

# ASA

*Acrylonitrile Styrene Acrylate*

Print Settings	
<b>Extruder Temperature</b>	245°C
<b>Bed Temperature</b>	105°C
<b>Bed Preparation</b>	Clean with isopropyl alcohol before and after printing.
<b>Cooling Fan</b>	Yes
<b>Closed Chamber</b>	Yes
<b>Heated Chamber</b>	Yes
<b>Chamber Temperature</b>	70°C
<b>Notes</b>	

Material Management	
<b>Drying</b>	<b>Temperature:</b> <ul style="list-style-type: none"> <li>• 60°C – 70°C</li> </ul> <b>Length:</b> <ul style="list-style-type: none"> <li>• Heat only → 4 hours</li> <li>• Heat + Vacuum → 2 hours</li> </ul>
<b>Recommended Support Material</b>	<ul style="list-style-type: none"> <li>• SSU00</li> <li>• SSU09</li> </ul>
<b>Storage</b>	Keep safe from moisture and sunlight by using desiccant and dark air tight containers, or a Material Management System.
<b>Compatible Materials</b>	<ul style="list-style-type: none"> <li>• ABS</li> <li>• TPU 75D</li> <li>• TPU 85A</li> <li>• TPU 95A</li> <li>• iGlide 180-PF</li> </ul>

Slicer Settings	KISSlicer (0.4mm)	KISSlicer (0.6mm)	SSI (0.4mm)	SSI (0.6mm)
<b>Material Profile Name</b>	ASA Natural v4 ASA Black v4		ASA	
<b>Layer Height</b>	0.16 – 0.2 mm	0.2 – 0.28 mm	0.16 – 0.2 mm	0.2 – 0.28 mm
<b>Loops</b>	3.5		3.5	
<b>Skin</b>	1		1	
<b>Infill</b>	20 %		20 %	