



## MATERIAL SPECIFICATION

Properties	Value	Test Method - ASTM
Density	1,25 g/cm <sup>3</sup>	D792
Melting Point	165-180°C	D3418
Tensile Modulus	2500 MPa	D638
Tensile Stress	42 MPa	D638
Glass Transition Temperature	55-60°C	D3418
Izod Impact Strength	40 J/m	D256
Heat Distortion Temperature	>100°C (after post-annealing)	D648

## 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