

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 ⁽¹⁾	(15) No	No	No	210 - 215 °C	60 °C	✓	✓	✓	✗				
PETG ⁽¹⁾	(8) No	No	No	230 - 270 °C	90 °C	✓	with glue stick	✓	✗				
PETG HT ⁽¹⁾	(1) No	No	No	270 °C	110 °C	✓	with glue stick	✓	✗				
ASA ⁽¹⁾	(2) Yes recommended	No	No	260 - 265 °C	95 - 110 °C	with glue stick	with glue stick	✓	✓				
ABS ⁽¹⁾	(5) Yes recommended	No	No	240 - 255 °C	110 °C	with glue stick	with glue stick	✓	✓				
PC (Polycarbonate) ⁽¹⁾	(2) Yes recommended	No	No	270 - 275 °C	115 °C	with glue stick	with glue stick	✓	✗				
CPE ⁽¹⁾	(1) No	Yes	No	275 °C	90 °C	✓	with glue stick	✓	✗				
PVA / BVOH ⁽¹⁾	(2) No	Yes	No	195 - 215 °C	60 °C	✓	✓	✓	✓				
HIPS ⁽¹⁾	(1) No	No	No	220 °C	110 °C	✓	✓	✓	✓				
PP (Polypropylene) ⁽¹⁾	(1) Yes	No	No	220 °C	100 °C	✗ not recommended	with PP tape	✓	✗				
Flex ⁽¹⁾	(5) No	Yes	No	230 - 260 °C	50 - 85 °C	✓	with glue stick	with glue stick	✗				
nGen ⁽¹⁾	(1) No	No	No	240 °C	90 °C	✓	with glue stick	✓	✗				
Nylon ⁽¹⁾	(3) Yes recommended	Yes	No	250 - 270 °C	75 - 90 °C	with glue stick	✗ not recommended	with glue stick	✗				
Composite materials ⁽¹⁾	(7) -	-	Yes	240 - 285 °C	75 - 110 °C	-	-	-	✗				
Wood / metal filled ⁽¹⁾	(7) No	No	-	190 - 220 °C	60 °C	✓	✓	✓	✗				
PVB ⁽¹⁾	(1) No	No	No	215 °C	75 °C	✗ not recommended	✓	✓	✓				

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