



PRINT SETTINGS PEI 1010

Nozzle Temp	370°C-395°C
Bed Temp	130-160°C
Heated Enclosure	Required
Bed Adhesion	Hairspray, glue stick, or increase bed temperature
Drying Settings	70°C for 8 hours

Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height
375°C Extruder 150°C Bed
40mm/s

Printing Considerations

- Temperature variations: Larger nozzle diameters, higher volumetric flow, and faster print speeds will require higher nozzle temperatures.
- PEI 1010 is a high 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 PEI 1010.
- PEI is extremely vulnerable to moisture absorption, filament must be dried before printing.