

PROPERTIES AND RECOMMENDATIONS

Physical properties *

Property	Typical	Unit
Density (at 21.5 °C)	1,2	g/cm ³
Glass transition temperature	61	°C
Crystallization temperature	114	°C
Softening temperature	129 - 132	°C
Melting temperature	150	°C

* Tested using 100% Infill

Mechanical properties *

Property	Typical	Error	Unit
Young's modulus	2636	± 330	MPa
Tensile strength	46.6	± 0.9	MPa
Elongation at break	1.90%	± 0.2%	-
Bending modulus	3283	± 132	MPa
Bending strength	85.1	± 2.9	MPa
Impact strength	2.7	± 0.2	KJ/m ²

* Tested using 100% Infill, a printing temperature of 205 °C and a printing speed of 60 mm/s.

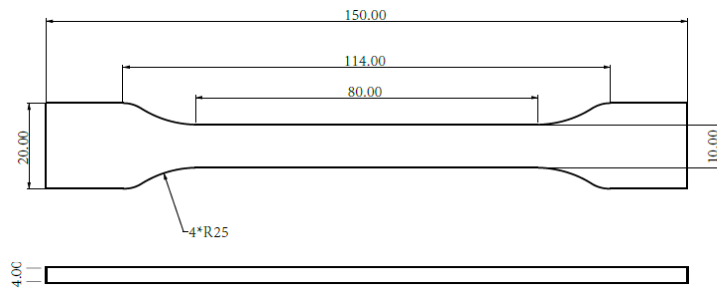
Recommendet printing conditions for a typical FDM 3d-printer *

Property	Typical	Unit
Nozzle temperature	190 - 230	°C
Build plate temperature	25 - 60	°C
Printing speed	50 - 70	mm/s
Environmental temperature	19 - 21	°C
Threshold overhang angle	45	°

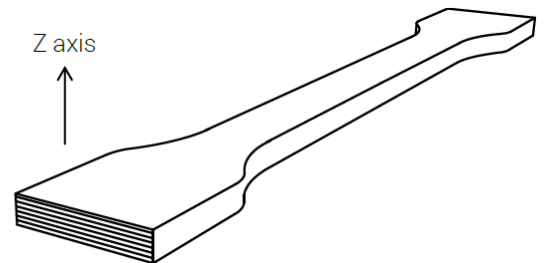
* eg. Raise 3D E2, Ultimaker S5 or Ender 3 Pro.

TESTING GEOMETRIES

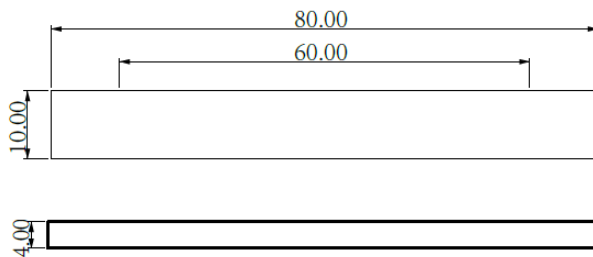
To test tensile properties *



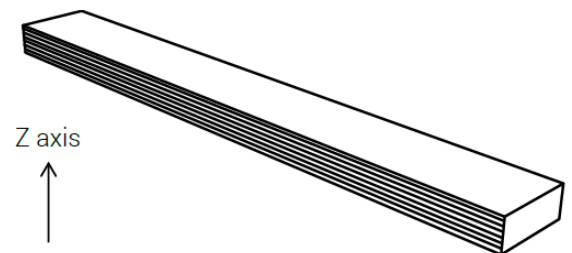
* Units in mm



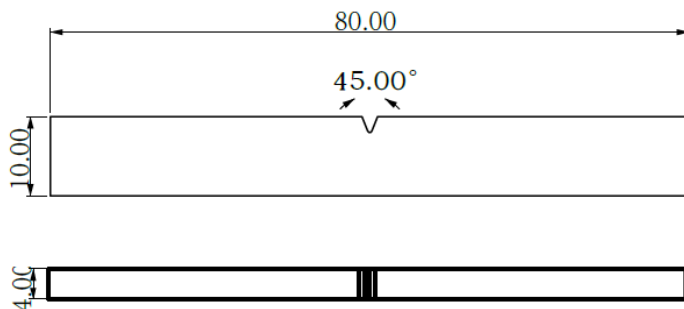
To test flexural properties *



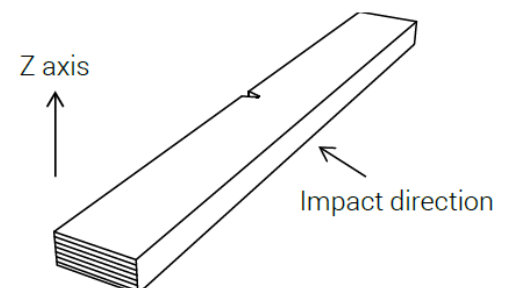
* Units in mm



To test impact properties *



* Units in mm



DISCLAIMER

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End-use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

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