
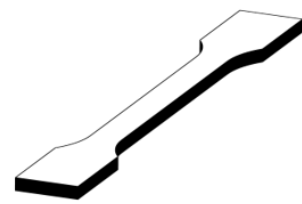




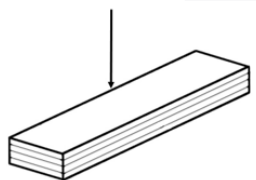
Physical Properties	Value	Standard
Density	1.27 g/cc	ISO 1183

Mechanical Properties

TENSILE TEST - STANDARD ISO 527

<p>Test specimens printed on Ultimaker with the following setup:</p> <ul style="list-style-type: none"> • Nozzle Temperature: 310 °C • Heat bed Temp: 90 °C • Print speed: 40 mm/s • Infill orientation: 45° 	 <p>xz</p>	 <p>xy</p>
	INFILL	100%
Tensile Strength (Mpa)	22.1	51.28
Elastic Modulus (Mpa)	1562	2085
Elongation at break (%)	3.52	5.68
Energy at break (J)	1.58	7.72

FLEXURAL TEST - STANDARD ISO 178

<p>Test specimens printed on Ultimaker with the following setup:</p> <ul style="list-style-type: none"> • Nozzle Temperature: 310 °C • Heat bed Temp: 90 °C • Print speed: 40 mm/s • Infill orientation: 45° 	 <p>xy - normal</p>
	INFILL
Flexural Strength (Mpa)	79.32
Flexural Modulus (Mpa)	1785.6
Deformation (%)	6.63

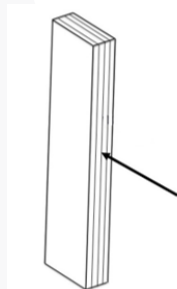


IMPACT TEST IZOD - STANDARD ISO 180

Test specimens printed on Ultimaker with the following setup:

- Nozzle Temperature: 310 °C
- Heat bed Temp: 90 °C
- Print speed: 40 mm/s
- Infill orientation: 45°

xy - parallel



INFILL	100%
Impact strength (KJ/m ²)	78.2
Impact Energy (J)	3.19

Thermal Properties	Value	Standard
Melting Point	280 °C	ISO 11357
Heat Deflection Temp. @ 1.82 MPa	108 °C	ISO 75

Other Properties	Value	Standard
Flammability	V-0	UL94

Filament specifications and print settings

Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.10 mm
Roundness Deviation	max 2%
Suggested Print Temperature	300 – 320 °C
Suggested Print Speed	25 – 45 mm/s
Suggested Bed Temperature	90 – 120 °C