

Name	Brand	Hotend Temp (°C)	Hot Bed Temp (°C)	Chamber Temp (°C)	Pressure Advance	Maximum Volume Velocity (mm ³ /s)
Hyper PLA	Creality	220	50	35	0.04	23
ENDER FAST PLA	Creality	220	50	35	0.04	23
Hyper ABS	Creality	260	80	50	0.03	23
Hyper PLA-CF	Creality	220	50	35	0.04	23
HP-ASA	Creality	260	90	50	0.04	14
Hyper PETG	Creality	240	70	35	0.05	23
HP-TPU	Creality	220	40	35	0.4	3
CR-TPU	Creality	220	40	35	0.34	2
CR-PETG	Creality	250	70	35	0.05	16
CR-ABS	Creality	260	100	60	0.04	18
CR-PLA	Creality	220	50	35	0.04	18
CR-Silk	Creality	220	50	35	0.04	10
CR-PLA Matte	Creality	220	50	35	0.04	18
CR-PLA Fluo	Creality	220	50	35	0.044	18
EN PLA+	Creality	220	50	35	0.04	18

Generic PLA	Generic	220	50	35	0.04	14
Generic ABS	Generic	260	100	50	0.06	16
Generic TPU	Generic	220	40	35	0.3	2
Generic PETG	Generic	250	70	35	0.1	16
Generic PLA-Silk	Generic	220	50	35	0.04	10
Generic HIPS	Generic	240	100	50	0.05	10
Generic PC	Generic	260	110	50	0.03	16
Generic ASA	Generic	260	90	50	0.04	10
CR-Wood	Crealty	220	50	35	0.044	18
CR-PLA-Carbon	Crealty	220	50	35	0.04	18
HP ULTRA PLA	Crealty	220	50	35	0.04	18
Ender PLA	Crealty	220	50	35	0.04	18
Generic PAHT-CF	Generic	300	90	50	0.036	8
Generic PET-CF	Generic	290	90	40	0.034	8
Generic PPS-CF	Generic	310	105	50	0.058	6
Generic PA6-CF	Generic	300	60	35	0.048	8

Generic PA12-CF	Generic	290	60	35	0.048	8
Generic PA612-CF	Generic	290	60	35	0.048	8
Generic Support for PA	Generic	290	80	35	0.034	6
Generic Support for PLA	Generic	220	50	35	0.04	6
Generic PVA	Generic	220	50	35	0.04	6
Generic BVOH	Generic	220	50	35	0.04	6

Flow Ratio	Cooling Fan (Min/Max) %	Layer Time (Min/Max) (s)	Cooling Overhang Threshold Value (%)	Overhang Fan Speed (%)	Auxiliary Cooling Fan (%)
0.95	100/100	100/4	50	100	80
0.95	100/100	100/6	50	100	80
0.95	10/60	30/12	25	80	0
0.95	100/100	100/8	50	100	0
0.95	10/40	40/10	25	100	0
0.98	40/80	30/8	25	100	0
1	100/100	100/8	95	100	80
1.02	100/100	100/8	95	100	80
0.95	40/80	30/8	25	100	0
0.95	10/60	30/12	25	80	0
0.95	100/100	100/4	50	100	80
0.95	100/100	100/4	50	100	80
0.95	100/100	100/4	50	100	80
0.95	100/100	100/4	50	100	80
0.98	100/100	100/4	50	100	80

0.95	100/100	100/6	50	100	80
0.95	10/60	30/12	25	80	0
1	100/100	100/8	95	100	70
0.95	40/80	30/8	25	90	0
0.95	100/100	100/8	50	100	80
0.95	30/80	30/10	10	80	0
0.95	10/60	30/12	25	60	0
0.95	10/80	40/5	25	80	0
0.95	100/100	100/8	50	100	80
0.95	100/100	100/8	50	100	80
0.95	100/100	100/4	50	100	80
0.95	100/100	100/4	50	100	80
0.93	10/50	30/8	10	70	0
0.95	10/50	30/8	10	70	0
0.95	10/50	30/8	10	70	0
0.93	10/50	30/8	10	70	0

0.93	10/50	30/8	10	70	0
0.93	10/50	30/8	10	70	0
0.95	10/60	30/8	0	70	0
0.98	100/100	100/8	50	100	60
1	100/100	100/8	50	100	60
1	100/100	100/8	50	100	60

Retraction Length (mm)	Retraction Speed (mm/s)
0.8	40
0.8	40
0.8	40
1	40
0.8	40
1.2	40
1.2	40
1.2	30
1.2	40
0.8	40
0.8	40
0.8	40
1.2	40
0.8	40
0.8	40

1.2	40
0.8	40
2	40
1.2	40
1.2	40
0.8	40
0.8	40
0.8	40
0.8	40
0.8	40
0.8	40
0.8	40
0.8	40
1.2	40
1.2	40
1.2	40
1.2	40

1.2	40
1.2	40
1.5	40
1.2	40
1.2	40
1.2	40