



## PRINT SETTINGS

### Nylon (PA)

<b>Nozzle Temp</b>	250°C-270°C
<b>Bed Temp</b>	90-120°C
<b>Heated Enclosure</b>	Recommended
<b>Bed Adhesion</b>	Hairspray, glue stick, or increase bed temperature
<b>Drying Settings</b>	60°C for 6 hours

#### Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height

255°C Extruder 90°C Bed

40mm/s

#### Printing Considerations

- Temperature variations: Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- Nylon 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.
- Slower speeds and extra build plate adhesive may be needed for larger parts printed with Nylon.
- **Nylon is prone to rapid moisture absorption. Drying is recommended before printing!**