

Material properties

Melt temperature	190-215	°C	ASTM D3418
Glass transition temperature	55-60	°C	ASTM D3418
Heat distortion temperature HDTB (0,45 MPa)	56	°C	ISO 75
Vicat Softening Temperature	60	°C	ASTM D1525
Met Flow Rate (210 C/2.16 kg)	9,56	g	ASTM D1238
Density	1,24	g/cm ³	ASTM D790
Water absorption, 24 u	0.1	%	ASTM D570
Shrink rate	0.5-0.7	%	ASTM D955

Mechanical properties

Tensile Strength (break, 3.20 mm/50 mm/min)	52	MPa	ISO 527
Tensile Modulus (3.20 mm/1.0 mm/min)	1320	MPa	ISO 527
Tensile elongation, (break, 3.20 mm/50 mm/min)	5	%	ISO 527
Flexural Modulus (3.20 mm/15 mm/min) ³	600	MPa	ISO 178
Flexural Strength (3.20 mm/15 mm/min)	108	MPa	ISO 178
Rockwell hardness (R-scale)	95		ASTM D785

Printer settings

Printer	Desktop FFF printer
Nozzle	0.4 mm A2 hardened
Layer height	0.2 mm
Infill	100% ±45
Extrusion Temperature	190 - 215 °C
Bed temperature	0 - 60 °C
Bed preparation	Clean or 3DLAC
Print speed	20-40 mm/sec
Requirements	Cooling fan