



TDS Rev 3.0

**Technical Data Sheet: Ultem® 9085 3D Printing Filament**

Physical Properties	Standard	Unit	Metric
Density	ISO 1183	g/cc	1.34

Mechanical Properties	Standard	Unit	Metric
Tensile Strength	ISO 527	MPa	54
Tensile Modulus	ISO 527	MPa	2050
Tensile Elongation	ISO 527	%	3
Flexural Strength	ISO 178	MPa	90
Flexural Modulus	ISO 178	MPa	2170

Thermal Properties	Standard	Unit	Metric
Glass Transition Temperature (Tg)	DSC	°C	186
Deflection Temperature at 0.45 MPa (66psi)	ISO 75	°C	158

Fire Testing*	Standard	Unit	Typical Value
Flamability Rating (*Base Resin)	UL 94	-	V-0 @1.5mm

Printed Specimen Conditions
Printer: Open Source FDM/FFF
Nozzle: 0.4mm
Layer Height: 0.25mm
Infill: 100%, +/- 45°
Extrusion Temp: 365-385°C
Bed Temp: 130-140°C
Specimen Orientation: XY Flat

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