

Material Property	Units	PLA Coloured	PLA Plus Coloured	Rapid PLA Plus Coloured	PLA PRO	PLA MATT	Rapid PETG	PETG PRO	PETG-CF	PETG-GF	TPU-95A	ASA	PAHT-CF
Print Settings													
Drying Temp	°C	55 ± 5	55 ± 5	55 ± 5	55 ± 5	55 ± 5	70 ± 5	70 ± 5	70 ± 5	70 ± 5	70 ± 5	80 ± 5	80 ± 5
Temp & Humidity	°C & %RH	<50 <20%	<50 <20%	<50 <20%	<50 <20%	<50 <20%	<70 <20%	<70 <20%	<70 <20%	<70 <20%	<70 <20%	<80 <20%	<70 <20%
Nozzle Temp	°C	190-230	200=230	200-230	180-210	190-230	240-270	230-260	240-270	240-270	220-240	240-270	260-290
Bed Temp	°C	35-65	35-65	35-65	35-65	35-65	65-70	65-70	90-110	65-75	30-45	90-100	100-120
Plate Type		Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other	Textured or Other
Print Speed	mm/s	<300	<280	<600	<300	<300	<600	<270	<220	<220	<60	<270	<100
Physical Properties													
Density	g/cm³	1.26	1.3	1.23	1.24	1.26	1.29	1.27	1.29	1.3	1.16	1.09	1.08
Melt Temp	°C	158	161	160	162	163	216	218	226	226	188	214	225
VICAT Soft Temp	°C	62	63	62	62	63	70	71	83	83	N/A	102	225
Heat Deflection Temp	°C	57	56	57	56	55	72	73	73.9	73.9	N/A	99	193
Mechanical Properties													
Tensile Strength	Mpa	38 ± 3	38 ± 2	39 ± 2	32 ± 2	30 ± 1	42 ± 2	40 ± 2	51 ± 8	50 ± 3	16 ± 2	35 ± 2	87 ± 3
Breaking Elongation XY	%	10.5% ± 2.1%	7.9% ± 1.6%	8.5% ± 1.2%	14.1% ± 2.1%	7.9% ± 1.1%	8.9% ± 1/5%	7.6% ± 1.1%	9.6% ± 1.0%	7.9% ± 1%	>500%	9.4% ± 2.3%	14.2% ± 1.1%
Bending Modulus XY	MPa	2993 ± 182	2979 ± 156	2846 ± 175	2964 ± 169	2996 ± 159	2097 ± 173	2111 ± 119	3340 ± 21	3345 ± 88	124.8 (no fracture)	1905 ± 131	5089 ± 54
Bending Strength	MPa	72 ± 5	74 ± 4	71 ± 6	66 ± 3	75 ± 3	68 ± 2	70 ± 2	85 ± 2	83 ± 3		65 ± 4	138 ± 3
Impact Strength	kJ/m²	66.2 ± 3.9	65.5 ± 3.6	50.4 ± 2.8	30.2 ± 2.3	29.3 ± 2.9	87.6 ± 4.2	68.5 ± 2.5	70.7 ± 6.2	51.9 ± 5.2		40.1 ± 3.7	86.4 ± 3.4