



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	260-275	internal
plate temp	°C	80	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-80	internal
print speed	mm/l°	40/60	internal
PROPERTY			
Physical			
Density (23 °C, method A)	g/cm ³	0.89	ISO 1133-1
Mechanical at 23°C / 50% rh			
Flexural modulus	MPa	950	ISO 178
Tensile stress at break	MPa	15	ISO 527-1, -2
Tensile stress at yield	MPa	17	ISO 527-1, -2
Tensile strain at break	%	500	ISO 527-1, -2
Tensile strain at yield	%	6	ISO 527-1, -2
Thermal			
Vicat softening temp. (A50)	°C	135	ISO 306
Heat deflection temp B (0.45 MPa, unannealed)	°C	80	ISO 75B-1, -2
DSC melting point	°C	163	ISO 11357-3
Impact			
Charpy impact strength - notched (23 °C)	kJ/m ²	65	ISO 179
Charpy impact strength - notched (-20 °C)	kJ/m ²	15	ISO 179
Charpy impact strength - notched (-30 °C)	kJ/m ²	10	ISO 179

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with PLENE 5 can be processed on conventional 3D printer using FDM / FFF technology.

(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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