Filament	Special Properties		Uses	Strength	Flexibility	Durability	Difficulty to print	Print Temperature (˚C)	Bed Temperature (˚C)	Printing notes
ABS	Impact resistant	Durable	Functional Parts	Medium	Medium	High	Medium	210 - 250	50 - 100	
Cleaning		Cleaning	Unclogging of Nozzles	N/A	N/A	N/A	Low	150 - 260	No heated bed needed	
HIPS	Dissolvable	Biodegradable	Support structures when using ABS on a dual extrusion printer.	Low	Medium	High	Medium	210 - 250	50 - 100	
Nylon	Flexible	Durable / Strong	All	High	High	High	Medium	220 - 260	50 - 100	Hygroscopic, keep sealed when not in use
PET	Strong / Recyclable	Durable / Flexible	All	High	High	High	Medium	220 - 250	No heated bed needed	
PETG	More flexible than PLA or ABS	Durable	All	Medium	High	High	Medium	220 - 235	No heated bed needed	
PETT	Strong	Clear / Flexible	Functional Parts	High	High	High	Medium	235 - 240	No heated bed needed	
PLA	Easy to print	Biodegradable	Consumer Products	Medium	Low	Medium	Low	180 - 230	No heated bed needed	
Polycarbonate	Transparent / Heat Resistant	Durable / Very strong	Functional Parts	High	High	High	Medium	270 - 310	90 - 105	
PVA	Dissolvable / Water Soluble	Biodegradable / Oil Resistant	Support structures when using PLA or ABS on a dual extrusion printer.	High	Low	Medium	Low	180 - 230	No heated bed needed	Hygroscopic, keep sealed when not in use
TPC	Extremely Flexible / Rubber-Like	Chemical / Heat resistant	Outdoor / Elastic Parts / UV light resistant	Low	High	Medium	High	210	60 - 100	
TPE	Rubber-Like	Extremely flexible	Elastic Parts / Wearables	Low	High	Medium	High	225 - 235	40	Print very slowly
TPU	Rubber-Like	Extremely flexible	Elastic Parts / Wearables	Low	High	Medium	High	225 - 235	No heated bed needed	Print slowly
Wood		Wood-like finish	Home Decor	Medium	Medium	Medium	Medium	195 - 220	No heated bed needed	