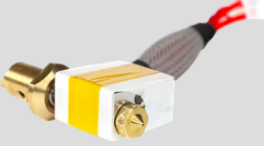

TYPE HEAD MODULE
PRINTING MATERIALS
COMPATIBLE SUPPORT
FILAMENTS

HEAD MODULES

NOZZLE	NOZZLE TYPE	COLOUR	MAX. TEMP.	AVAILABLE NOZZLE DIAMETERS	SPECIFICATION	USE
	LT		240°C	0,4 mm 0,6 mm 0,8 mm	Teflon heatbreak Brass nozzle Aluminium heating block	PLA-36 PVA-20 PET-G-32 TPU-93A
	MT		360°C	0,4 mm 0,6 mm 0,8 mm	Steel heatbreak Brass nozzle Aluminium heating block	ABS-42 ASA-39 PA-6/66 PA-1212 PC-ABS-47 THERMEC™ ZED ODS-20 HIPS-20
	MT-HS		360°C	0,4 mm 0,6 mm 0,8 mm	Steel heatbreak Steel nozzle Aluminium heating block	CF PA-12 GF30-PA6 PETG Carbon other abbrasive
	HT		420°C / 500°C	0,4 mm	Steel heatbreak Steel nozzle Heating block made of nickel-plated copper	PEKK-A

Important! The table includes the current list of filaments and compatible support materials, taking into consideration the settings we tested. It is possible to use other variants, however, we are able to supply printing pressets/profiles to those presented in the table. Currently, the Print-Room Department is testing appropriate solutions for other materials.

MATERIAL	COMPATIBLE SUPPORT FILAMENT		
	Single extrusion	Dual extrusion	
	Breakaway suport	Breakaway suport	Soluble suport
ABS-42	ABS-42	HIPS-20	ODS-20
ASA-39	ASA-39	HIPS-20	ODS-20
CF PA-12	CF PA-12	-	ODS-20
HIPS-20	HIPS-20	ABS-42	-
PA-12	PA-12	-	-
PA-6/66 HD	PA-6/66 HD	-	-
PC-ABS-47	PC-ABS-47	HIPS-20	-
PEKK-A	PEKK-A	-	ODS-20
PET-G-32	PET-G-32	HIPS-20	-
PLA-36	PLA-36	-	PVA-20
THERMEC™ ZED	THERMEC™ ZED	HIPS-20	-
TPU-93A	TPU-93A	-	-
Ultrafuse® ABS Fusion+	Ultrafuse® ABS Fusion+	HIPS-20	ODS-20
XSTRAND™ GF30-PA6	XSTRAND™ GF30-PA6	-	-
ADHESIVE	COMPATIBLE FILAMENT		
DIMAFIX	ABS-42 HIPS-20 ASA-39 PC-ABS-47 PET-G-32 TPU-93A PLA-36 THERMEC™ ZED ODS-20 PVA-20		
PVP GLUE	CF PA-12 PA-6/66 HD XSTRAND™ GF30-PA6		

<i>MATERIAL</i>	NOZZLE TYPE	LEFT HEAD TEMPERATURE	RIGHT HEAD TEMPERATURE	PLATFORM TEMPERATURE	CHAMBER TEMPERATURE
ABS-42	MT, MT-HS, HT	250 °C	230 °C	90 °C	50 °C
ASA-39	MT, MT-HS, HT	250 °C	230 °C	105 °C	70 °C
CF PA-12	MT-HS, HT	245 °C	230 °C	0/95 °C	70 °C
HIPS-20	MT, MT-HS, HT	-	-	-	-
PA-12	MT, MT-HS, HT	250 °C	80 °C	40 °C	0 °C
ODS-20	MT, MT-HS, HT	-	-	-	-
PA-6/66 HD	MT, MT-HS, HT	245 °C	200 °C	0 °C	0 °C
PC-ABS-47	MT, MT-HS, HT	290 °C	230 °C	120 °C	70 °C
PEKK-A	HT	340 °C	200 °C	110 °C	70 °C
PET-G-32	LT	245 °C	230 °C	90 °C	45 °C
PLA-36	LT	215 °C	225 °C	45 °C	30 °C
THERMEC™ ZED	MT, MT-HS, HT	320 °C	195 °C	130 °C	70 °C
TPU-93A	LT	225 °C	225 °C	40 °C	30 °C
Ultrafuse® ABS Fusion+	MT, MT-HS, HT	250 °C	230 °C	90 °C	50 °C
XSTRAND™ GF30-PA6	MT-HS, HT	245 °C	80 °C	80 °C	70 °C