

NO.	PARAMETERS	PLA+	ABS+
1	NOZZLE TEMPERATURE	190-220°C (Recomanded) -It depends on Printer model, Print speed and Nozzle size	225-250°C (Recomanded) -It depends on Printer model, Print speed and Nozzle size
2	BED TEMPERATURE	50-60°C (Recommended) , Print can be done without heating bed.	100-120°C (Recomanded)
3	SPEED	50-70 mm/sec	50-70mm/sec
4	PART COOLING FAN	100% from second layer (Recomanded)	Not recommended , Only use for small models if required
5	HOTEND TYPE	PETF lined hotend (Recomanded)	Any type
6	ENCLOSURE	Not required	Recomanded
7	RETRACTION	Required (Caliberation based on printer model)	Required (Caliberation based on printer model)