



## FILAMENT DATASHEET

MATERIAL: Monumental, Clay, Sandy, Darkstone, Caementum, Heritage Brick.

### WE CARE ABOUT YOUR PRINTS

Suggested printing specs.	Value	Unit	Standard
Extruder Temperature	230° +/-10°	°C	Internal
Bed Temperature	100° +/-10°	°C	Internal
Print speed	60-70	mm/s	Internal
Fan	0-20	%	Internal
Minimum Nozzle Diameter	0,35	mm	Internal
Material Properties	Value	Unit	Standard
Water Absorption	0,2	%	ISO 179
Tensile Modulus	2500	Pa	ISO 527
Vicat Softening Temperature	102°	°C	ISO 96
Charpy Impact at 23°C	8	ft·lb/in <sup>2</sup>	ISO 179
Charpy Impact at -30°C	3	ft·lb/in <sup>2</sup>	ISO 179
MFR	4	g/10 min	ISO 1133

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