

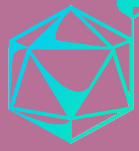
Dicey Tech

www.3dicey.com

Quick Reference Guide

 Type of Filament	 Primary Benefit	 Ideal for	 Durability	 Flexibility	 Printing Difficulty
PLA Polylactic Acid	Good Strength, User Friendly, Durability, Some Impact Resistance	Consumer Products, Small Toys, Higher Print Speeds, Smoother Layers	Fair to Good Durability	Slight Flexibility, More Brittle	Easy: Fairly Low Maintenance Once Temperature, Bed Height & Speed are Set
 Soluble?	 Food Safe	 General Print Temp Range	 Shrinkage	 Heated Bed	 Cooling
No	Refer to Specific Manufacturer Guidelines	180 C - 230 C	Some, Less Sensitive to Cooling as Compared to ABS	Recommended, but Not Required 50 C - 60 C	75%-100%

 Type of Filament	 Primary Benefit	 Ideal for	 Durability	 Flexibility	 Printing Difficulty
ABS Acrylonitrile Bu- tadiene Styrene	High Strength Durability Impact Resistance Toughness	Moving Parts, Automotive Parts, Electronic Houseing Toys	High Durability	Low Flexibility, Minor Bending before Snapping	Moderate: Requires Fine Tuning Bed & Nozzle Temperature
 Soluble?	 Food Safe	 General Print Temp Range	 Shrinkage	 Heated Bed	 Cooling
Yes, in Acetone	Not Considered Food Safe	210 C - 250 C	Yes, Enclosed Chanber Recommended to Control Cooling Speed	Yes, 80 C- 100 C	No



Dicey Tech

www.3dicey.com

Quick Reference Guide

 Type of Filament	 Primary Benefit	 Ideal for	 Durability	 Flexibility	 Printing Difficulty
PETG Polyethylene Terephthalate Glycol	Stiff, High Strength, Lightweight, Impact Resistant	Mechanical Parts, Impact Resistance, Flexibility, Durability	High Durability	Good Flexibility, More Flexible than PLA or ABS	Moderate: Requires Fine Tuning Bed & Nozzle Temperature
 Soluble?	 Food Safe	 General Print Temp Range	 Shrinkage	 Heated Bed	 Cooling
No, Non-Hydrophobic	Refer to Specific Manufacturer Guidelines	220 C - 250 C	Minimal Shrinkage	Yes 70 C - 80 C	20%-40%

 Type of Filament	 Primary Benefit	 Ideal for	 Durability	 Flexibility	 Printing Difficulty
PVA Polyvinyl Alcohol	Dual Extrusion Support Structure Paired with PLA	Easily Removable PLA Support Structure	Good Durability	Low Flexibility, Some Bending Before Snapping	Easy: Fairly Low Maintenance Once Temperature, Bed Height & Speed are Set
 Soluble?	 Food Safe	 General Print Temp Range	 Shrinkage	 Heated Bed	 Cooling
Yes, in warm Water	Refer to Specific Manufacturer Guidelines	180 C - 230 C	Some Shrinking Possible	Recommended, but Not Required 50 C - 60 C	Yes, 50-80%