



Phoenix™

Recommended Printer Conditions

Nozzle temperature*	240-260°C
Heated bed temperature**	70°C
Speed***	30-150 mm/s
Infill	As needed, up to 100 %
Layer height	0.2 mm
Cooling fan	On

*Nozzle temperature recommendations based on achieving better print definition. The recommendations given above leave about $\pm 5^{\circ}\text{C}$ to account for any fluctuations in temperature by the printer.

**Nylon chemistries stick best to glass, garolite and PEI build plates. Buildtak is not recommended. Glue is also recommended.

***Higher print speeds might require higher nozzle temperatures

These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters.