



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	390°-420°	internal
plate temp	C°	90°	internal
min. nozzle diameter (2)	mm.	0.5	internal
fan	%	0	internal
print speed	mm/l°	40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.52	ISO 1183-3
Water absorption	%	<0,1	ISO 62
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	140	ISO 527
Elongation at maximum force	%	2,5	ISO 527
Modulus of elasticity	GPa	10	ISO 527
Flexural strength	MPa	205	ISO 178
Flexural elongation at max. forse	%	3	ISO 178
Flexural modulud	GPa	8	ISO 178
Charpy impact strength	kJ / m <sup>2</sup>	40	ISO 179 1eU
Charpy impact strength, notched	kJ / m <sup>2</sup>	7	ISO 179 1eA
Thermal			
Heat distortion temp.	°C	315	ISO 75
Continuous service temp.	°C	250	IEC 60216
Service temp.	°C	280	lifetime max. 200h
Electrical			
Insulation resistance strip electrode	Ω	≤10 <sup>12</sup>	DIN/IEC 60167
Surface Resistance	Ω	<10 <sup>12</sup>	DIN IEC 60093

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### ADDITIONAL INFORMATIONS

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

PEEK Glass is a special formula glass sphere reinforced developed for 3D printing and to obtain best results we recommend pre dry-dehumidifier the filaments at 120° for 6-8 h or at 150° for 3-6 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 360°, 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 .

(2) 0.5 mm is the minimum diameter of the nozzle with glass spheres reinforced.  
Glass spheres are abrasive, we suggest to use a nozzle in hardened or tempered metal, like Widia, or wear resistance internal surface, like ceramics or other.  
**NO tefloned surface!**

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