



PRINT SETTINGS CF PC+PBT

Nozzle Temp	250°C-260°C
Bed Temp	100-120°C
Heated Enclosure	Recommended
Bed Adhesion	Hairspray, glue stick, or increase bed temperature
Drying Settings	60°C for 4 hours

Preferred Print Parameters

0.6mm Nozzle – 0.4mm Layer Height

255°C Extruder 90°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.
- PC+PBT is a higher temp engineering material. It likes to shrink when it cools which can cause parts to warp up off of the print bed. Use build plate adhesive, higher temperatures, or a brim/raft to alleviate.