



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	240-270	internal
plate temp	°C	60-80	internal
min. nozzle diameter (2)	mm.	0.5	internal
fan	%	0	internal
print speed	mm/l°	35	internal
PROPERTY			
Physical			
Specific gravity	g/cm <sup>3</sup>	1,13	ISO 1183-3
Water absorption	%	<0,3	ISO 62
Melt flow rates (MFR)	g/10 min	2,2	ISO 1133
Melt volume rate (MVR)	cm <sup>3</sup> /10 min	2,2	ISO 1133
Linear mould shrinkage	%	0,3-0,5	DIN 16742
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	87	ISO 527
Elongation at maximum force	%	2,7	ISO 527
Modulus of elasticity	GPa	4,2	ISO 527
Charpy impact strength	kJ / m <sup>2</sup>	26	ISO 179 1eU
Thermal			
Heat distortion temp.	°C	90	ISO 75
Continuous service temp.	°C	120	IEC 60216
Service temp.	°C	160	lifetime max. 200h
Electrical			
Insulation resistance strip electrode	Ω	≤10 <sup>12</sup>	DIN/IEC 60167
Surface resistance	Ω	<10 <sup>12</sup>	DIN IEC 60093

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### ADDITIONAL INFORMATIONS

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

PAHP Glass is a special polyamide glass sphere reinforced developed for 3D printing and to obtain best results we recommend pre drying the filaments at 120° for 4-6 h. 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 210°, 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 .

(2) 0.5 mm is the minimum diameter of the nozzle with glass spheres reinforced. Glass spheres are abrasive, we suggest to use a nozzle in hardened or tempered metal, like Widia, or wear resistance internal surface, like ceramics or other.  
NO tefloned surface!

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