



PRINT SETTINGS CF ABS

Nozzle Temp	230°C-250°C
Bed Temp	100-120°C
Heated Enclosure	Not Required
Bed Adhesion	Hairspray, glue stick, or increase bed temperature
Drying Settings	60°C for 4 hours

Preferred Print Parameters

0.6mm Nozzle – 0.4mm Layer Height

235°C Extruder 110°C Bed

40mm/s

Printing Considerations

- Carbon fiber filament is abrasive! Use a hardened steel nozzle.
- 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.