



## MATERIAL SPECIFICATION

Properties	Value	Test Method - ISO
Density	1,09 g/cm <sup>3</sup>	1183B
Vicat Softening Temperature	109°C	306/B50
Tensile Modulus	2000 MPa	527-2
Tensile Stress	43 MPa	527-2/50
Notched Impact Strenght	50 kJ/m <sup>3</sup>	179/1
Molding shrinkage	0.4 - 0.7 %	294-4

## FILAMENT SPECIFICATION

Properties	Value and Tolerances
Diameter 1.75/2.85 mm	±0.08 mm
Roundness deviation	max 4%
Suggested print temperature (guideline)	240 - 260°C
Suggested print speed	30 - 60 mm/s
Suggested bed temperature	100 -110°C