

# PRINTING TAULMAN3D MATERIALS: BEST PRINTER SETTINGS

## Temperature NOTE for Nylons:

The number one issue we see from printer to printer is the "Actual" nozzle temperature versus the "Real" temperature with a bias toward most units printing too cold.

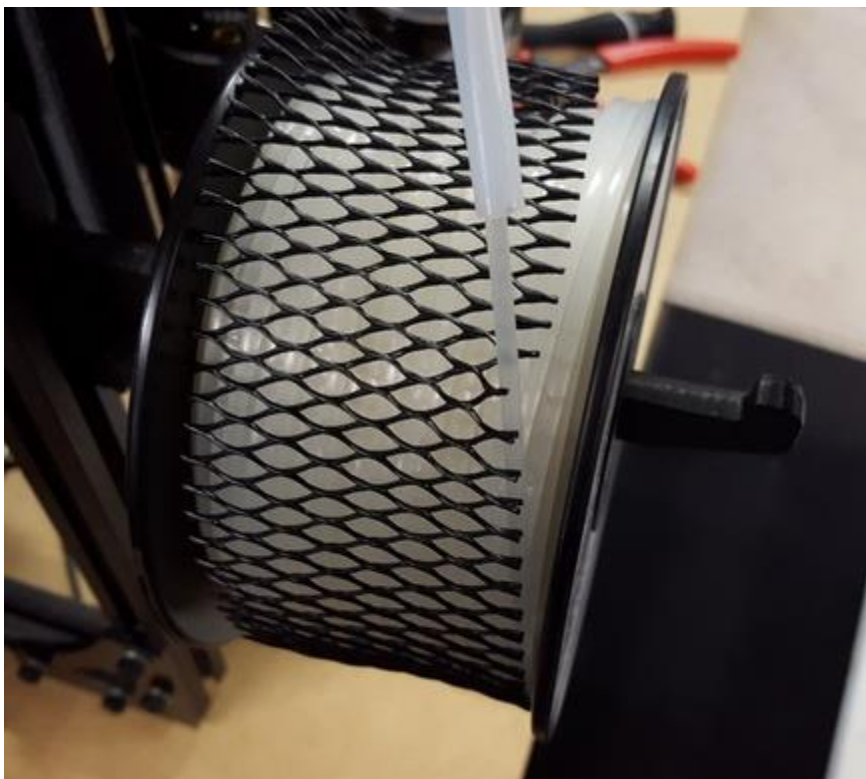
Nylons can print at 275C, If there is any layer bonding issue with your print, please do not hesitate to increase print temp.

---

## Webbing on some spools of materials:

For spools that come with a webbing over the material, the web is maintained "ON" during printing as noted below. This keeps the material from un-winding about the spool.

---



## Printing taulman3D Materials:

NOTE: *For ALL Nylon based materials, users should turn "OFF" any fans that blow on the printed part unless it's a very small part of less than 10mm sq. = Alloy 910, 618, 645, Bridge, PCTPE, 680 and 230*

### **Alloy 910**

Print temp = 250C - 260C

Nozzle = any size

Print speed = equivalent to ABS

Retraction = 3-4mm

Print bed =            Hot = Glass heated to 45C with coat of PVA  
                              Cold = BuildTak with coat of PVA

NOTE: Black Alloy 910 may appear to be Gray on the spool, however prints black.

### **Nylon 680**

Print temp = 250C - 255C

Nozzle = any size

Print speed = equivalent to ABS

Retraction = 3-4mm

Print bed =            Hot = Glass heated to 45C with coat of PVA  
                              Cold = BuildTak with coat of PVA

### **T-Lyne**

Print temp - 185C to 220C - Smaller nozzles than .5mm can use a higher temp up to 235C

Nozzle - Larger = Better or easier to print.

Print Speed = 25mm/s Direct Drive and 18mm/s Bowden - varies from unit to unit.

NOTE: When T-Lyne is too hot, it will have lots of fine bubbles and a rough texture.

Print Bed - T-Lyne prints on most beds cold and heated beds to 40C

### **guidel!ne**

Print temp = 245C - 252C

Nozzle = any size

Print speed = ABS speeds

Retraction = 3-4mm

Print bed =            Hot = Glass heated to 45C with coat of PVA\*

\*Elmers Glue All is suggested as it's considered food safe.

For Medical use, PEI sheet heated to 70C

NOTE: It is best "NOT" to let the bed cool to ambient, but only down to 35C in end of g-code.

This will reduce glass breakage

### **t-glass - all colors**

Print temp = 238C - 245C

Nozzle = any size

Print speed = ABS speeds - slower for high detailed prints

Retraction = 3-4mm

Print bed = Hot = Glass heated to 45C with coat of PVA

NOTE: It is best "NOT" to let the bed cool to ambient, but only down to 35C in end of g-code.

This will reduce glass breakage.

### **TECH-G**

Print temp = 238C - 245C

Nozzle = any size

Print speed = ABS speeds - slower for high detailed prints

Retraction = 3-4mm

Print bed = Hot = Glass heated to 45C with coat of PVA

NOTE: It is best "NOT" to let the bed cool to ambient, but only down to 35C in end of g-code.

This will reduce glass breakage.

### **Nylon 645**

Print temp = 250C - 255C

Nozzle = any size

Print speed = 80% of ABS speeds

Retraction = 3-4mm

Print bed = Hot = Glass heated to 45C with coat of PVA

### **BluPrint**

Print temp = 285C - 290C

Nozzle = any size

Print speed = ABS speeds

Retraction = 3-4mm

Print bed = Glass heated to 110C or PEI heated to 110C

### **Nylon 618**

Print temp = 250C - 260C

Nozzle = any size

Print speed = 80% of ABS speeds

Retraction = 3-4mm

Print bed = Hot = Glass heated to 55C with coat of 100% PVA

Cold = Garolite Board

