



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	235-255	internal
plate temp	C°	80-100	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	50-100	internal
print speed	mm/l°	40-60	internal
PROPERTY			
Physical			
Density (method A)	g/cm ³	0.9	ISO 1183
Optical			
Haze (50 µm)	%	0.6	ASTM D 1003
Loss (45°, 50 µm)	-	88	ASTM D 2457
Thermal			
Vicat softening temp. (A50)	°C	107	ISO 306
Heat deflection temp B (0.45 MPa, unannealed)	°C	62	ISO 75B-1, -2
Melting temp.	°C	132	ISO 11357-3
Film			
Seal initiation temperature	%	105	-

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with PLENE 4 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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