



PRINT SETTINGS ABS

Nozzle Temp	220°C-250°C
Bed Temp	100°C-120°C
Heated Enclosure	Recommended
Bed Adhesion	Hairspray, glue stick, or increase bed temperature
Drying Settings	60°C for 4 hours

Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height

230°C Extruder 110°C Bed

45-55mm/s

Printing Considerations

- Temperature variations: Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- ABS likes to shrink as it cools which causes warping from your print bed; higher bed temperatures, enclosed printers, and brims or rafts help greatly.