



PEEK is a very difficult material to 3D print. Your 3D printer should have the capability to extrude at 420 C, with a bed temperature of around 120 C. Print temperatures and optimal chamber temperatures differ depending on the printer but can be found around 360 to 420 for the nozzle temperature and around 100C for the chamber temperature. Your printer should have adequate thermal control in the build chamber throughout the printing process. Lack of thermal control and incorrect settings could lead to inadequate crystallization of the polymer in your printer. Lack of process control can also lead to specking on the part with black specs forming during printing on your part. Lack of process control and inadequate temperatures can also lead to brown discoloration in the part, which is an indication that the parts has not been properly crystalized. Do not let the PEEK material remain in your printer's nozzle for extended periods of time when not extruding. This will lead to specking and nozzle blockages. You could post 3D printing anneal your PEEK part in an oven. You should pre-dry your PEEK filament in an oven as well. The best build surface for PEEK is PEI sheets.

Disclaimer: 3D4Makers makes no warranties what so ever, expressed or implied, including but not limited to, any implied fitness for any particular purpose. From the moment the product is shipped it is beyond our control. The information in this document is believed to be correct at the time of writing. However, handling, processing, settings, the type of 3D printer, slicing and other variables are completely up to the user. The method through which the product is used can be varied. It is up for the customer to determine how it is 3D printed and whether it is fit for purpose or suited to a particular application.

