Filament	Nozzle Temp °C	Bed Temp °C	Density	Melt Index	Tensile strength	Elongation at break	Bending strength	Flexural modulus	Izod impact strength	Distortion Temp	Fanle
PLA	190-210	50-70	1.23g/cm³	12-15(190°C/216kg)g/10min	≥ 38 MPa	15.00%	60MPa	2700MPa	3.9 kj/m²	53°C(0.45MPa)	100%
PLA+	200-220	50-70	1.2g/cm³	14(190°C/216kg)g/10min	≥ 50MPa	11.20%	91MPa	1913MPa	5.4kj/m²	53°C(0.45MPa)	100%
PLA Pro	180-220	50-65	1.25g/cm³	7-15(190°C/216kg)g/10min	≥ 44 MPa	6.00%	8OMPa	2900MPa	5 kj/m²	57°C(0.45MPa)	100%
HS-PLA	210-230	50-70	1.22g/cm³	8.2(190°C/216kg)g/10min	≥ 60 MPa	19.10%	80MPa	2680MPa	3.85 kj/m²	53°C(0.45MPa)	100%
Silk-PLA	195-230	50-70	1.21g/cm³	12.8(190°C/216kg)g/10min	≥ 52MPa	14.20%	65MPa	1440MPa	5.8kj/m²	50°C(0.45MPa)	100%
Dual-color Silk PLA	195-230	50-70	1.2g/cm³	12.8(190°C/216kg)g/10min	≥ 55MPa	19.80%	68MPa	1650MPa	3.9kj/m²	53°C(0.45MPa)	100%
Tri-color PLA	195-230	50-70	1.2g/cm³	12.8(190°C/216kg)g/10min	≥ 55MPa	19.80%	68MPa	1650MPa	3.9kj/m²	53°C(0.45MPa)	100%
PLA	200-220	50-70	1.23g/cm³	14(190°C/216kg)g/10min	≥ 50MPa	11.20%	91MPa	1913MPa	5.4kj/m²	53°C(0.45MPa)	100%
Glow in the dark PLA	200-220	50-70	1.23g/cm³	14(190°C/216kg)g/10min	≥ 50MPa	11.20%	91MPa	1913MPa	5.4kj/m²	53°C(0.45MPa)	100%
Titanium metal PLA	200-220	50-70	1.22g/cm³	14(190°C/216kg)g/10min	≥ 60MPa	12.20%	93MPa	1918MPa	5.6kj/m²	54°C(0.45MPa)	100%
Silk Rainbow PLA	195-230	50-70	1.21g/cm³	12.8(190°C/216kg)g/10min	≥ 52MPa	14.20%	65MPa	1440MPa	5.8kj/m²	50°C(0.45MPa)	100%
Glitter PLA	200-220	50-70	1.23g/cm³	14.5(190°C/216kg)g/10min	≥ 52MPa	11.50%	90MPa	1915MPa	5.3kj/m²	53.5°C(0.45MPa)	100%
Copper Red PLA	190-220	50-70	1.35g/cm³	10(190°C/216kg)g/10min	≥ 63MPa	11.80%	93MPa	2280MPa	5.2kj/m²	53°C(0.45MPa)	100%
Wood PLA	190-220	50-70	1.20g/cm³	12.1(190°C/216kg)g/10min	≥ 50MPa	23.20%	61MPa	2130MPa	4.4kj/m²	51°C(0.45MPa)	100%
OAK PLA	190-210	50-70	1.23g/cm³	12-15(190°C/216kg)g/10min	≥ 38 MPa	15.00%	60MPa	2700MPa	3.9 kj/m²	53°C(0.45MPa)	100%
Marble PLA	190-220	50-70	1.23g/cm³	13.1(190°C/216kg)g/10min	≥ 53MPa	12.50%	91MPa	1930MPa	5.2kj/m²	53°C(0.45MPa)	100%
PLA-CF	190-220	50-70	1.21g/cm³	12.3(190°C/216kg)g/10min	≥ 30MPa	6.20%	36MPa	2850MPa	4.4kj/m²	53°C(0.45MPa)	100%
Matte PLA	200-230	50-65	1.31g/cm³	5-8(190°C/216kg)g/10min	≥ 42 MPa	10.00%	80MPa	2825MPa	5.9 kj/m²	58°C(0.45MPa)	100%
PETG	230-250	70-90	1.26g/cm³	20(250C/2.16kg)g/10min	≥ 50MPa	82.00%	65MPa	1078MPa	4.7kj/m²	62°C(0.45MPa)	100%
HS-PETG	230-260	70-90	1.26g/cm³	13-15(190C/2.16kg)g/10min	≥ 51MPa	8.80%	64MPa	1072MPa	4.8kj/m²	62°C(0.45MPa)	100%
Glitter-PETG	230-250	70-90	1.28g/cm³	20.5(250C/2.16kg)g/10min	≥ 50MPa	83.00%	64MPa	1078MPa	4.7kj/m²	62°C(0.45MPa)	100%
TPU	200-230	50-70	1.21g/cm³	1.2(190°C/2.16kg)	≥ 34MPa	680.00%					
ABS	240-270	90-110	1.04g/cm³	13(190°C/2.16kg)	≥ 42MPa	22.00%	66MPa	1179MPa	27kj/m²	77°C(0.45MPa)	0%
ASA	250-270	90-110	1.1g/cm³	25(220°C/216kg)g/10min	≥ 44 MPa	6.80%	75MPa	3200MPa	5 kj/m²	105°C(0.45MPa)	100%
PA	250-290	90-110	1.12g/cm³	5.3(230°C/216kg)g/10min	≥ 56 MPa	180.00%	56MPa	1480MPa	15 kj/m²	50°C(0.45MPa)	0%
PETG-CF	230-250	70-90	1.25g/cm³	19.6(250C/2.16kg)g/10min	≥36MPa	10.20%	72MPa	2950MPa	28kj/m²	72°C(0.45MPa)	100%
PA-CF	250-280°C	50-70	1.24g/cm³	10.3(250°C/216kg)g/10min	≥ 76MPa	26.20%	123MPa	4980MPa	12.4kj/m²	153°C(0.45MPa)	100%
ABS-CF	240-270°C	100-110	1.06g/cm³	14.2(220°C/2.16kg)	≥ 30.8MPa	5.80%	76MPa	2688MPa	3.52kj/m²	97°C(0.45MPa)	0%