



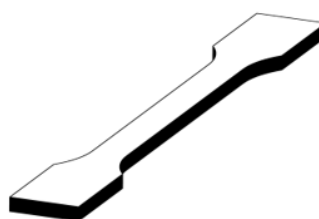
Physical Properties	Value	Standard
Density	1.07 g/cc	ISO 1183
Ball Indentation Hardness	85 MPa	ISO 2039-1

Mechanical Properties

TENSILE TEST - STANDARD ISO 527

Test specimens printed on Ultimaker 2+ with the following setup:

- Nozzle type: Standard Brass 0.4
- Nozzle Temperature: 260 °C
- Heat bed Temp: 100 °C
- Print speed: 25 mm/s
- Infill orientation: 45°
- Cooling fan: OFF



xy

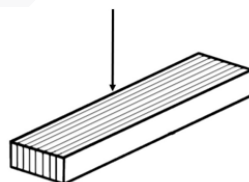
INFILL	15%	50%	100%
Tensile Strength (Mpa)	20.2	24.5	38.6
Elastic Modulus (Mpa)	1246	1312	2191
Elongation at break (%)	3.72	4.31	4.21
Energy at break (J)	2.04	3.06	4.40

FLEXURAL TEST - STANDARD ISO 178

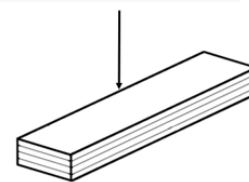
Test specimens printed on Ultimaker 2+ with the following setup:

- Nozzle type: Standard Brass 0.4
- Nozzle Temperature: 260 °C
- Heat bed Temp: 100 °C
- Print speed: 25 mm/s
- Infill orientation: 45°
- Cooling fan: OFF

zy - parallel



xy - normal



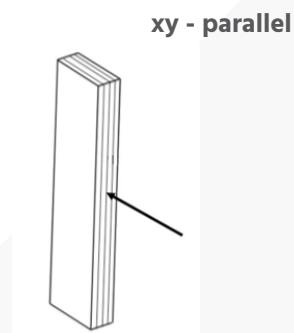
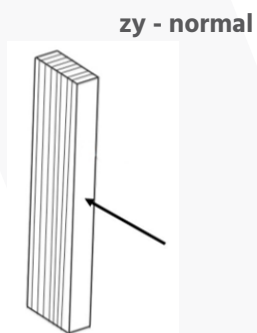
INFILL	50%	100%	50%	100%
Flexural Strength (Mpa)	71.2	85.7	64.7	80.1
Flexural Modulus (Mpa)	1845	2034	1839	2236
Deformation (%)	4.25	4.94	5.01	5.54



IMPACT TEST IZOD - STANDARD ISO 180

Test specimens printed on Ultimaker 2+ with the following setup:

- Nozzle type: Standard Brass 0.4
- Nozzle Temperature: 260 °C
- Heat bed Temp: 100 °C
- Print speed: 25 mm/s
- Infill orientation: 45°
- Cooling fan: OFF



INFILL	50%	100%	50%	100%
Impact Strength (KJ/m ²)	16.87	27.17	15.04	24.88
Impact Energy (J)	0.68	1.05	0.60	1.00

Thermal Properties	Value	Standard
Vicat Softening Temp.	113 °C	ISO 306/A50
Heat Deflection Temp.	106 °C	ISO 75-2/B

Electrical Properties	Value	Standard
Dielectric Constant (100 Hz)	3.9	IEC 60250
Volume resistivity	1.0E12 ohm*m	IEC 60093

Filament specifications and print settings

Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Roundness Deviation	max 2%
Suggested Print Temperature	260 °C
Suggested Print Speed	20 – 40 mm/s
Suggested Bed Temperature	100 °C
Cooling Fan	OFF