



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!!!**