

# PrintaMent

## cheat sheets



APRINTA**PRO**

	Printing temperature	Heated bed setting	Adhesion Agent	Part cooling fan 2nd layer	nozzle	Printingspeed	Layer height	Flowrate
<b>PLA</b>	180-220°C	0°C*   >65°C	PrintaFix	100%	standard**	up to 70mm/s	≥0.1mm	100%
<b>PET-G</b>	210-255°C	65-70°C	PrintaFix	50%	standard	up to 60mm/s	≥0.1mm	104%
<b>M-ABS</b>	220-255°C	65°C***	PrintaFix	20%	standard**	up to 50mm/s	≥0.1mm	100%
<b>PURE</b>	200-220°C	0°C*   >65°C	PrintaFix	35%	hardened ≥0.5mm	up to 35mm/s	≥0.15mm	103%
<b>FLEX HARD</b>	220-240°C	0°C	PrintaFix	100%	standard	up to 45mm/s	≥0.1mm	100%
<b>WOOD</b>	200-220°C	0°C*   >65°C	PrintaFix	35%	hardened ≥0.5mm	up to 35mm/s	≥0.15mm	103%
<b>PVA-HT</b>	230-250°C	>55°C	PrintaFix	50%	standard	up to 30mm/s	≥0.1mm	100%
<b>PVA-M</b>	190-210°C	>35°C	PrintaFix	50%	standard	up to 30mm/s	≥0.1mm	100%
<b>METAL</b>	190-220°C	0°C*   >65°C	PrintaFix	100%	hardened ≥0.5mm	up to 45mm/s	≥0.1mm	102%
<b>PET-G CF20</b>	210-255°C	65-70°C	PrintaFix	50%	hardened ≥0.5mm	up to 45mm/s	≥0.15mm	100%
<b>PA12</b>	255-275°C	90-100°C***	UHU Stick   PEI	30%	standard	up to 75mm/s	≥0.1mm	100%
<b>PC</b>	280-290°C	100-105°C***	UHU Stick   PEI	0-10%	standard	up to 50mm/s	≥0.1mm	100%
<b>PC-ABS</b>	245-275°C	85-95°C***	UHU Stick   PEI	5%	standard	up to 50mm/s	≥0.1mm	103%

\* = Not required with PrintaFix | \*\* = hardened nozzle ≥0.5mm for color "glow in the dark" | \*\*\* = use enclosure for temperature control