



FILATECH
Making It Better

Attention! Please Read Carefully before Attempting to 3D Print



Achtung! Bitte lesen Sie sorgfältig, bevor Sie versuchen, 3D-Druck

RECOMMENDED PRINTING CONFIGURATION FOR FILATECH FILAMENTS
(PARAMETERS TESTED ON PRUSA MK2 AND MK3 PRINTERS)

Grade	Filament			Extruder						Bed			Cooling		Printing Speed (mm/s)	Remarks
	Product	Carrier	Size (mm)	Drive Type		Nozzle		Temp (C)		Temp (C)		Surface	Fan	Enclosure		
				Direct	Bowden	Material	Dia (mm)	1st Layer	Others	1st Layer	Others					
Commercial	PLA/PLA+	Polylactic Acid	1.75	Yes	Yes	Normal	0.4	205	200	60	55	Smooth	ON/Auto	N/A	20-120	
	ABS	Acrylonitrile Butadiene Styrene	1.75	Yes	Yes	Normal	0.4	255	255	110	100	Smooth	ON/Auto	N/A	20-100	
	PETG	Polyethylene terephthalate Glycol-Modified	1.75	Yes	Yes	Normal	0.4	240	235	90	85	Smooth	ON/Auto	N/A	20-120	
Speciality	PA	Polyamid (Nylon)	1.75	Yes	Yes	Normal	0.4	275	275	110	100	Smooth	OFF	YES	20-70	
	PC	Polycarbonate	1.75	Yes	Yes	Normal	0.4	275	275	110	100	Smooth	OFF	YES	20-70	
	HIPS	High Impact Polystyrene	1.75	Yes	Yes	Normal	0.4	230	225	100	110	Smooth	ON/Auto	N/A	20-100	
	TPU	Thermoplastic Polyurethan	1.75	Yes	With Precutions	Normal	0.4	230	235	50	50	Smooth	ON/Auto	N/A	20-100	
	TPU+	Thermoplastic Polyurethan	1.75	Yes	With Precutions	Normal	0.4	210	205	50	50	Smooth	ON/Auto	N/A	20-100	
	TPE	Themoplastic Elastometer	1.75	Yes	No	Normal	0.4	230	225	50	50	Smooth	ON/Auto	N/A	20-80	Use Min. 0.6mm Nozzle for better extrdusion, Due to very soft Filament
	WPLA	Wood-PLA Composite	1.75	Yes	Yes	Normal	0.6	215	210	60	55	Smooth	ON/Auto	N/A	20-120	To Prevent Nozzle Blockage By Fibers, It Is Recommended To Use Min. 0.6mm Nozzle
Engineering (FilaENG)	FilaPLA	High Temperature PLA Compound	1.75	Yes	Yes	Normal	0.4	235	230	50	50	Smooth	ON/Auto	N/A	20-100	Anneal at 80C for 30 min To Acheave Max HDT (100C)
	FilaTough	High Performace Engineering Compound	1.75	Yes	Yes	Normal	0.4	245	240	80	80	Smooth	OFF	N/A	20-70	
	FilaCarbon	ABS-Carbon Fiber Composite	1.75	Yes	Yes	Hardened Steel	0.6	255	255	110	100	Smooth	ON/Auto	N/A	20-100	To Prevent Nozzle Blockage By Carbon Fibers, It Is Recommended To Use Min. 0.6mm Hardened Steel Nozzle
	FilaFlexible30	TPEE Base Compound	1.75	Yes	With Precutions	Normal	0.4	235	235	50	50	Smooth	ON/Auto	N/A	20-100	
	FilaFlexible40	TPEE Base Compound	1.75	Yes	Yes	Normal	0.4	235	235	50	50	Smooth	ON/Auto	N/A	20-100	
	FilaFlexible55	TPEE Base Compound	1.75	Yes	Yes	Normal	0.4	235	235	50	50	Smooth	ON/Auto	N/A	20-100	