

### **SECTION 1 - TYPICAL MATERIAL PROPERTIES**

Physical Properties	Unit	Value
Density	g/cc	1.80
Humidity Absorption	%	No information available
Tensile Strength	MPa	No information available
Tensile Elongation	%	No information available
Flexural Strength	MPa	No information available
Flexural Modulus	GPa	No information available
Izod Impact Strength	kJ/m <sup>2</sup>	No information available

### **SECTION 2 - FILAMENT SPECIFICATION**

Nominal Diameter	Diameter Tolerance	Ovality
1.75mm	± 0.05	≥ 95%
2.85mm	± 0.05	≥ 95%
Net Filament Weight	Ceramic Content	
1000/500/250 grams	60%	

### **SECTION 3 - GUIDELINE FOR PRINT SETTINGS**

Advised Printing Temperature	205-235°C
Advised Build Plate Temperature	40-50°C
Build Plate Surface Type	Blue Painter's Tape/Glass
Print Cooling	None
Advised Printing Speed	30mm/sec (1800mm/min)
Nozzle Size/Type	0.6mm/Stainless Steel or harder

### **SECTION 4 - ADDITIONAL INFORMATION**

**Firing/Sintering Temperature:** 1360-1500°C

This filament is abrasive and will wear standard brass nozzles fast. The Virtual Foundry, Inc recommends a stainless steel or hardened steel nozzle.

**DISCLAIMER:** The product- and technical information provided in this datasheet is correct to the best of The Virtual Foundry, Inc's knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.