



## PRINT SETTINGS PC+ABS

<b>Nozzle Temp</b>	245°C-260°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 4 hours

### Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height

255°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.
- PC/ABS 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 warping.