

# PC-ABS

*Polycarbonate Acrylonitrile Butadiene Styrene*

Print Settings	
<b>Extruder Temperature</b>	260°C
<b>Bed Temperature</b>	N/A – Slicer automatically sets temperature based on support material.
<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>	74°C
<b>Notes</b>	

Material Management	
<b>Drying</b>	<b>Temperature</b> <ul style="list-style-type: none"> <li>• 65°C - 70°C</li> </ul> <b>Dry Time</b> <ul style="list-style-type: none"> <li>• Heat Only → 12 hours</li> <li>• Heat + Vacuum → 2 hours</li> </ul>
<b>Recommended Support Material</b>	<ul style="list-style-type: none"> <li>• SSU00</li> <li>• SSU01</li> </ul>
<b>Storage</b>	Store in moisture-free environment.
<b>Compatible Materials</b>	

Slicer Settings	KISSlicer (0.4mm)	KISSlicer (0.6mm)	SSI (0.4mm)	SSI (0.6mm)
<b>Material Profile Name</b>	PC-ABS 3ntr v4 0.4	N/A	PCABS 3ntr	PCABS 3ntr
<b>Layer Height</b>	0.2 – 0.24 mm	0.24 – 0.32 mm	0.2 – 0.24 mm	0.24 – 0.32 mm
<b>Loops</b>	3.5		3.5	
<b>Skin</b>	1		1	
<b>Infill</b>	20 %		20 %	