



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	320-340	internal
plate temp	C°	100	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0	internal
print speed	mm/l°	35	internal
PROPERTY			
Physical			
Specific gravity	g/cm ³	1,45	ISO 1183-3
Water absorption	%	<0,05	ISO 62
Flammability behaviour	-	V-0	UL 94
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	75	ISO 527
Elongation at maximum force	%	2,9	ISO 527
Modulus of elasticity	GPa	4	ISO 527
Flexural strength	MPa	95	ISO 178
Flexural elongation at max force	%	2,8	ISO 178
Flexural modulus	GPa	3	ISO 178
Charpy impact strength	kJ/m ²	20	ISO 179 1eU
Thermal			
Continuous service temp.	°C	220	IEC 60216
Service temp.	°C	240	during lifetime
Electrical			
Insulation resistance strip electrode	Ω	≤10 ⁹	DIN/IEC 60167
Surface resistance	Ω	≤10 ⁹	DIN IEC 60093

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with PPS Natural can be processed on conventional 3D printer using FDM / FFF technology.

PPS Natural is a polyphenylene developed for 3D printing and to obtain best results we recommend pre drying the filaments at 100°/140° for 2-4 h or at 50°/90° for >4 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 230°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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