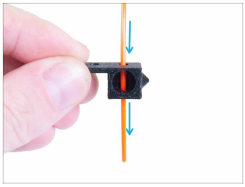


- Drill both holes on the extruder-idler with a 3 mm (0.12 inch) drill bit.

⚠ **It is CRUCIAL to drill both holes at the same time!**

- In the most cases, the printed fs-lever part requires removal of the edge of the first layer. This edge may subsequently cause **malfunction of the filament sensor**.
- Carefully remove the edge with a scalpel, focus on the corner shown in the picture.

STEP 13 E-axis parts post-processing

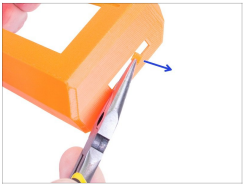
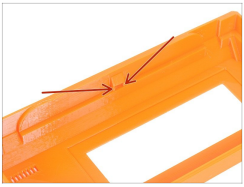


NOTE: This step is for **MK3S/MK2.5S** and you will need the steel ball.

- Insert a piece of filament through the adapter-printer part to clean both filament guiding holes.
- Insert the steel ball and roll with the ball to all sides to ensure smooth movement.
- Push a piece of filament through the hole multiple times to clean it on the fs-cover part. **Do not use 3mm (0.12inch) drill bit for cleaning this hole!**
- Use the 3mm (0.12inch) drill bit for cleaning the screw hole.

NOTE: The filament guiding holes must be properly cleaned!

STEP 14 LCD parts post-processing

- Use pliers and carefully remove the temporary supports in the SD card slot on LCD-cover.
- Remove both temporary supports on the longer side, but keep the inclined part above, which will "lock" the PCB of the LCD in place (see the picture).

Notes:

Notes:

Notes:

Notes: