

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	10 h @ 80°C
Nozzle Temperature	300 - 340 °C
Bed Temperature	100 - 120 °C
Chamber Temperature	40 - 80 °C
Annealing after printing	8-10h @ 150°C

Physical and thermal properties

	Testing standard	Typical value
Density	ISO 1183	1.31 g/cm ³
Heat Deflection Temperature	ISO 75 - 0.45 MPa	258 °C (annealed)
Continuous Use Temperature	IEC 60216	220 °C

Mechanical properties

	Testing standard	Typical value
Tensile strength (X-Y)	ISO 527	95 MPa
Elongation at break (X-Y)	ISO 527	1.4 %
Young's modulus (X-Y)	ISO 527	8.1 GPa
Impact Strength (X-Y)	ISO 179	28 kJ/m ² (unnotched)

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