

Bambu X2D with AMS 2

Which filament should I use?

BUILD VOLUME 256 × 256 × 260 mm				ADVERTISED ACCURACY 50 µm				MINIMUM LAYER HEIGHT 0.08 mm				STANDARD LAYER HEIGHT 0.20 mm					
REQUIREMENT		PLA				PETG HF				PP							
		PROTOTYPE				GENERAL PURPOSE				CHEMICAL EXPOSURE							
COMMON USE CASES																	
Quick fit / visual model		BEST				GOOD				LIMITED							
Functional bracket / enclosure		LIMITED				BEST				LIMITED							
MECHANICAL LIMITS																	
Pressure (bar(g))		≤ 0.5				≤ 1.0				≤ 1.5*							
Vacuum (mbar)		~ 10				10 ⁻²				10 ⁻² → 5×10 ⁻⁴							
Broad chemical resistance		AVOID				LIMITED				BEST							
Impact / repeated handling		AVOID				BEST				GOOD							
Warm environment		AVOID				GOOD				GOOD							
Easy, predictable printing		BEST				GOOD				LIMITED							
Dimensional accuracy		BEST				GOOD				LIMITED							
* PP holds pressure leak-tight but is flexible and creeps under sustained load — prefer for low-pressure / chemically-exposed service, not rigid pressure vessels.																	
SOLVENT COMPATIBILITY · BRIEF SPLASH ONLY · NO IMMERSION / LIQUID CONTAINMENT · YES = COMPATIBLE · NO = DO NOT USE																	
MATERIAL	WATER	ETHANOL	ISOPRO-PANOL	METHANOL	ACETONE	ACETO-NITRILE	THF	DMF	DMSO	ETHYL ACETATE	TOLUENE	XYLENE	HEXANE / HEPTANE	DCM	CHLORO-FORM		
PLA	YES	NO	NO	NO	NO	NO	NO	NO	NO	NO	NO	NO	YES	NO	NO		
PETG HF	YES	YES	YES	NO	NO	NO	NO	NO	NO	NO	NO	NO	YES	NO	NO		
PP	YES	YES	YES	YES	YES	YES	NO	YES	YES	NO	NO	NO	YES	NO	NO		
NEED A SPECIAL PROPERTY? OTHER COMPATIBLE MATERIALS																	
FLEXIBLE TPU 85A			TOUGH / WEAR NYLON / PA			STIFF / STABLE PA-CF / PET-CF			UV / HIGH HEAT ASA / PC			SOLUBLE SUPPORT PVA / BVOH			ESD CONTROL ESD-RATED		