

# MG94 ABS

*Acrylonitrile Butadiene Styrene*

Print Settings	
<b>Extruder Temperature</b>	235°C - 260°C
<b>Bed Temperature</b>	110°C - 130°C
<b>Bed Preparation</b>	Wolfbite for ABS, PETG, TPU, and TPE
<b>Cooling Fan</b>	
<b>Closed Chamber</b>	Yes
<b>Heated Chamber</b>	No
<b>Chamber Temperature</b>	N/A
<b>Notes</b>	<ul style="list-style-type: none"> <li>• Make sure the HEPA filter is powered, and the chamber door is closed during a print job.</li> <li>• Acetone vapor treatment can minimize layer lines.</li> <li>• <a href="#">Tips for printing large parts in ABS</a></li> </ul>

Material Management	
<b>Drying</b>	
<b>Recommended Support Material</b>	<ul style="list-style-type: none"> <li>• For challenging prints with complex internal geometry, MG94 ABS is compatible with HydroFill Water-Soluble Support.</li> </ul>
<b>Storage</b>	<ul style="list-style-type: none"> <li>• Store away from humidity and sunlight.</li> </ul>
<b>Compatible Materials</b>	<ul style="list-style-type: none"> <li>• PLA</li> </ul>

Slicer Settings	APEX
<b>Material Profile Name</b>	ABS ABS Dual Color ABS Hydrofill ABS with PLA
<b>Layer Height</b>	0.2 mm
<b>Loops</b>	0.6
<b>Skin</b>	1
<b>Infill</b>	33 %