



## PRINT SETTINGS PC

<b>Nozzle Temp</b>	260°C-280°C
<b>Bed Temp</b>	110-130°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  
260°C Extruder 120°C Bed  
40mm/s

### Printing Considerations

- Temperature variations: Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- PC 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 PC.