

Flashforge Material Parameters Table

Filament	Printing with enclose	Dry box recommended	Hardened nozzle required	Nozzle temperature (°C)	Bed temperature (°C)	Printable with FF sticker	Printable with glass plate	Printable with PEI sheet	Soluble with common solvents	Water absorption (equilibrium in water, 23°C)	Tensile Strength (MPa)	Flexural Strength (MPa)
Composite Filament												
PA12-CF15(9891BK)	🚫	✅	✅	260-280	70-90	✅	⚠️ (with glue stick)	🚫	🚫	0.3	50-55	90-96
PA6-CF10	🚫	✅	✅	270-300	90-120	✅	⚠️ (with glue stick)	🚫	🚫	0.6	63-67	140-145
PA66-CF10	🚫	✅	✅	280-300	90-120	✅	⚠️ (with glue stick)	🚫	🚫	<1	83.5-88.5	140-145
PET-CF15(9780BK)	🚫	✅	✅	280-300	80-100	✅	⚠️ (with glue stick)	—	🚫	<0.3	45-50	—
PETG-CF10	🚫	✅	✅	230-250	60-80	✅	⚠️ (with glue stick)	✅	🚫	0.8	40-43	75-85
PLA-CF10	🚫	✅	✅	200-230	40-50	✅	⚠️ (with glue stick)	✅	🚫	0.5	40-45	85-95
Engineering Filament												
PA6/66	✅ (recommend)	✅	🚫	230-250	80-90	⚠️ (with glue stick)	⚠️ (with glue stick)	🚫	🚫	3.2	55-58	84-87
PA1010	✅ (recommend)	✅	🚫	250-270	80-90	⚠️ (with glue stick)	⚠️ (with glue stick)	🚫	🚫	0.3	38-40	72.4-76.5
PAHT	✅ (recommend)	✅	🚫	260-280	80-90	⚠️ (with glue stick)	⚠️ (with glue stick)	🚫	🚫	0.5	66.5-68	75-80
PC	✅ (recommend)	✅	🚫	250-270	90-110	✅ (with glue stick)	⚠️ (with glue stick)	⚠️ (with 125°C heated buildplate)	🚫	0.8	40-45	83-87
PP	✅	🚫	🚫	220-240	90-110	⚠️ (with glue stick)	⚠️ (with glue stick)	🚫	🚫	0.5	25~30	25~30
PC-ABS	✅ (recommend)	✅	🚫	250-280	90-110	✅ (with glue stick)	⚠️ (with glue stick)	—	🚫	0.8	43.5~45.5	71.5~74.5
ASA	✅ (recommend)	🚫	🚫	250-260	80-90	✅	⚠️ (with glue stick)	—	✅	1	42-45	75-79
HIPS	✅ (recommend)	🚫	🚫	230-250	80-90	✅	⚠️ (with glue stick)	✅	Soluble in cinene	1	28.5-29.5	46.5-49
Standard Filament												
PLA PRO	🚫	🚫	🚫	190-210	50-55	✅	✅	✅	🚫	<0.3	45.5-49	73-76
PLA	🚫	🚫	🚫	200-220	50-55	✅	✅	✅	🚫	<0.3	45-49	69-75
PETG PRO	🚫	🚫	🚫	220-240	70-80	✅	✅	✅	🚫	<0.2	35-40	45-50
PETG	🚫	🚫	🚫	240-250	80-90	✅	✅	✅	🚫	<0.2	40-45	50-55
ABS PRO	✅ (recommend)	🚫	🚫	230-250	100-110	✅	⚠️ (with glue stick)	✅	Soluble in acetone	1	33-37	65-67
ASA	✅ (recommend)	🚫	🚫	230-250	100-110	✅	⚠️ (with glue stick)	✅	Soluble in acetone	1	35-40	65-70
Flexible Filament												
TPU85A-95A	🚫	🚫	🚫	190-210	50-55	🚫	✅	✅	🚫	0.5	20~25	<10
Flexible	🚫	🚫	🚫	190-210	50-55	🚫	✅	✅	🚫	0.5	15~20	<10
Supporting Filament												
PVA	🚫	✅	🚫	190-210	40-50	✅	⚠️ (with glue stick)	—	Soluble in water	15	73~77	88~93