Filament

[Filamentguide online]

Enthält nützliche und wichtige Hinweise zu Druckbettvorbereitung, Bettblech und Materialeigenschaften !

Material	Printing with enclosure	Dry box recommended	Hardened nozzle required	Nozzle temperature (+-10 °C)	Bed temperature (+-10 °C)	Printable on powder coated sheet	Printable on smooth PEI sheet	Printable on satin sheet	Soluble with common solvents	Heat deflection temperature (avg. °C)	Impact resistance Charpy (kJ/m²)	Tensile strength (Mpa)	Price
› PLA (15)	No	No	No	210 - 215 °C	60 °C	✓	✓	✓	✗				
› PETG (8)	No	No	No	230 - 270 °C	90 °C	✓	! with glue stick	✓	✗				
› PETG HT (1)	No	No	No	270 °C	110 °C	✓	! with glue stick	✓	✗				
› ASA (2)	Yes recommended	No	No	260 - 265 °C	95 - 110 °C	! with glue stick	! with glue stick	✓	✓				
› ABS (5)	Yes recommended	No	No	240 - 255 °C	110 °C	! with glue stick	! with glue stick	✓	✓				
› PC (Polycarbonate) (2)	Yes recommended	No	No	270 - 275 °C	115 °C	! with glue stick	! with glue stick	✓	✗				
› CPE (1)	No	Yes	No	275 °C	90 °C	✓	! with glue stick	✓	✗				
› PVA / BVOH (2)	No	Yes	No	195 - 215 °C	60 °C	✓	✓	✓	✓				
› HIPS (1)	No	No	No	220 °C	110 °C	✓	✓	✓	✓				
› PP (Polypropylene) (1)	Yes	No	No	220 °C	100 °C	✗ not recommended	! with PP tape	✓	✗				
› Flex (5)	No	Yes	No	230 - 260 °C	50 - 85 °C	✓	! with glue stick	! with glue stick	✗				
› nGen (1)	No	No	No	240 °C	90 °C	✓	! with glue stick	✓	✗				
› Nylon (3)	Yes recommended	Yes	No	250 - 270 °C	75 - 90 °C	! with glue stick	✗ not recommended	! with glue stick	✗				
› Composite materials (7)	-	-	Yes	240 - 285 °C	75 - 110 °C	-	-	-	✗				
› Wood / metal filled (7)	No	No	-	190 - 220 °C	60 °C	✓	✓	✓	✗				
› PVB (1)	No	No	No	215 °C	75 °C	✗	✓	✓	✓				

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