

Physical properties

Property	Typical value
Density	1,22 g/cm ³
Diameter	1,75/2,85 mm
Diameter tolerance	± 0,05 mm
Roundness tolerance	± 5 %

Thermal properties

Property	Test method	Typical value
Vicat softening temperature	ASTM E2092 (0,45 MPa)	75-100°C

Mechanical properties

Property	Test method	Typical value
Tensile stress	ASTM D 638	2450 MPa
Tensile strength	ASTM D 638	32 MPa
Elongation at break	ASTM D 638	100 %

Recommended printing conditions

Property	Typical value
Printing temperature	195-225°C
Buildplate temperature	50-70°C
Printing speed	50 mm/sec
Heat treatment (100% infill)	110°C – 15 min

Packaging

Property	Typical value
Coil size (D x H)	200x65 mm
Net weight	1000 g
Length per kg	330 m (1,75 mm) / 130 m (2,85 mm)
Coil core diameter	52 mm

Plastics degrade and lose their properties over time. We recommend using the purchased roll within 12 months of opening the outer packaging. Store the material in a cool, dry, and dark place to maintain its quality. Avoid direct contact with the molten product, as it can cause severe burns—take appropriate safety measures. When the material is heated above its melting point, vapors may be released, so ensure proper ventilation. Avoid overheating the material. The provided information has been compiled to the best of our knowledge and understanding. The technical data are typically based on sample values and are not guaranteed characteristics. They may be subject to change as products are developed.