

Properties ^[1]	Test Standard	Test Condition	S.I. Unit	S.I. Typical Value ^[2]	
				Printing	Injection Moulding
Physical Properties					
Density	ISO 1183	23°C	g/cm ³	1.25	
Glass transition Temperature	ISO 11357	10°C/min	°C	60	
Melt Index	ISO 1133	190°C,2.16kg	g/10min	7.0	
Mechanical Properties					
Tensile strength	ISO 527	50mm/min	MPa	40.5	55.3
Elongation at break	ISO 527	50mm/min	%	3.2	25.5
Bending Strength	ISO 178	2m/min	MPa	72.5	85.5
Bending modulus	ISO 178	2m/min	MPa	2650	2865
Izod Impact, Notched	ISO 180	23°C	KJ/m ²	3.5	5.6
Thermal Properties					
Heat distortion temperature	ISO 75	0.45MPa	°C	53	
Flammability	UL94	1.6mm	Class	HB	

[1] These are typical values of the product's properties, and these values alone do not represent a sufficient basis for any part design and are not intended for use in establishing maximum, minimum, or ranges of values for specification purposes.

[2] The listed values are maybe different for pigmented material. **Printing conditions:** Printing temperature=210°C, printing speed=80mm/s, number of shells=2, Nozzle size=0.4mm, and 100% infill. **Injection moulding processing conditions:** Temperature:190°C;Back pressure:0-1MPa; mould temperature: 30-40°C.

Typical Conditions of Printing

Printing Recommendation	Typical Range
Extruder Temperature	190-230°C
Printing Speed	30-100mm/s
Bed Temperature	Room temprature-40°C
Layer Height	0.1-0.4mm
Infill	As needed up to 100%
Matters need attention	General print

The parameter is just for referential purpose only. In actual processing, the parameter should be adjusted by construction of 3D machine, shape and size of product, and so on.