



## Printing Various Filaments on Wham Bam PEX Build Surface

| Material                      | Brand Tested | Use                            | Best Hotend Temperature | Best Bed Temperature | Use Fan | Fan % (layer 3) | Squish % | Print Speed (mm/s) | Adhesion Promotor | Release Agent | Warping | Enclosure Required |
|-------------------------------|--------------|--------------------------------|-------------------------|----------------------|---------|-----------------|----------|--------------------|-------------------|---------------|---------|--------------------|
| PC                            | generic      | Strong and Flexible            | 290                     | 110                  | no      | 0               | 70       | 40                 | Glue Stick        | no            | no      | yes                |
| PCTPE                         | Taulman3D    | Semi Flexible                  | 240                     | 70                   | no      | 60              | 70       | 40                 | Glue Stick        | no            | no      | no                 |
| PCTG                          | Essentium    | Strong and Flexible            | 240                     | 70                   | yes     | 50              | 70       | 50                 | no                | no            | no      | no                 |
| Nylon 230                     | Taulman3D    | Strong Wear Resistant          | 230                     | 90                   | no      | 60              | 70       | 40                 | Glue Stick        | no            | yes     | yes                |
| ePA (Nylon) Natural           | eSun         | Strong                         | 250                     | 90                   | no      | 0               | 80       | 30-60              | Glue Stick        | no            | yes     | yes                |
| ePA -CF (Nylon Carbon Filled) | eSun         | Strong                         | 248                     | 90                   | no      | 0               | 90       | 40                 | Glue Stick        | no            | no      | no                 |
| ePA-GF (Nylon Glass Filled)   | SainSmart    | Stong and Rigid                | 248                     | 90                   | no      | 0               | 90       | 40                 | Glue Stick        | no            | no      | no                 |
| PP                            | Verbatim     | Flexible                       | 220                     | 100                  | yes     | 100             | 60       | 40                 | no                | no            | no      | yes                |
| ASA                           | Paramount3D  | Similiar to ABS                | 220                     | 100                  | no      | 0               | 70       | 40                 | Glue Stick        | no            | no      | no                 |
| ABS                           | generic      | Strong                         | 230                     | 110-130              | no      | 0               | 70       | 40                 | no                | no            | yes     | yes                |
| ABS-GF10                      | 3DXTech      | Less warping                   | 235                     | 110                  | no      | 0               | 80       | 40                 | no                | no            | no      | no                 |
| PLA                           | generic      | Easy to use                    | 200-208                 | 70                   | yes     | 100             | 50       | 40                 | no                | no            | no      | no                 |
| PLA-Pro                       | generic      | Higher temp                    | 215-220                 | 70                   | yes     | 100             | 50       | 40                 | no                | no            | no      | no                 |
| PETG                          | generic      | Strong and Resiliant           | 240-250                 | 70                   | yes     | 60              | 80       | 40                 | no                | Glue Stick    | no      | no                 |
| TPU                           | generic      | Flexible                       | 220                     | 60                   | yes     | 50              | 90       | 40                 | no                | no            | no      | no                 |
| PVA                           | generic      | Disolves in Water              | 205                     | 70                   | no      | 0               | 50       | 40                 | Glue Stick        | no            | no      | yes                |
| HIPS                          | generic      | Disolves in Limonene           | 230                     | 110                  | yes     | 50              | 70       | 40                 | no                | no            |         |                    |
| i150-PF                       | IGUS         | Self Lubricating, for Bearings | 245-250                 | 70                   | no      | 0               | 90       | 60                 | none              | none          | none    | no                 |