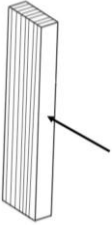
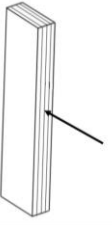




Authorized PANTONE Partner

TDS Rev. 2.0
Update: 20.03.2019

| IMPACT TEST IZOD – STANDARD ISO 180 | | | | | | |
|---|--|-------|-------|--|-------|-------|
| Test specimens printed on Ultimaker 2+ with the following setup: <ul style="list-style-type: none"> - Nozzle type: standard brass - Nozzle Temperature: 210 °C - Heat bed Temp: 35 °C - Print speed: 50 mm/s - Infill orientation: 45° | zy- normal  | | | xy- parallel  | | |
| | 15% | 50% | 100% | 15% | 50% | 100% |
| Impact strength (KJ/m ²) | 10,85 | 11,81 | 15,27 | 11,03 | 11,34 | 17,91 |
| Impact Energy (J) | 0,43 | 0,47 | 0,61 | 0,44 | 0,45 | 0,72 |

| THERMAL PROPERTIES | VALUE | STANDARD |
|------------------------------|--------------|------------|
| Melting point | 145 – 160 °C | ASTM D3418 |
| Glass Transition Temperature | 60 °C | ASTM D3418 |

| FILAMENT SPECIFICATIONS AND PRINT SETTINGS | |
|--|----------------------------|
| Diameter 1.75mm | 1.75 ± 0.05 mm |
| Diameter 2.85mm | 2.85 ± 0.05 mm |
| Roundness deviation | max 2% |
| Suggested Print Temperature | 200 – 215 °C |
| Suggested Print Speed | 40 – 85 mm/s |
| Suggested Bed Temperature | 30 – 50 °C (not necessary) |
| Cooling fan | 100% |