

**Product Texts**

Printing direction	XY
Printing speed	20-40 mm/s
Infill	100%-rectilinear
Infill angle	45°/-45°
Chamber temperature	60-80°C
Extrusion temperature	370-380°C
Bed temperature	110-125°C

**Processing/Physical Characteristics**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	42	g/10min	ISO 1133
Temperature	380	°C	-
Load	5	kg	-

**Thermal properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	308	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	159	°C	ISO 11357-1/-2
Temp. of deflection under load, 1.80 MPa	172	°C	ISO 75-1/-2

**ASTM Data**

UL 94 Flame rating	V-0	-	UL 94
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**Electrical properties**

	Value	Unit	Test Standard
<b>ISO Data</b>			
Electric strength	84	kV/mm	IEC 60243-1
<b>ASTM Data</b>			
Surface Resistivity	1E16	Ohm	ASTM D 257

**Other properties**

Density	1260	kg/m <sup>3</sup>	ISO 1183
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**3D Data**

	Value	Unit	Test Standard
<b>Other Standards<sup>[S]</sup></b>			
Tensile modulus, flat	2510	MPa	ISO 527
Tensile strength, flat	65	MPa	ISO 527
Stress at break, flat	48	MPa	ISO 527
Strain at break, flat	5	%	ISO 527
Flexural modulus, flat	1660	MPa	ISO 178
Charpy notched impact strength, +23°C, flat	2.5	kJ/m <sup>2</sup>	ISO 179/1eA

S: These properties are reported by the producer according standards that are different to our defaults.

**Characteristics****Processing**

Additive Manufacturing

**Chemical Resistance**

General Chemical Resistance

**Delivery form**

Monofilament

**Regional Availability**

Europe

**Special Characteristics**

Flame retardant, Heat stabilized or stable to heat