



## PRINT SETTINGS PCTG

<b>Nozzle Temp</b>	235°C-250°C
<b>Bed Temp</b>	80-100°C
<b>Heated Enclosure</b>	Not required
<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 – 0.2-0.3mm Layer Height

240°C Extruder 90°C Bed

45-55mm/s

### Printing Considerations

- Temperature variations: Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- PCTG can be stringy with incorrect settings – bring temperature down or increase retraction to alleviate this