

Physical properties

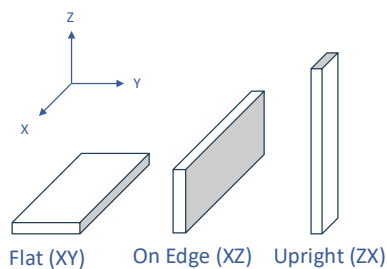
Property	Typical value
Density	1,05 g/cm ³
Diameter	1,75/2,85 mm
Diameter tolerance	± 0,05 mm
Roundness tolerance	± 5 %

Thermal properties

Property	Test method	Typical value
Vicat softening temperature	ISO 75 (0,45 MPa)	93°C

Mechanical properties*

Property	Test method	Typical value		
		Flat (XY)	On Edge (XZ)	Upright (ZX)
Tensile stress	MSZ EN ISO 527	28,4 MPa	31,3 MPa	-
Tensile strength	MSZ EN ISO 527	25,9 MPa	27,2 MPa	-
Elongation at break	MSZ EN ISO 527	3,39 %	3,36 %	-
Modulus of elasticity	MSZ EN ISO 527	1,65 MPa	1,64MPa	-
Flexural modulus	MSZ EN ISO 178	1,94 MPa	1,97 MPa	-
Charpy impact strength (V- notched)	ISO 179/1	11,2 kJ/m ²	20,2 kJ/m ²	-



Recommended printing conditions

Property	Typical value
Printing temperature	240-270°C
Buildplate temperature	100-110°C
Printing speed	40-80 mm/sec

Packaging

Property	Typical value					
Net weight	100 g	425 g	500 g	850 g	1000 g	3000 g
Coil size (D x H)	-	200x65 mm	200x65 mm	200x65 mm	200x65 mm	300x95 mm
Coil core diameter	-	52 mm	52 mm	52 mm	52 mm	52 mm
Length per kg	400 m (1,75 mm) / 147 m (2,85 mm)					

*The test samples were produced on a Makerbot Method X printer, the results may vary depending on the type of printer and the printing parameters used.

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.