

Fillamentum PC/ABS

(Polycarbonate and Acrylonitrile butadiene styrene compound)

Printing temperature: 260 – 280 °C

Heated bed temperature: 90 – 105 °C

Speed: 30 – 55 mm/s

Part cooling fan: 0 – 15 %

Heated bed surface: PEI, mirror / glass

Adhesive: Magigoo PC, 3DLac

Raft / skirt / brim: Brim 10 mm / raft

Heated chamber / enclosure: recommended

Adhesion - For printing PC/ABS, it is recommended to use brim around the object. The ideal width is 5–10 mm. The best results were achieved while using Magigoo PC and also 3DLac.

Bridges and overhangs - Standard overhangs can be printed without problem. Big overhangs and bridges are almost impossible to print without supports. For the supports, it's crucial to find out the best support z distance.

Cooling - It is not recommended to use more than 15 % of fan speed, as fast cooling could lead into warping and shrinking. Also, less cooling helps to produce stronger parts because layers have enough time to bond well.

Storing - Airtight bag with desiccant.
In case of moist material, re-dry it in appropriate device. The conditions to achieve optimal level of moisture are 80 °C for 3 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing etc.
