

- High temperature resistant (180°C melting point after annealing)
- Impact resistant
- Flame resistant
- Ideal for tooling, prototyping

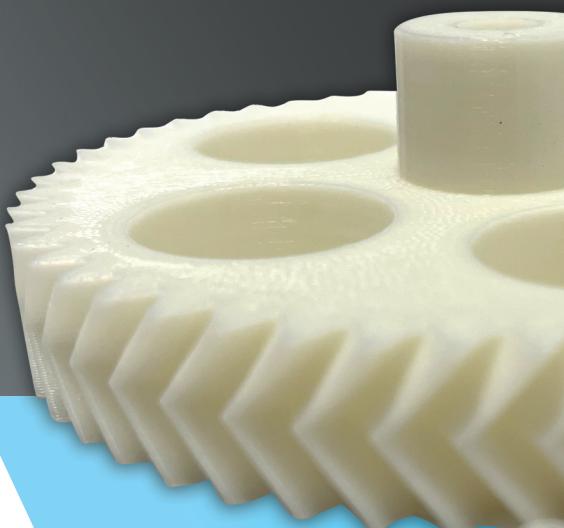
Thermal Properties		Units	Test Method
Melt Mass-Flow Rate	13 ± 2	g/10min	ISO 1133
Heat Deflection (HDT) at 0.455 MPa	57 ± 2	°C	ISO 75
Heat Deflection (HDT) at 1.820 MPa	54 ± 3	°C	ISO 75
Glass Transition, 1Hz	66 – 67	°C	ISO 6721
Coefficient of Thermal Expansion	8 x 10 <sup>-5</sup>	m/m°C	-
Melting Temperature <sup>[a]</sup>	175 – 185	°C	ISO 11357
VICAT Softening Temperature	57 ± 2	°C	ISO 306

**EXTRUDER TEMP**  
**200-225°C**

**BED TEMP**  
**20-60°C**

Mechanical Properties		Units	Test Method
Tensile Modulus	2400 ± 40	MPa	ISO 527-1
Tensile Stress at Yield	35.2 ± 0.8	MPa	ISO 527-1
Tensile Stress at Break	30.0 ± 3.0	MPa	ISO 527-1
Elongation at yield	2.0 ± 0.0	%	ISO 527-1
Elongation at break	6.0 ± 2.0	%	ISO 527-1
Flexural Strength	68 ± 5	MPa	ISO 178
Flexural Modulus	2120 ± 480	MPa	ISO 178
Izod Impact Strength, notched	10 ± 3	kJ/m <sup>2</sup>	ISO 180

<sup>[a]</sup>Property measured using the filament. All remaining properties are measured using 3D test specimens.



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