



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	310-340	internal
plate temp	C°	90-100	internal
min. nozzle diameter	mm.	0,4	internal
fan	%	0-05	internal
print speed	mm/1°	30-40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.65	ISO 1183
Mechanical / dry			
Tensile strength	MPa	126	ISO 527
Elongation at maximum force	%	1,4	ISO 527
Modulus of elasticity	GPa	11	ISO 527
Charpy impact strength	kJ/m ²	30	ISO 179
Thermal			
Continuos service temperature	°C	220	IEC 60216
Service temp. Max 200h	°C	240	ISO 3167
Electrical properties			
Insulation reistence strip electroode	Ohm	>10-9	ISO 3167

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with PPSGF can be processed on conventional 3D printer using FDM / FFF technology.

PPSGF is a special PPS added 25% glass fiber developed for 3D printing and to obtain best results we recommend pre-drying the filaments at 100° for 3h. 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 280°, 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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