

	Nozzle size	Bed adhesion	Print temp.	Bed temp.	Layer height	Print speed	Fan speed	Flowrate	Retraction	Difficulty	Drying	Special	Food Approval EU*	FDA**	
PLA	PLA	≥0.25mm	PEI, glass, hairspray or gluestick	205±10°C	≤60°C	≥0,1mm	Medium/high	Medium/high	100%	DD: ±2mm BT: ±5mm	Easy	Optional	-	Yes	Yes
	PLA MATT	≥0.25mm	PEI, glass, hairspray or gluestick	215±10°C	≤60°C	≥0,1mm	Medium/high	Medium/high	105%	DD: ±2mm BT: ±5mm	Easy	Optional	Hardened steel nozzle advised	No	No
	PLA GLITTER	≥0.4mm	PEI, glass, hairspray or gluestick	205±10°C	≤60°C	≥0,1mm	Medium/high	Medium/high	100%	DD: ±2mm BT: ±5mm	Easy	Optional	-	No	No
	PLA SATIN	≥0.25mm	PEI, glass, hairspray or gluestick	225±10°C	50-70°C	≥0,1mm	Medium	Medium/high	96%	DD: ±1,5mm BT: ±6mm	Easy	Optional	-	-	-
	PLA-X3	≥0.25mm	Hairspray, PEI or magigoo	230±10°C	50-60°C	≥0,1mm	Medium/high	Medium/high	103%	DD: ±2,5mm BT: ±6,5mm	Intermediate	Advised	-	No	No
	TPLA	≥0.25mm	Hairspray, PEI, glass or gluestick	205±10°C	≤60°C	≥0,1mm	Medium	Medium/high	100%	DD: ±2mm BT: ±5mm	Easy	Optional	-	No	No
	MT-BRONZE	≥0.4mm	Hairspray or buildtak	210±10°C	≤60°C	≥0,1mm	Medium	Medium/high	105%	DD: ±3mm BT: ±3mm	Easy	Optional	Hardened steel nozzle required	No	No
	MT-COPPER	≥0.4mm	Hairspray or buildtak	210±10°C	≤60°C	≥0,1mm	Medium	Medium/high	105%	DD: ±3mm BT: ±3mm	Easy	Optional	Hardened steel nozzle required	No	No
	WOOD	≥0.4mm	PEI or hairspray	200±10°C	≤60°C	≥0,1mm	Medium	Medium/high	104%	DD: ±3mm BT: ±3mm	Intermediate	Optional	Avoid long residence times in nozzle	No	No
TOUGH PLA	≥0.4mm	PEI, glass, hairspray or gluestick	210±10°C	≥60°C	≥0,1mm	Medium/high	Medium/high	100%	DD: ±2mm BT: ±5mm	Easy	Optional	-	No	No	
STYRENE	ABS	≥0.25mm	Dimafix	250±10°C	≥90°C	≥0,1mm	Medium	Low/no	105%	DD: ±3mm BT: ±6mm	Intermediate	Optional	Ventilated room, enclosure advised	No	No
	ABS-X	≥0.25mm	PEI or dimafix	245±10°C	≥100°C	≥0,1mm	Medium	Low/no	100%	DD: ±1,5mm BT: ±4mm	Intermediate	Optional	-	No	No
	ASA-X	≥0.25mm	Dimafix	240±10°C	80-90°C	≥0,1mm	Medium	Low/no	100%	DD: ±2mm BT: ±3mm	Intermediate	Optional	-	No	No
	HIPS	≥0.25mm	Buildtak + hairspray or kapton	245±10°C	≥85°C	≥0,1mm	Medium	Low/no	100%	DD: ±2mm BT: ±5mm	Intermediate	Optional	Ventilated room, dissolves in D'Limonene, enclosure advised	No	No
	M-ABS	≥0.25mm	Dimafix	250±10°C	≥90°C	≥0,1mm	Medium	Low	95%	DD: ±2mm BT: ±6mm	Easy	Optional	-	No	No
	PC-ABS	≥0.25mm	Dimafix	270±10°C	100-110°C	≥0,1mm	Medium	Low/no	106%	DD: ±2mm BT: ±4mm	Intermediate	Optional	Enclosure advised	No	No
	PCABS0	≥0.25mm	Dimafix	270±20°C	≥100°C	≥0,1mm	Medium	Low/no	105%	DD: ±4mm BT: ±7mm	Intermediate	Optional	Enclosure advised	No	No

