



Parts in the image are printed with PA12-CF15,
But you could print it with ABS or ASA. **PLA and PETG not supported or tested.**

PA12-CF15

Layer height: 0.2mm
Perimeters: 4
Solid layers Top: 5
Solid layers Bottom: 5
Infill: 40%
Infill pattern: Grid
Nozzle Temp.: 280C
Bed Temp.: 100C
Chamber Temp.: 48-50C
Outer wall: 40 mm/s
Inner wall 60 mm/s
Infill 80 mm/s

No support needed!!!

ABS or ASA

Layer height: 0.2mm
Perimeters: 4
Solid layers Top: 5
Solid layers Bottom: 5
Infill: 40%
Infill pattern: Grid
Nozzle Temp.: 255C
Bed Temp.: 90C
Chamber Temp.: 40-45C
Outer wall: 45 mm/s
Inner wall 120 mm/s
Infill 140 mm/s

No support needed!!!