

SECTION 1 - TYPICAL MATERIAL PROPERTIES

| Physical Properties | Unit | Value |
|----------------------------|-------------------|--------------------------|
| Density | g/cc | 1.50 - 1.54 |
| Humidity Absorption | % | No information available |
| Tensile Strength | MPa | No information available |
| Tensile Elongation | % | No information available |
| Flexural Strength | MPa | No information available |
| Flexural Modulus | GPa | No information available |
| Izod Impact Strength | kJ/m ² | No information available |

SECTION 2 - FILAMENT SPECIFICATION

| Nominal Diameter | Diameter Tolerance | Ovality |
|-------------------------|---------------------------|----------------|
| 1.75mm | ± 0.05 | ≥ 95% |
| 2.85mm | ± 0.05 | ≥ 95% |

| Net Filament Weight | Metal Content |
|----------------------------|----------------------|
| 500/250 grams | 60% - 65% |

SECTION 3 - GUIDELINE FOR PRINT SETTINGS

| | |
|---------------------------------|---|
| Advised Printing Temperature | 205-235°C |
| Advised Build Plate Temperature | 40-50°C |
| Build Plate Surface Type | Glass//PEI/Fiberglass/Spring Steel |
| Build Plate Preparation | Glue Stick (on glass) Blue Painter's Tape (on PEI/Fiberglass) - Nothing needed for Powder Coated Spring Steel |
| Print Cooling | None |
| Advised Printing Speed | 60mm/sec (3600mm/min) |
| Nooze Size/Type | 0.6mm/Stainless Steel or harder |

SECTION 4 - ADDITIONAL INFORMATION

Sintering Temperature: 555°C (1031°F)

This filament is abrasive and will wear standard brass nozzles fast. The Virtual Foundry, Inc recommends a stainless steel or hardened steel nozzle. A Filawarmer is not required for this filament.

DISCLAIMER: The product and technical information provided in this datasheet is correct to the best of The Virtual Foundry, Inc's knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.