



## PRINT SETTINGS PEI 9085

<b>Nozzle Temp</b>	350°C-380°C
<b>Bed Temp</b>	130-160°C
<b>Heated Enclosure</b>	Required
<b>Bed Adhesion</b>	Hairspray, glue stick, or increase bed temperature
<b>Drying Settings</b>	70°C for 8 hours

### Preferred Print Parameters

0.4mm Nozzle – 0.2mm Layer Height  
365°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 9085 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 9085.
- PEI is extremely vulnerable to moisture absorption; filament must be dried before printing.