

ABS

Acrylonitrile Butadiene Styrene

Recommended Print Settings	
Extruder Temperature	242°C
Bed Temperature	125°C
Bed Preparation	Clean with isopropyl alcohol before and after printing.
Cooling Fan	Yes
Closed Chamber	Yes
Heated Chamber	Yes
Chamber Temperature	70°C
Notes	<ul style="list-style-type: none"> • Always print with HEPA Filter ON. • Always make sure the chamber door is closed.

Recommended Material Management	
Drying	<p>Temperature</p> <ul style="list-style-type: none"> • 60°C - 70°C <p>Dry Time</p> <ul style="list-style-type: none"> • Heat Only → 4 hours • Heat + Vacuum → 2 hours
Recommended Support Material	<ul style="list-style-type: none"> • SSU00 • SSU09
Storage	<ul style="list-style-type: none"> • Keep safe from moisture and sunlight.
Compatible Materials	<ul style="list-style-type: none"> • ABS • TPU 75D • TPU 85A • TPU 95A

Slicer Settings	KISSlicer (0.4mm)	KISSlicer (0.6mm)	SSI (0.4mm)	SSI (0.6mm)
Material Profile Name	ABS Black 0.4	ABS Black 0.6	ABS	ABS
Layer Height	0.2 mm	0.24 – 0.36 mm	0.16 – 0.2 mm	0.2 – 0.28 mm
Loops	3.5		3.5	
Skin	1		1	
Infill	16.7% – 20%		16.7% – 20%	