

MATERIAL		HARDWARE			TEMPERATURES		SHEETS						PHYSICAL FEATURES				
		Enclosure	Drybox	Hardened nozzle	Nozzle	Bed	Textured	Smooth PEI	Satin	Special PA Nylon	PP	HT	Easily soluble	Heat deflection	Impact resistance	Tensile strength	Price
> PLA	ⓘ	No	-	No	185-235 °C	50-60 °C	✓	✓	✓	✗	⚠ First, print with PP	✗	✗				
> PETG	ⓘ	No	No	No	215-270 °C	70-90 °C	✓	⚠ with glue stick	✓	✓ Cleaned with water	✓	✗	✗				
> PETG HT	ⓘ	No	No	No	270 °C	110 °C	✓	⚠ with glue stick	✓	✓ Cleaned with water	✓	✗	✗				
> ASA	ⓘ	Recommended	No	No	220-275 °C	90-110 °C	⚠ with glue stick	⚠ with glue stick	✓	✗	✓	✗	✓				
> ABS	ⓘ	Recommended	No	No	230-255 °C	95-110 °C	⚠ with glue stick	⚠ with glue stick	✓	✗	✓	✗	✓				
> PC (Polycarbonate)	ⓘ	Recommended	No	No	270-275 °C	100-115 °C	⚠ with glue stick	⚠ with glue stick	✓	✗	✓	✗	✗				
> CPE	ⓘ	No	Yes	No	275 °C	90-110 °C	✓	⚠ with glue stick	✓	✗	✗	✗	✗				
> PVA / BV0H	ⓘ	No	Yes	No	195-215 °C	60 °C	✓	✓	✓	✗	✓	✗	✓				
> HIPS	ⓘ	No	No	No	225-255 °C	100-110 °C	✓	✓	✓	✗	✗	✗	✓				
> PP (Polypropylene)	ⓘ	-	No	No	220-245 °C	70-100 °C	✗	⚠ with PP tape	-	✗	✓	✗	✗				
> Flex	ⓘ	No	-	No	220-260 °C	40-85 °C	✓	⚠ with glue stick	-	-	✓	✗	✗				
> nGen	ⓘ	No	No	No	240 °C	90 °C	✓	⚠ with glue stick	✓	✗	✗	✗	✗				
> PA (Nylon)	ⓘ	Recommended	Yes	No	240-285 °C	70-115 °C	⚠ with glue stick	✗	⚠ with glue stick	-	✗	✗	✗				
> Composite materials	ⓘ	-	-	Yes	225-285 °C	40-115 °C	-	-	-	-	-	-	✗				
> Wood / metal filled	ⓘ	No	No	-	190-270 °C	60-100 °C	-	-	✓	-	-	✗	✗				
> PVB	ⓘ	No	No	No	215 °C	75 °C	✗	✓	✓	✗	✓	✗	✓				
> PEI	ⓘ	Yes Necessary 90-190 °C	Yes Necessary	No	430 °C	150 °C	✓ with MagiGoo HT	✗	✗	✗	✗	✓ with MagiGoo HT	✗				