

PC-ABS

Polycarbonate Acrylonitrile Butadiene Styrene

Print Settings	
Extruder Temperature	260°C
Bed Temperature	N/A – Slicer automatically sets temperature based on support material.
Bed Preparation	Clean with isopropyl alcohol before and after printing.
Cooling Fan	Yes
Closed Chamber	Yes
Heated Chamber	Yes
Chamber Temperature	80°C
Notes	<ul style="list-style-type: none"> It is recommended to anneal the printed part right after the printing process to release the residual internal stress when not using a heated chamber. Annealing settings: 90°C for 2 hours.

Material Management	
Drying	<p>Temperature</p> <ul style="list-style-type: none"> 65°C - 70°C <p>Dry Time</p> <ul style="list-style-type: none"> Heat Only → 12 hours Heat + Vacuum → 2 hours
Recommended Support Material	<ul style="list-style-type: none"> SSU00 SSU09
Storage	Store in moisture-free environment.
Compatible Materials	

Slicer Settings	KISSlicer (0.4mm)	KISSlicer (0.6mm)	SSI (0.4mm)	SSI (0.6mm)
Material Profile Name	PCABS White (PM) 0.4 PCABS Black (PM) 0.4	PCABS White (PM) 0.6 PCABS Black (PM) 0.6	None	None
Layer Height	0.2 – 0.24 mm	0.24 – 0.28 mm	0.2 – 0.24 mm	0.24 – 0.28 mm
Loops	-	-	-	-
Skin	-	-	-	-
Infill	-	-	-	-