Public printing recommendation

Prusa3D Prusament ASA Pro Green

MaterialID MAT0015

3DPIceland Labs

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WORKFLOW-RELIABILITY - Bug Fixes and Workflow Reliability

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Guidance boundary: values below are shared base-material guidance resolved only through the canonical BaseMaterialId link. They are not manufacturer-, spool- or printer-specific validated settings. Missing fields remain Not recorded.

Overall	Engineering axes	Public rank	MSRP USD/kg
48/100	**6/5**	**99 / 234**	**26.40**

Engineering profile

Recommended applications

- Rigid brackets, fixtures and shape-stable prototypes
- Repeatable print jobs and production-style batches
- Cosmetic parts, concept models or low-load prototypes
- Avoid high tensile load applications

Measured strengths

- Consistency: 81/100. Repeatability is one of the stronger signals in this material profile.
- Impact: 44/100. Impact behavior is competitive against the material-family context.
- Stiffness: 71/100. Stiffness is a relative advantage in this comparison group.

Limitations

- Tensile: 23/100. Avoid using this as the primary choice for tensile-loaded parts.
- Layer adhesion: 24/100. Z-axis performance should be treated with caution.

Engineering trade-offs

- Good repeatability does not compensate for low tensile capability in load-bearing designs.
- Stiffness is useful for shape stability, but impact tolerance is a separate limitation.
- The report should be read as a suitability warning rather than a general-purpose recommendation.

Base-material printing guidance

Guidance	Minimum	Recommended	Maximum	Unit
Nozzle temperature	250	260	270	°C
Bed temperature	110	110	110	°C
Print speed	55	165	165	mm/s
Cooling	20	20	25	%

Guidance	Value	Unit
Cooling guidance	Low	
Drying temperature	85	°C
Drying time	6	hours
Enclosure	Required	
Printer / G-code reference	PrusaCoreOneL	
Slicer profile reference	Prusament ASA	

Print workflow checks

- Confirm nozzle temperature, bed temperature, speed, cooling and drying requirements from the manufacturer profile or spool label.
- Print a small validation part before committing to a long, costly or safety-relevant print.
- Orient the part so the governing load does not rely on an unverified or weak engineering axis.
- Engineering/high-temperature family: confirm enclosure, ventilation, warping control and material-specific drying requirements.
- Layer-adhesion evidence is weak; avoid critical Z-axis loading without additional validation.

Decision guidance

- Use this material mainly for low-load, visual or experimental parts.
- Do not choose it as a tensile-strength benchmark material.

Stronger same-family alternatives

MaterialID	Material	Manufacturer	Overall	Tensile	Impact

Confirm exact settings against the manufacturer profile, spool label and actual printer/material combination. Results do not replace application-specific validation.

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