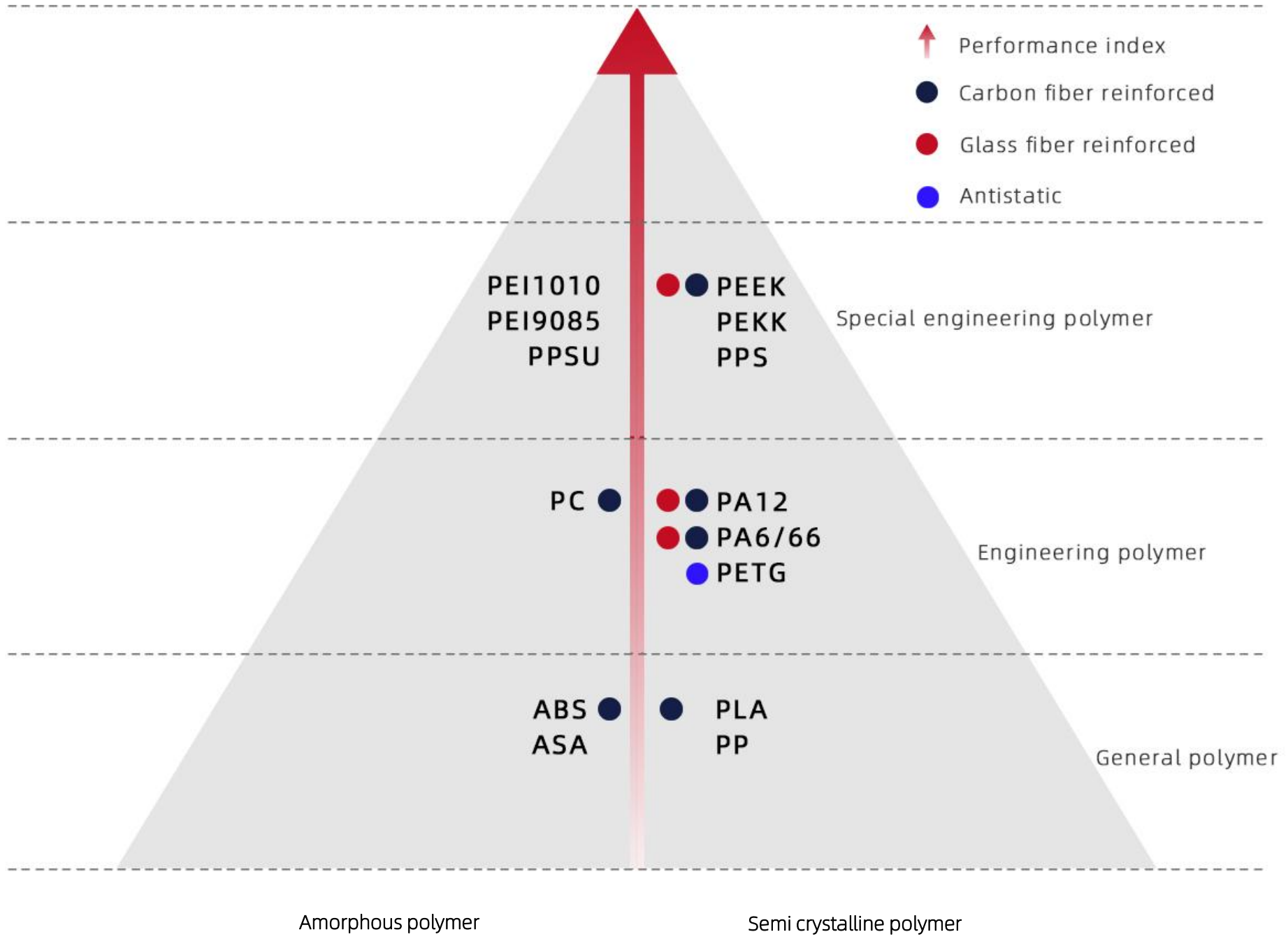


# IEMAI 3D Printing Materials Pyramid



# IEMAI 3D Polymer Printing Guide

Materials	Drying Temp C°	Drying Time H	Extruder Temp C°	Bed Temp C°	Chamber Temp C°	Bed Glue	Print Speed mm/s	Annealing condition
PEEK	150 Metal Reel	3	390-430	100-140	80-120	Special	15-50	150C° For 1H, 200C° For 2H, 150C° For 30Min, Take it out after natural cooling
PEKK	150 Metal Reel	3	370-410	90-130	70-100	Special	15-50	150C° For 1H, 200C° For 2H, 150C° For 30Min, Take it out after natural cooling
PEI 9085	170 Metal Reel	3	350-390	140-200	90-150	Special	15-50	-
PEI 1010	170 Metal Reel	3	350-390	140-200	90-150	Special	15-40	-
PPSU	170 Metal Reel	3	350-390	140-200	90-150	Special	15-40	-
PPS	150 Metal Reel	3	300-340	90-130	70-100	Special	15-50	-
CF-PEEK	150 Metal Reel	3	410-450	100-140	80-120	Special	15-50	150C° For 1H, 220C° For 2H, 150C° For 30Min, Take it out after natural cooling
GF-PEEK	150 Metal Reel	3	410-450	100-140	80-120	Special	15-50	150C° For 1H, 220C° For 2H, 150C° For 30Min, Take it out after natural cooling
GF-PA	80	3	250-280	80-110	60-80	Special	15-50	70C° For 2H, Take it out after natural cooling
CF-PA	80	3	250-280	80-110	60-80	Special	15-50	70C° For 2H, Take it out after natural cooling
CF-ABS	60	3	230-260	70-100	60-70	Special	15-50	-
CF-PC	80	3	250-280	80-110	60-80	Special	15-50	90C° For 2H, Take it out after natural cooling
ESD-PETG	60	3	220-260	70-90	50-70	Special	15-50	-
PA	80	3	230-260	80-110	60-80	Special	15-60	70C° For 2H, Take it out after natural cooling
PC	80	3	230-260	80-110	60-80	Special	15-60	90C° For 2H, Take it out after natural cooling
ABS	60	3	210-250	70-90	60-70	Special	15-60	-
ASA	60	3	210-250	80-110	60-70	Special	15-60	-
PETG	60	3	210-250	60-80	50-60	Special	15-60	-
PP	70	3	230-260	100-140	60-70	Special	15-40	-
TPU	60	3	210-250	60-80	0-70	Special	15-40	-
PLA	/	/	190-230	40-60	0-50	Special	15-60	-