

Bambulab:		PLA	PLA-CF	ABS	ASA	PETG	PETG-CF	PC	TPU 95A	PET-CF	PAHT-CF
	Price EUR	28 €/kg	39 €/kg	28 €/kg	31 €/kg	28 €/kg	39 €/kg	43 €/kg	46 €/kg	91 €/kg 💰	102 €/kg 💰
Props	UV resistance	★★	★★	★	★★★★★	★★★★★	★★★★★	★	★★★	★★★★★	★
	Heat resistance	57 °C ❄️	55 °C ❄️	87 °C	100 °C 🔥	69 °C ❄️	74 °C ❄️	117 °C 🔥	N/A	205 °C 🔥	194 °C 🔥
	Saturated water	0.43%	0.42%	0.65% 💧	0.45%	0.32%	0.30%	0.25%	1.16% 💧	0.37%	0.88% 💧
Resistant	Toughness	27 kj/m²	23 kj/m²	39 kj/m²	41 kj/m² 🤪	53 kj/m² 🤪	41 kj/m²	35 kj/m²	125 kj/m² 🤪	36 kj/m²	58 kj/m² 🤪
Hard	Strength	76 MPa	96 MPa 🤪	68 MPa	65 MPa	81 MPa	83 MPa	108 MPa 🤪	N/A	149 MPa 🤪	140 MPa 🤪
Flexible	Stiffness	2.8 GPa	3.7 GPa 🤪	1.9 GPa 😊	1.9 GPa 😊	1.8 GPa 😊	2.9 GPa	2.3 GPa	😊	5.1 GPa 🤪	4.1 GPa 🤪
Prep	Drying required							🔥	🔥	🔥	🔥
	Drying oven	55°C, 8h	55°C, 8h	80°C, 8h	80°C, 8h	65°C, 8h	65°C, 8h	80°C, 8h	70°C, 8h	80°C, 12h	80°C, 12h
	Drying heatbed	70°C, 12h	70°C, 12h	95°C, 12h	95°C, 12h	80°C, 12h	80°C, 12h	95°C, 12h	85°C, 12h	95°C, 12h	95°C, 12h
Printing	AMS compatible	✓	✓	✓	✓	✓	✓	✓	⊘	⊘	✓
	Liquid Glue	✓	✓	✓	✓	✓	✓	⊘	✓	✓	⊘
	Abrasive		⚙️					⚙️		⚙️	⚙️
	Warp			↓	↓			↓			
	Max overhang	55 °	55 °	70 °	70 °	70 °	70 °	70 °	70 °	70 °	70 °
	Layer adhesion	14 kj/m²	8 kj/m² ↓	7 kj/m² ↓	5 kj/m² ↓	14 kj/m²	11 kj/m²	9 kj/m² ↓	27 kj/m²	5 kj/m² ↓	13 kj/m²
	Max bridge	30 mm	30 mm	40 mm	40 mm	30 mm	30 mm	40 mm	20 mm 🏠	30 mm	40 mm
	Nozzle size	All	>=0.4mm	All	All	All	>=0.4mm	All	>=0.4mm	0.6mm	0.6mm
Build plate	❄️	🔥	🔥	🔥	🔥	🔥	🔥	❄️	🔥	🔥	
Print speed	300mm/s 🏠	250mm/s	300mm/s 🏠	250mm/s	200mm/s ⚡	200mm/s ⚡	300mm/s 🏠	80mm/s ⚡	100mm/s ⚡	100mm/s ⚡	
Tips					Tips			Tips		Tips	
Post process	Annealing	55~60°C 6~12h	55~60°C 6~12h	80~90°C 6~12h	80~90°C 6~12h	N/A	65~70°C 6~12h	85~100°C 6~12h		90~130°C 6~12h	90~130°C 6~12h

<https://bambulab.com/en-ca/filament-guide>

<https://wiki.bambulab.com/en/general/filament-guide-material-table>

<https://wiki.bambulab.com/en/knowledge-sharing/flowrate-calibration-by-microlidar>

Refer to the "Filament TDS" PDF for each filament for more details (overhang, bridge, etc).

💡 If didn't reboot printer and use the same material as last time → Skip flow calibration and vibration calibration.

💡 If same bed temperature as the last print → Skip bed leveling.