



# MATERIALS MATRIX

MATERIAL	ABS	PLA	PVA	PET/PETG	HIPS	NYLON	PC	PP	ASA	TPU
PROPERTIES	Strong, Light	Rigid, Biodegradable, Food Safe	Soluble, Flexible	Semi-Rigid, High Impact Resistance	Soluble, High Impact Resistance	Strong, Flexible, Impact Resistant	Rigid, Impact Resistant	Firm, Flexible	Rigid, Impact Resistant	Flexible, High Impact Resistance
EXTRUDER HEAD TEMP (°C)	220-250 °C	190-220 °C	185-200 °C	230-245 °C	230-245 °C	220-270 °C	260-310 °C	220-250 °C	235-255 °C	220-250 °C
BED TEMP (°C)	95-110 °C	45-60 °C	45-60 °C	100-115 °C	100-115 °C	75-90 °C	80-120 °C	85-100 °C	90-110 °C	80-100 °C
MAX CONTINUOUS SERVICE TEMP (°C)	98 °C	60-74 °C	75 °C	73 °C	100 °C	80-95 °C	121 °C	100 °C	95 °C	80-100 °C
TENSILE STRENGTH (PSI)	4,100 PSI	7,250 PSI	11,313 PSI	7,700 PSI	3,500 PSI	12,400 PSI	9,500 PSI	5,400 PSI	7977 PSI	5076 PSI