

PEI



Color : nativ (orange)

PROPERTIES

Physical

Density	1.27	ISO 1183
Mold shrinkage on tensile bar, flow	0.5 – 0.7 %	Provider method
Water absorption	1.25 % (23°C/sat)	ISO 62
Moisture absorption	0.7 % (23°C/50% RH)	ISO 62
Melt volume rate	13 cm ³ /10min MVR @ 340°C/5.0 kg	ISO 1133

Thermal

Thermal conductivity	0.21 W/m·°C	ISO 8302
CTE, 23°C to 150°C, flow	5.10 ⁻⁰⁵ 1/°C	ISO 11359-2
CTE, 23°C to 150°C, xflow	5.E-05 1/°C	ISO 11359-2
Ball Pressure Test, 125°C +/- 2°C	PASSES -	IEC 60695-10-2
Vicat Softening Temp, Rate A/50	215 °C	ISO 306
Vicat Softening Temp, Rate B/50	211 °C	ISO 306
Vicat Softening Temp, Rate B/120	212 °C	ISO 306
HDT/Be, 0.45MPa Edgew	200 °C	ISO 75/Be
120*10*4 sp=100mm		

Mecanical

Taber abrasion, CS-17, 1kg	10 mg/1000c	Provider method
Tensile stress, yield, 50 mm/min	105 MPa	ISO 527
Tensile stress, break 50mm/min	85 MPa	ISO 527
Tensile Strain, yield 50 mm/min	6 %	ISO 527
Tensile strain, break, 50 mm/min	60 %	ISO 527
Tensile modulus, 1 mm/min	3200 MPa	ISO 527
Flexural stress, yield, 2 mm/min	160 MPa	ISO 178
Flexural modulus, 2 mm/min	3300 MPa	ISO 178
Hardness, H358/30	140 MPa	ISO 2039-1

Electrical

Volume Resistivity	1.E+15Ohm·cm	IEC 60093
Surface Resistivity, ROA	>1.E+15 Ohm	IEC 60093
Dielectric Strength, in oil, 0.8 mm	33 kV/mm	IEC 60243-1
Dielectric Strength, in oil, 1.6 mm	25 kV/mm	IEC 60243-1
Dielectric Strength, in oil, 3.2 mm	16 kV/mm	IEC 60243-1
Relative Permittivity, 1 MHz	2.9	IEC 60250
Dissipation Factor, 50/60 Hz	0.0005	IEC 60250
Dissipation Factor, 1 MHz	0.0006	IEC 60250
Dissipation Factor, 2450 MHz	0.0025	IEC 60250
Comparative Tracking Index	150 V	IEC 60112
Comparative Tracking Index, M	100 V	IEC 60112
Relative Permittivity, 50/60 Hz	2.9	IEC 60250

Impact

Izod impact, notched 80*10*4+23°C	5 kJ/m ²	ISO 180/1A
Izod impact, notched 80*10*4-30°C	5 kJ/m ²	ISO 180/1A

Flame characteristics

UL Recognized, 94V-0 flame class rating	1.5 mm	UL 94
UL recognized, 94-5VA rating	3 mm	UL 94
Glow wire flammability index	3.2 mm	IEC 60695-2-12
960°C, passes at		
oxygen index	47 %	ISO 4589

PRINTING RECOMMANDATIONS

3D printing

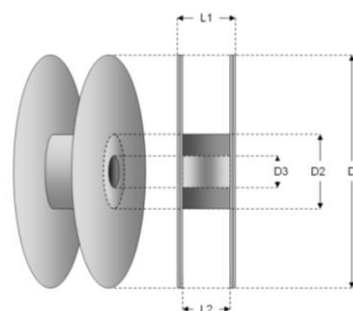
Extrusion Temp.*	370°C to 400°C
Plate Temp. *	150°C
Speed	40 – 100 mm/s

* The above values are typical properties only and should not be considered as a specification. Values can vary regarding printers and specific printing parameters. User should confirm results by their own tests.

HEALTH & SAFETY

Material not hazardous for health in itself. However, as dust, in case of peeling or sanding, dust may cause skin, eyes and respiratory tract irritation. Users must wear individual protection equipment (mask, gloves...) in case of sanding or milling the printed pieces. Consult MSDS for more data. Always refers to MSDS prior handling.

PACKAGING



Spools	L1	L2	D1	D2	D3
500 g	55	45	200	105	52
1.0 kg	67	59	200	105	52
2.5 kg	100	90	300	210	52

in mm

Spools packed in individual boxes, under vacuum with desiccant. Product supplied with batch number and material traceability. Other spools are available on request (up to 25 kg).

CONTACT

