



3D Printing Guide

Parameter	Value
Pre - Print Drying	65-75 °C, 8-12 h (Convection Oven)
Recommended Nozzle Temp	240-270 °C
Recommended Bed Temp	85-100 °C
Cooling Fan	0 %-60 %
Print Environment	≤ 60 °C, ≤ 20 % RH (Sealed with Desiccant)
Storage Environment	≤ 35 °C, ≤ 20 % RH (Sealed with Desiccant)
Print Speed	Up to 350 mm/s