

Dry PA12 at 80°C for 8 hours and PA6-CF at 80°C for 12 hours before every print — including freshly opened factory-sealed spools.

Parameter	PA12	PA6-CF	Notes
PRINT SETTINGS 7 items			
Nozzle temperature	245–260°C	255–270°C	Start low, increase if under-extrusion occurs.
Bed temperature	80°C	85°C	PEI sheet + glue stick for adhesion and release.
Cooling fan	Off (10% max)	Off	Any cooling degrades interlayer bonding.
Print speed	45–55mm/s	40–50mm/s	Reduce 10mm/s if layer delamination occurs.
Layer height	0.2mm	0.2mm	0.15mm for improved surface quality.
Enclosure	Recommended	Recommended	Required for large or tall prints (>50mm).
Nozzle type	Brass OK	Hardened steel	CF is abrasive — hardened steel required.
TROUBLESHOOTING 5 items			
Popping or crackling sounds	Wet filament	Wet filament	Dry the spool completely before resuming.
Layer delamination	Cooling fan too high	Cooling fan too high	Set fan to 0%. Enclose the printer.
Corner warping	Bed temp too low	Bed temp too low	Raise bed temp. Add brim. Close enclosure.
Rough or bubbly surface	Wet filament	Wet filament	Dry completely. Do not print wet Nylon.
Excessive stringing	Temp too high or wet	Temp too high or wet	Reduce nozzle temp 5°C increments. Check dryness.