

General information

Diameter	1.75 mm
Net filament weight	1 kg
Spool weight	164 g
Spool size	200 mm (OD) x 67 mm (W)
Spool material	Polycarbonate (drying up to 120°C)

Recommended printing settings

Drying before printing	8 h @ 90°C
Nozzle Temperature	270 - 290 °C
Bed Temperature	80 - 110 °C
Chamber Temperature	40 - 80 °C
Annealing after printing	4h @ 140°C

Annealing is optional. It will increase the heat resistance, but material has very significantly higher HDT without annealing than ABS/ASA.

Physical and thermal properties

	Testing standard	Typical value
Density	ISO 1183	1.38 g/cm ³
Heat Deflection Temperature	ISO 75 - 0.45 MPa	180 °C
Heat Deflection Temperature	ISO 75 – 1.8 MPa	120 °C

Mechanical properties

	Testing standard	Typical value
Tensile strength	ISO 527	118 MPa
Elongation at break	ISO 527	3 %
Young's modulus	ISO 527	7.1 GPa

The physical and mechanical properties were obtained with injection molded test tokens.

Disclaimer: The technical data provided in this datasheet is furnished without charge or obligation and accepted at the recipient's sole risk. This data should not be used to establish specifications limits or used alone as the basis of design. The data provided is not intended to substitute any testing that may be required to determine fitness for any specific use.