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		Nozzle size	Bed adhesion	Print temp.	Bed temp.	Layer height	Print speed	Fan speed	Flowrate	Retraction	Difficulty	Drying	Special	Food Approval EU*	FDA**
(CO) POLYESTER	PET-G	≥0.25mm	PEI Magigoo or hairspray	240±10°C	≥70°C	≥0,1mm	Medium	Medium/low	95%	DD: ±3,5mm BT: ±5mm	Easy	Optional	-	Yes	Yes
	CARBON-P	≥0.5mm	Dimafix or hairspray	240±15°C	70-90°C	≥0,1mm	Medium	Low/no	105%	DD: ±1,5mm BT: ±4mm	Advanced	Optional	Hardened steel nozzle required	No	No
	PC	≥0.4mm	PC sheet + hairspray, PEI or gluestick	300±10°C	≥100°C	≥0,1mm	Medium	Low/no	100%	DD: ±2mm BT: ±5mm	Advanced	Optional	Enclosure advised	No	Yes
FLEXIBLE	GLASSBEND	≥0.25mm	PEI	290±20°C	≥100°C	≥0,1mm	Medium	Low/no	108%	DD: ±2,5mm BT: ±5mm	Intermediate	Drying improves clarity	Enclosure advised	Yes	Yes
	FLEX 45	≥0.25mm	PEI	250±10°C	≥100°C	≥0,1mm	Low	Low/medium	104%	DD: ±3mm BT: ±3mm	Advanced	Required	Avoid long residence time in nozzle	No	No
	TPU98A	≥0.25mm	Hairspray, glass or PEI	230±10°C	≤60°C	≥0,1mm	Low/medium	Medium/high	110%	DD: ±1,5mm BT: ±2,5mm	Advanced	Required	-	No	Yes
SUPPORT	PVA	≥0.25mm	Hairspray, PEI, glass or gluestick	210±10°C	≥60°C	≥0,1mm	Medium	Medium	105%	DD: ±2mm BT: ±3mm	Advanced	Required	Avoid nozzle temperatures >225°C	No	No
	PVA-M	≥0.25mm	Hairspray, PEI, glass or gluestick	220±10°C	≥60°C	≥0,1mm	Medium	Medium	105%	DD: ±2mm BT: ±3mm	Advanced	Required	Avoid nozzle temperatures >235°C	No	No
	PVA-S	≥0.25mm	Hairspray, PEI, glass or gluestick	240±10°C	≥60°C	≥0,1mm	Medium	Low/medium	105%	DD: ±2mm BT: ±3mm	Advanced	Required	Avoid nozzle temperatures >250°C	No	No
	BVOH	≥0.25mm	Hairspray, PEI, glass or gluestick	220±10°C	≥60°C	≥0,1mm	Medium	Medium	100%	DD: ±3mm BT: ±5mm	Advanced	Required	Avoid nozzle temperatures >240°C	No	No
POLYAMIDE	PA-CX12	≥0.25mm	PA glue or PA sheet	260±10°C	≥100°C	≥0,1mm	Medium	Low/no	100%	DD: ±3mm BT: ±5mm	Advanced	Required	Enclosure advised	-	Yes
POLYOLEFIN	PP	≥0.25mm	Packing tape, pp sheet or pp glue	240±10°C	≤100°C	≥0,1mm	Medium	Medium/high	100%	DD: ±1,5mm BT: ±7mm	Advanced	Optional	-	Yes	Yes
RECYCLED	PIPG	≥0.25mm	PEI Magigoo or hairspray	240±10°C	≥70°C	≥0,1mm	Medium	Medium/low	95%	DD: ±3,5mm BT: ±5mm	Easy	Optional	-	No	No
	RPLA	≥0.25mm	PEI, glass, hairspray or gluestick	210±10°C	≤60°C	≥0,1mm	Medium/high	Medium/high	100%	DD: ±2mm BT: ±5mm	Easy	Optional	-	No	No

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	Nozzle size	Bed adhesion	Print temp.	Bed temp.	Layer height	Print speed	Fan speed	Flowrate	Retraction	Difficulty	Drying	Special	Food Approval EU*	FDA**
DURABIO™	≥0.25mm	Dimafix	240±10°C	≥100°C	≥0,1mm	Medium	Medium/high	100%	DD: ±2mm BT: ±5,5mm	Intermediate	5 hours 80°C suggested	-	-	-
3DIAKON™	≥0.25mm	Dimafix	255±10°C	100°C	≥0,1mm	Medium	Low/no	95%	DD: ±2mm BT: ±4mm	Intermediate	4 hours 80°C suggested	Enclosure advised	-	-
BVOH	≥0.25mm	Hairspray, PEI, glass or gluestick	220±10°C	≥60°C	≥0,1mm	Medium	Medium	100%	DD: ±3mm BT: ±5mm	Advanced	Required	Avoid nozzle temperatures >240°C	No	No

ONEPET	≥0.25mm	PEI or hairspray	245±10°C	≥70°C	≥0,1mm	Medium	Medium	100%	DD: ±2mm BT: ±5mm	Intermediate	Strongly recommended	-	No	No
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ARNITEL ID2045	≥0.25mm	Glass or gluestick	230±10°C	35-60°C	≥0,1mm	Low/medium	Medium/high	106%	DD: ±2mm BT: ±7mm	Advanced	Optional	-	No	No
NOVAMID® ID1070	≥0.25mm	Dimafix or PEI	260±10°C	100-120°C	≥0,1mm	Medium/high	Low/no	100%	DD: ±2mm BT: ±7mm	Advanced	4 hours 80°C suggested	Enclosure advised	No	No
NOVAMID® ID1030	≥0.25mm	Dimafix or PEI	260±10°C	80-120°C	≥0,1mm	Medium/high	Low/no	100%	DD: ±2mm BT: ±7mm	Advanced	4 hours 80°C suggested	Enclosure advised	-	-
NOVAMID® ID1030 CF10	≥0.4mm	Dimafix, PEI or gluestick	270±10°C	80-120°C	≥0,1mm	Medium/high	Low/no	100%	DD: ±2mm BT: ±6mm	Advanced	Optional	Enclosure advised	-	-
NOVAMID® AM1030 FR(F)	≥0.25mm	PEI, Magigoo PA	270±5°C	110-115°C	≥0,1mm	Medium/high	Low/no	100%	DD: ±2mm BT: ±7mm	Advanced	4 hours 80°C suggested	Enclosure advised	No	No
ARNITEL® ID2060 HT	≥0.25mm	PEI, double sided tape	230±10°C	80-120°C	≥0,1mm	Low/medium	Low/medium	105%	DD: ±2mm BT: ±7mm	Advanced	Optional	-	-	-
ARNITE® ID3040	≥0.25mm	PEI or gluestick	290±10°C	60-120°C	≥0,1mm	Medium/high	Low/no	100%	DD: ±2mm BT: ±7mm	Advanced	4 hours 80°C suggested	-	-	-

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