

Product Texts

Printing direction	ZX (XZ)
Printing speed	45 mm/s
Infill	100%
Infill angle	45°/-45° (-)
Nozzle temperature	360°C
Bed temperature	95°C

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	35	g/10min	ISO 1133
Temperature	380	°C	-
Load	5	kg	-

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	332	°C	ISO 11357-1/-3
Glass transition temperature, 10°C/min	161	°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
Thickness tested	0.8	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Relative permittivity, 1MHz	2.6 ^[1]	-	IEC 62631-2-1
Electric strength	84 ^[1]	kV/mm	IEC 60243-1
ASTM Data			
Surface Resistivity	1E16 ^[1]	Ohm	ASTM D 257

1: ZX

Other properties	Value	Unit	Test Standard
Density	1270	kg/m ³	ISO 1183

3D Data	Value	Unit	Test Standard
Other Standards^[5]			
Tensile modulus, on-edge	2450	MPa	ISO 527
Tensile modulus, upright	2780	MPa	ISO 527
Tensile strength, on-edge	64.1	MPa	ISO 527
Tensile strength, upright	32.4	MPa	ISO 527
Stress at break, on-edge	64.1	MPa	ISO 527
Stress at break, upright	32.4	MPa	ISO 527
Strain at break, on-edge	4.5	%	ISO 527
Strain at break, upright	1.4	%	ISO 527
Flexural modulus, on-edge	1920	MPa	ISO 178
Flexural modulus, upright	1710	MPa	ISO 178
Flexural strength, upright	62.9	MPa	ISO 178
Charpy notched impact strength, +23°C, on-edge	5.35	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, +23°C, upright	1.9	kJ/m ²	ISO 179/1eA
Volume resistivity, upright	1E16	Ohm*m	ASTM D 257

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