

Bypass AMS for all engineering and flexible materials. Feed directly from an external dry box through the H2C bypass port.

| Material                      | Nozzle    | Bed   | Speed   | Cooling | Enclosure | Notes                                    |
|-------------------------------|-----------|-------|---------|---------|-----------|------------------------------------------|
| STANDARD MATERIALS 5 items    |           |       |         |         |           |                                          |
| PLA                           | 220–230°C | 35°C  | 150mm/s | 100%    | Open OK   | Textured PEI. AMS compatible.            |
| PETG                          | 230–240°C | 70°C  | 100mm/s | 50–80%  | Open OK   | Light glue stick prevents over-adhesion. |
| ABS                           | 240–255°C | 100°C | 50mm/s  | Off     | Closed    | Glue stick. Enclosure required.          |
| ASA                           | 245–260°C | 95°C  | 50mm/s  | 0–20%   | Closed    | Glue stick optional for large prints.    |
| TPU 95A                       | 225–235°C | 40°C  | 25mm/s  | 50%     | Open OK   | Bypass AMS. Direct drive only.           |
| ENGINEERING MATERIALS 6 items |           |       |         |         |           |                                          |
| PA12                          | 245–260°C | 80°C  | 50mm/s  | Off     | Closed    | Dry 8 hrs at 80°C. PEI + glue stick.     |
| PA6-CF                        | 255–270°C | 85°C  | 45mm/s  | Off     | Closed    | Hardened nozzle. Dry 12 hrs.             |
| PA12-CF                       | 255–275°C | 85°C  | 45mm/s  | Off     | Closed    | Hardened nozzle. Dry 12 hrs.             |
| PC                            | 270–295°C | 110°C | 40mm/s  | Off     | Closed    | All-metal hotend required. Glue stick.   |
| ASA-CF                        | 255–270°C | 95°C  | 40mm/s  | Off     | Closed    | Hardened nozzle. Glue stick optional.    |
| PPA-CF                        | 285–300°C | 120°C | 35mm/s  | Off     | Closed    | Paper spool required. Dry 12 hrs.        |