

MATERIALS GUIDE

Material	Summary	Printing Temperature (°C)	Heated Bed Temperature (°C)	Print Speed	Fan Speed (%)	Adhesion	Nozzle Requirement?
PLA	Easy to print and low warp - ideal for general prototyping	205 ±10	0-60	Medium-High	50-100	hairspray, bluetape, glass, PEI	≥0.2mm
PLA Matte	Matte-finish and textured feel	205 ±10	0-60	Medium-High	50-100	hairspray, bluetape, glass, PEI	≥0.2mm
ePLA	Engineering-grade PLA with mechanical properties and heat resistance of 95°C+	235 ±10	0-70	Medium-High	75-100	hairspray, bluetape, glass, PEI	≥0.2mm
PLA Cosmic	Featuring non-toxic metallic flakes for that extra sparkle	215 ±10	0-60	Medium-High	50-100	hairspray, bluetape, glass, PEI	≥0.4mm
Wood	PLA-based; looks, smells and feels like wood	210 ±10	0-60	Medium-High	50-100	hairspray, bluetape, glass, PEI	≥0.4mm
ONE PET	Stiff and tough PET material made from recycled plastic bottles	250 ±10	80-100	Medium	40-70	hairspray, bluetape, glass, PEI	≥0.2mm
PETg	Easy to print and durable - also food contact acceptable	215 ±10	60-80	High	50-100	hairspray, bluetape, glass, PEI	N/A
Carbon Fibre	PET-based filament featuring 20% carbon fibre powder for extra rigidity	235 ±10	0-60	High	50-100	hairspray, bluetape, glass, PEI	Hardened nozzle; ≥0.5mm
ABS	High impact strength with minimal warping	250 ±10	80-100	Medium	0-25	hairspray, bluetape, glass, PEI	≥0.2mm
ASA	Strong, minimal warping and UV resistant so perfect for outdoors	245 ±10	80-100	Medium	0-25	hairspray, bluetape, glass, PEI	≥0.2mm
bioPC	Impact resistant, high chemical resistant and heat resistant to 100°C	270 ±10	100	Low-Medium	10%	hairspray, bluetape, glass, PEI	≥0.2mm
FLEXpro	Flexible, heat resistant to 140°C, oil-resistant and 450% elongation at break	235 ±15	0-60	Medium-Fast	Medium-Fast	hairspray, bluetape, glass, PEI	≥0.2mm