



## TECHNICAL DATA SHEET

		Standard	Unit	Typical Value
<b>MECHANICAL PROPERTIES</b>	Tensile Strength. Break	ISO 527	MPa	9,56
	Tensile Modulus	ISO 527	MPa	641
	Tensile Elongation. Break	ISO 527	%	7,4
	Flexural Strength	ISO 178	MPa	16.9
	Flexural Modulus	ISO 178	MPa	826
<b>ELECTRICAL PROPERTIES</b>	Volume Resistivity	Probe 10x4x25,9	$\Omega$ cm	27,44

## PROCCESING PARAMETERS

<b>NOZZLE DIAMETER</b>	0.4 mm
<b>PRINTING TEMPERATURE</b>	250° C/260° C
<b>TABLE TEMPERATURE</b>	No
<b>CHAMBER TEMPERATURE</b>	No
<b>PRINTING SPEED</b>	40 mm/s
<b>FILLING SPEED</b>	40 mm/s
<b>MATERIAL FLOW</b>	100%
<b>FILL DENSITY</b>	100%
<b>LAYER HEIGHT/QUALITY</b>	0.2 mm
<b>ADHESIVE/ADHESIVE TYPE</b>	SKIRT

### OBSERVATIONS

The filament prints correctly with the parameters specified in the manufacturing data table.

A better finish and a more even print is noticeable when increasing the temperature from 250 to 260°C.

As a printing trick, due to the high adhesion of the material, and to facilitate the separation of the part from the manufacturing table, we perform a live calibration on the initial layer, in order to separate as much as possible, the 1st layer of the part from the printing table (without affecting the printing quality).

We manage to facilitate the separation of the part to a certain extent, although the high adhesion of the material continues to make separation difficult, making the use of high adhesion foil the best option.

### DISCLAIMER

The technical data contained on this data sheet should not be used to establish specifications of the final product. The data provided is not intended to substitute any testing that may be required to determine fitness for any specific use. [www.aimplas.net](http://www.aimplas.net)