



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	390°-420°	internal
plate temp	C°	90°	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0	internal
print speed	mm/l°	40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1,31	ISO 1183-3
Water absorption	%	<0,1	ISO 62
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	97	ISO 527
Elongation at maximum force	%	5	ISO 527
Modulus of elasticity	GPa	3,8	ISO 527
Flexural strength	MPa	145	ISO 178
Flexural elongation at max. force	%	7	ISO 178
Flexural modulud	GPa	3,4	ISO 178
Charpy impact strength	kJ / m ²	185	ISO 179 1eU
Charpy impact strength, notched	kJ / m ²	7	ISO 179 1eA
Thermal			
Heat distortion temp.	°C	145	ISO 75
Service temp.	°C	260	lifetime max. 200h
Electrical			
Insulation resistance strip electrode	Ω	≤10 ¹²	DIN/IEC 60167
Surface Resistance	Ω	<10 ¹²	DIN IEC 60093

Disclaimer

The above information is provide in good fact .Treedfilaments is not responsible for any processing which may occur to product finished articles , packaging materials and other .

Further Treedfilaments makes no warranty or representation of any kind regarding the information given or the product described and expressly disclaims all implied warranties , representations and conditions , including without limitation all warranties and conditions of quality , merchantability and suitability or fitness for particular purpose .



ADDITIONAL INFORMATIONS

In general filaments made with PEEK Natural can be processed on conventional 3D printer using FDM / FFF technology.

PEEK Natural is a special formula developed for 3D printing and to obtain best results we recommend pre dry-dehumidifier the filaments at 120° for 6-8 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 360°, 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 .

Disclaimer

The above information is provide in good fact .Treedfilaments is not responsible for any processing which may occur to product finished articles , packaging materials and other .

Further Treedfilaments makes no warranty or representation of any kind regarding the information given or the product described and expressly disclaims all implied warranties , representations and conditions , including without limitation all warranties and conditions of quality , merchantability and suitability or fitness for particular purpose .