

Material	Suggested Printing Temp.	Suggested Heated Bed Temp.	Suggested Printing Speed	Biodegradable	Flexible	Strength Rating
PLA	180-210 C	20-45 C	30-40 mm/s	✓		Medium
PLA Plus	220-240 C	50-60 C	30-40 mm/s	✓		High
Bioflex	240-250 C	30-60 C	15 mm/s	✓	✓	Medium
ABS	230-250 C	90-95 C	30-40 mm/s			High
ABS/PA	255-265 C	100-110 C	30-40 mm/s			High
ASA	230-250 C	90-100 C	30-40 mm/s			High
PET-G	220-245 C	70-80 C	30-40 mm/s			High
TPU	210-240 C	20-70 C	15 mm/s		✓	Low
PMMA	245-255 C	90-100 C	30-40 mm/s			High
PC	280-300 C	100-110 C	30-40 mm/s			Very High
PC/ABS B	270-290 C	90-100 C	30-40 mm/s			Very High
PC/ABS I	270-290 C	90-100 C	30-40 mm/s			Very High
Nylon 6/66	255-275C	100-110 C	30-40 mm/s			High
Nylon 12	255-275C	100-110 C	30-40 mm/s			High
Nylon 12 with Glass reinforcement	255-275 C	100-110 C	30-40 mm/s			Very High
Nylon 12 with Carbon reinforcement	260-275C	100-115 C	30-40 mm/s			Very High
<b>Support</b>						
HIPS	230-240 C	90-100 C	30-40 mm/s			Medium
PVA	190-240 C	20-45 C	25-30 mm/s			Low
Scaffolding	225-250 C	95-105 C	30-40 mm/s			Medium
<b>Utility</b>						
Cleaning	200-280 C	N/A	N/A			N/A