

PHYSICAL PROPERTIES	AVERAGE VALUES	UNITS	STANDARDS
DENSITY	1,24	g/cm <sup>3</sup>	
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 <sup>2</sup>	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  
1Kg

DIAMETER  
1,75mm / 2,85mm

COLOR  
Various

PACKAGING  
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