



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, CREALITY AND BAMBOOLAB 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 Textured	ON/Auto	N/A	200-250	
	ABS	Acrylonitrile Butadiene Styrene	1.75	Yes	Yes	Normal	0.4	255	255	110	100	Smooth Textured	ON/Auto	N/A	200-250	
	PETG	Polyethylene terephthalate Glycol-Modified	1.75	Yes	Yes	Normal	0.4	240	235	90	85	Smooth Textured	ON/Auto	N/A	200-250	
Hyper	Hyper PLA	Polylactic Acid	1.75	Yes	Yes	Normal	0.4	220	220	60	55	Smooth Textured	ON/Auto	N/A	400-600	
	Hyper ABS	Acrylonitrile Butadiene Styrene	1.75	Yes	Yes	Normal	0.4	265-270	265-270	100	90	Smooth Textured	ON/Auto	N/A	400-600	
	Hyper PETG	Polyethylene terephthalate Glycol-Modified	1.75	Yes	Yes	Normal	0.4	250	255	70	70	Smooth Textured	ON/Auto	N/A	400-600	
Speciality	PA	Polyamid (Nylon)	1.75	Yes	Yes	Normal	0.4	275	275	110	100	Smooth Textured	OFF	YES	20-70	For Printers with enclosure and heated chamber you can use the fan
	PC	Polycarbonate	1.75	Yes	Yes	Normal	0.4	275	275	110	100	Smooth Textured	OFF	YES	20-70	For Printers with enclosure and heated chamber you can use the fan
	HIPS	High Impact Polystyrene	1.75	Yes	Yes	Normal	0.4	230	225	100	110	Smooth Textured	ON/Auto	N/A	20-100	
	TPU	Thermoplastic Polyurethan	1.75	Yes	With Precutions	Normal	0.4	230	235	50	50	Smooth Textured	ON/Auto	N/A	20-100	
	TPU+	Thermoplastic Polyurethan	1.75	Yes	With Precutions	Normal	0.4	210	205	50	50	Smooth Textured	ON/Auto	N/A	20-100	
	TPE	Themoplastic Elastometer	1.75	Yes	No	Normal	0.4	230	225	50	50	Smooth Textured	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	Hardened Steel	0.6	215	210	60	55	Smooth Textured	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 Textured	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 Textured	OFF	N/A	20-70	For Printers with enclosure and heated chamber you can use the fan
	FilaCarbon	ABS-Carbon Fiber Composite	1.75	Yes	Yes	Hardened Steel	0.6	255	255	100	100	Smooth Textured	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 Textured	ON/Auto	N/A	20-100	
	FilaFlexible40	TPEE Base Compound	1.75	Yes	Yes	Normal	0.4	235	235	50	50	Smooth Textured	ON/Auto	N/A	20-100	
	FilaFlexible55	TPEE Base Compound	1.75	Yes	Yes	Normal	0.4	235	235	50	50	Smooth Textured	ON/Auto	N/A	20-100	