

### Physical properties

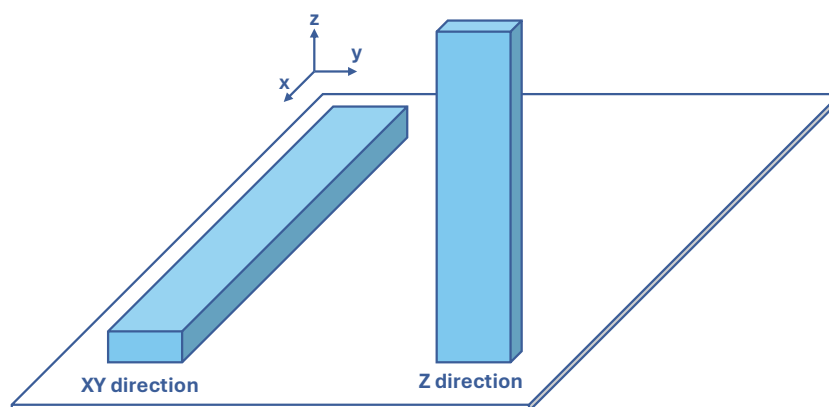
| Property                     | Test method                  | Typical value          |
|------------------------------|------------------------------|------------------------|
| Density                      | ASTM D792                    | 1,24 g/cm <sup>3</sup> |
| Diameter                     | -                            | 1,75/2,85 mm           |
| Diameter tolerance           | -                            | ± 0,05 mm              |
| Roundness tolerance          | -                            | ± 5 %                  |
| Melting temperature          | ASTM D3418                   | 145-160 °C             |
| Glass transition temperature | ASTM D3418                   | 55-60 °C               |
| Melt flow rate (MFR)         | ASTM D1238 (210 °C, 2,16 kg) | 6 g/10 min             |

### Mechanical properties\*

| Property                                   | Test method         | Typical value              |
|--------------------------------------------|---------------------|----------------------------|
| Tensile strength (XY direction)            | ISO 527             | 64±1 MPa                   |
| Tensile strength (Z direction)             | ISO 527             | 36±2 MPa                   |
| Young's modulus (XY direction)             | ISO 527             | 3240±30 MPa                |
| Young's modulus (Z direction)              | ISO 527             | 2850±33 MPa                |
| Elongation at break (XY direction)         | ISO 527             | 2,3±0,05 %                 |
| Elongation at break (Z direction)          | ISO 527             | 1,4±0,1 %                  |
| Bending strength (XY direction)            | ISO 178             | 79±0,8 MPa                 |
| Bending strength (Z direction)             | ISO 178             | 40±10 MPa                  |
| Flexural modulus (XY direction)            | ISO 178             | 2302±95 MPa                |
| Flexural modulus (Z direction)             | ISO 178             | 2012±81 MPa                |
| Impact strength (Charpy) (XY direction)    | ISO 179 (notched)   | 11,6±2,3 kJ/m <sup>2</sup> |
| Impact strength (Charpy) (Z direction)     | ISO 179 (notched)   | 1,5±0,1 kJ/m <sup>2</sup>  |
| Heat deflection temperature (XY direction) | ISO 75-2 (0,45 MPa) | 56±0,3 °C                  |
| Heat deflection temperature (Z direction)  | ISO 75-2 (0,45 MPa) | 54±0,3 °C                  |
| Heat deflection temperature (XY direction) | ISO 75-2 (1,8 MPa)  | 56,6±0,4 °C                |
| Heat deflection temperature (Z direction)  | ISO 75-2 (1,8 MPa)  | 51,9±0,1 °C                |

## Recommended printing conditions

| Property             | Typical value           |
|----------------------|-------------------------|
| Printer              | BambuLab P1S            |
| Printing temperature | 218 °C                  |
| Bed temperature      | 48 °C                   |
| Infill               | 100 %                   |
| Bed                  | Textured PEI, with glue |
| Printing speed       | 200 mm/sec              |



## Packaging

| Property           | Typical value                     |           |           |           |
|--------------------|-----------------------------------|-----------|-----------|-----------|
| Net weight         | 100 g                             | 500 g     | 1000 g    | 3000 g    |
| Coil size (D x H)  | -                                 | 200x65 mm | 200x65 mm | 300x95 mm |
| Coil core diameter | -                                 | 52 mm     | 52 mm     | 52 mm     |
| Length per kg      | 330 m (1,75 mm) / 130 m (2,85 mm) |           |           |           |

\*The performance data shown are the results of laboratory measurements performed by the manufacturer on standard test specimens. The values are for informational purposes only and are intended for design and comparison purposes. The mechanical and functional properties of the actual printed parts are influenced by a number of additional factors, including the 3D printer used, the print settings, the model geometry, and the environmental and operating conditions. The final performance may differ from the reference values provided.

Plastics degrade and lose their properties over time. We recommend using the purchased roll within 12 months of opening the outer packaging. Store the material in a cool, dry, and dark place to maintain its quality. Avoid direct contact with the molten product, as it can cause severe burns—take appropriate safety measures. When the material is heated above its melting point, vapors may be released, so ensure proper ventilation. Avoid overheating the material. The provided information has been compiled to the best of our knowledge and understanding. The technical data are typically based on sample values and are not guaranteed characteristics. They may be subject to change as products are developed.