

PHYSICAL PROPERTIES	AVERAGE VALUES	UNITS	STANDARDS
 DENSITY	1,24	g/cm ³	
 FLOW RATE (210°C /2.16KG)	8	g/10 min	ISO 1133-A
 FLOW RATE (190°C /2.16KG)	3	g/10 min	ISO 1133-A
 STEREOCHEMICAL PURITY	96	(% L-isomero)	
 RESIDUAL MONOMER	0.3% (max)		
 MOISTURE (COULOMETRIC KAR L-FISHER)	400 (max)	ppm	
 MELTING TEMPERATURE	155°	°C Tm (DSC)	
 GLASS TRANSITION TEMPERATURE	55 - 60°	°C Tg (DSC)	

MECHANICAL PROPERTIES	AVERAGE VALUES	UNITS	STANDARDS
 TENSILE MODULUS	3500	MPa	ISO 527-1
 TENSILE STRENGTH	45	MPa	ISO 527-1
 STRAIN AT YIELD	5% (max)		ISO 527-1
 CHARPY NOTCHED IMPACT, 23°C	≤5	kJ/m ²	ISO 179-1eA

PRINTING PROPERTIES	AVERAGE VALUES	UNITS	STANDARDS
 NOZZLE TEMPERATURE	190 - 230	°C	
 HOT BED TEMPERATURE	50 - 70	°C	
 COOLING FAN	ON (100)	%	
 PRINT SPEED	80-120	mm/s	

SUGGESTED BED MATERIAL: Glass/Glue, BuildTak, BlueTape, Garolite

SPOOL SIZE	DIAMETER	COLOR	PACKAGING
1Kg	1,75mm	Various	Reusable bag, spool and silica
300g	1,75mm	Various	Reusable bag, spool and silica

* The indicated parameters are valid for correctly calibrated printers (PID, mechanical and fuser).
 * Supervised and tested manufacturing process (diameter, color and winding) to guarantee the quality of our product.
 *Compatible with most FDM 3D printers on the market