

# MATERIALS

MATERIAL	SUMMARY	PRINT TEMP	BED TEMP	PRINT SPEED	FAN SPEED	FLOW RATE	RETRACTION	SPECIAL
PLA	Easy to print, low-warp	205±10°C	≤60°C	Medium/high	Medium/high	100%	DD: ±2mm BT: ±5mm	
PLA Cosmic	PLA with non-toxic, glitter flakes	205±10°C	≤60°C	Medium/high	Medium/high	100%	DD: ±2mm BT: ±5mm	Nozzle: ≥0.4mm
ePLA	Engineering-grade, heat resistance >95 °C (after annealing)	230±10°C	50-60°C	Medium/high	Medium/high	103%	DD: ±2.5mm BT: ±6.5mm	Drying advised
PLA Matte	Matte finish, hides layer lines	215±10°C	≤60°C	Medium/high	Medium/high	105%	DD: ±2mm BT: ±5mm	Hardened steel nozzle advised
Wood PLA	Looks, smells and feels like Wood	200±10°C	≤60°C	Medium	Medium/high	104%	DD: ±3mm BT: ±3mm	Nozzle: ≥0.4mm
ONE PET	Stiff and tough, made from 100% recycled plastic bottles	245±10°C	≤70°C	Medium	Medium	100%	DD: ±2mm BT: ±5mm	Drying strongly recommended
PETG	Durable, low-warp and water resistant	240±10°C	≤70°C	Medium	Medium/low	95%	DD: ±3.5mm BT: ±5mm	
Carbon-PETG	80% PETg, 20% Carbon Fibre powder. Strong and lightweight.	240±15°C	≤70°C	Medium	Low/none	105%	DD: ±1.5mm BT: ±4mm	Hardened steel nozzle; ≥0.5mm
ABS	Ultra low-warp, high impact strength.	245±10°C	≥100°C	Medium	Low/none	100%	DD: ±1.5mm BT: ±4mm	
ASA	Ultra low-warp, high impact strength, UV resistant	240±10°C	80-90°C	Medium	Low/none	100%	DD: ±2mm BT: ±3mm	

**Please note:** These ranges should work for most printers but feel free to experiment to get the best results. For recycled content per material (ISO 14021) and also EU Food Safe Declaration, please see [filamentive.com/downloads](https://filamentive.com/downloads)

Want to try some of these materials? Samples available: [filamentive.com](https://filamentive.com)

