



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	220-230	internal
plate temp	C°	90-110	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-20	internal
print speed	mm/l°	30-50	internal
PROPERTY			
Physical			
Specific gravity	g/cm <sup>3</sup>	1.17	ASTM D792
Water absorption	%	0.4	ASTM D570
Mechanical at 23°C / 50% rh			
Flexural modulus	GPa	2.3	ASTM D790
IZOD impact	J/cm	3.2	ASTM D256
Tensile strength at break	MPa	51	ASTM D638
Thermal			
Heat deflection	°C	77	ASTM D648

### Disclaimer

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### ADDITIONAL INFORMATIONS

In general filaments made with HIRMA (PMMA) can be processed on conventional 3D printer using FDM / FFF technology.

HIRMA (PMMA) is a dedicated polymethyl methacrylate developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 3 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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