



PRINT SETTINGS PC+Siloxane

Nozzle Temp	245°C-260°C
Bed Temp	90-120°C
Heated Enclosure	Recommended
Bed Adhesion	Hairspray, glue stick, or increase bed temperature
Drying Settings	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.
- SiPC 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.