



MATERIAL SPECIFICATION

Properties	Value	Test Method - ISO
Density	105 g/cm ³	1183B
Vicat Softening Temperature	102°C	306/B50
Tensile Modulus	2150 MPa	527-2
Tensile Stress	43 MPa	527-2/50
Flextural Modulus	2100 MPa	178
Flextural Stress	70 MPa	178

FILAMENT SPECIFICATION

Properties	Value and Tolerances
Diameter 1.75/2.85 mm	±0.05 mm
Roundness deviation	max 3%
Suggested print temperature (guideline)	240 - 250°C
Suggested print speed	40 - 80 mm/s
Suggested bed temperature	90 -110°C