



	Print Temp	Bed Temp	Strength	Flexibility	Durability	Difficulty	Shrinkage	Soluble	Food Safe*	Blue Tape	Glue Stick	Typical Uses
<b>ABS</b> Acrylonitrile Butadiene Styrene	150-310 210-250 °C	50-150 50-100 °C	●●	●●	●●●	●●		Acetone	No			Functional Parts
<b>ASA</b> Acrylonitrile Styrene Acrylate	150-310 240-260 °C	50-150 100-120 °C	●●	●	●●●	●●		Acetone	No			Outdoor Use
<b>Carbon Fiber</b> Carbon Fiber and PLA blend	150-310 195-220 °C	50-150 N/A °C	●●	●	●●●	●●		No	No		-	Functional Parts
<b>Cleaning</b> Cleaning Filament	150-310 150-260 °C	50-150 N/A °C	-	-	-	●	-	-	-	-	-	Nozzle Cleaning / Unclogging
<b>Color Changing</b> PLA or ABS with color changing properties	150-310 210-220 °C	50-150 N/A °C	●●	●●	●●	●		No	No			Educational, Modelling
<b>Conductive</b> Conductive PLA or ABS	150-310 215-230 °C	50-150 N/A °C	●●	●●	●	●		No	No		-	Electronics
<b>Flexible, TPE, TPU</b> Thermoplastic Urethane / Polyurethane	150-310 225-235 °C	50-150 N/A °C	●	●●●	●●	●●●		No	No			Elastic Parts, Wearables
<b>FPE</b> Flexible Polyester	150-310 205-250 °C	50-150 75 °C	●	●●●	●●●	●●		No	Yes	-		Flexible Parts
<b>Glow-In-The-Dark</b> Glow in the dark PLA or ABS	150-310 210-220 °C	50-150 N/A °C	●●	●●	●●	●		No	No		-	Educational, Modelling
<b>HIPS</b> High Impact Polystyrene	150-310 210-250 °C	50-150 50-100 °C	●	●●	●●●	●●		Solvent	No			Support Structures
<b>Lignin (bioFila)</b> Lignin and PLA plus additives	150-310 190-225 °C	50-150 55 °C	●●	●	●●●	●●●		No	Yes			All Purpose
<b>Magnetic</b> PLA with powdered iron	150-310 195-220 °C	50-150 N/A °C	●●	●●	●●	●●●		No	No		-	Educational, Experimental
<b>Metal PLA / ABS</b> Metal Powder and PLA or ABS blend	150-310 195-220 °C	50-150 N/A °C	●●	●	●●●	●●●		No	No		-	Jewellery
<b>nGen</b> Similar to PETG	150-310 210-240 °C	50-150 60 °C	●●	●●●	●●●	●●		No	Yes		-	All Purpose
<b>Nylon</b> Polyamide	150-310 220-260 °C	50-150 50-100 °C	●●●	●●●	●●●	●●		No	Yes	-		All Purpose
<b>PC</b> Polycarbonate	150-310 270-310 °C	50-150 90-105 °C	●●●	●●●	●●●	●●		Acetone	No	-		Functional Parts
<b>PC/ABS</b> Polycarbonate ABS	150-310 260-280 °C	50-150 120 °C	●●	●	●●●	●●●		No	No	-		Functional Parts
<b>PET (CPE)</b> Polyethylene Terephthalate	150-310 220-250 °C	50-150 N/A °C	●●●	●●●	●●●	●●		No	Yes		-	All Purpose
<b>PETG (XT, N-Vent)</b> Poly-Ethylene Terephthalate Glycol	150-310 220-235 °C	50-150 N/A °C	●●	●●●	●●●	●●		No	Yes		-	All Purpose
<b>PETT (T-Glase)</b> PolyEthylene coTrimethylene Terephthalate	150-310 235-240 °C	50-150 N/A °C	●●●	●●●	●●●	●●		No	Yes		-	Functional Parts
<b>PLA</b> Polylactic Acid	150-310 180-230 °C	50-150 N/A °C	●●	●	●●	●		No	Yes			Consumer Products
<b>PMMA, Acrylic</b> Polymethyl Methacrylate	150-310 235-250 °C	50-150 100-120 °C	●●	●	●●●	●●		Acetone	No			Light diffusers, Modelling
<b>POM, Acetal</b> Polyoxymethylene	150-310 210-225 °C	50-150 130 °C	●●●	●	●●	●●●		Chemical	No	-		Functional Parts
<b>PORO-LAY</b> Rubber-elastomeric polymer with PVA	150-310 220-235 °C	50-150 N/A °C	●●●	●	●●	●		Water	Yes		-	Experimental
<b>PP</b> Polypropylene	150-310 210-230 °C	50-150 120-150 °C	●●	●●●	●●	●●●		No	Yes		-	Flexible Components
<b>PVA</b> Polyvinyl Alcohol	150-310 180-230 °C	50-150 N/A °C	●●●	●	●●	●		Water	Yes		-	Support Structures
<b>Sandstone (Laybrick)</b> Co-polyester and chalk powder	150-310 165-210 °C	50-150 N/A °C	●	●	●	●●		No	No		-	Architectural Modelling
<b>TPC</b> Thermoplastic Copolyester	150-310 210-210 °C	50-150 60-100 °C	●	●●●	●●	●●●		No	No		-	Elastic Parts, Outdoor Use
<b>Wax (MOLDLAY)</b> Wax-like properties	150-310 170-180 °C	50-150 N/A °C	●	●	●	●		No	No		-	Lost Wax Casting
<b>Wood (Laywood)</b> Wood PLA Blend	150-310 195-220 °C	50-150 N/A °C	●●	●●	●●	●●		No	No		-	All Purpose (natural finish)