



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	255-265	internal
plate temp	C°	70	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-50	internal
print speed	mm/l°	35-50	internal
PROPERTY			
Physical			
Density	g/cm ³	1.02	ISO 1183
Molding shrinkage	%	0.9 to 1.2	-
Mechanical at 23°C / 50% rh			
Tensile modulus	MPa	1950	ISO 527-2/1
Tensile stress (yield)	MPa	20.0	ISO 527-2/50
Tensile strain (break)	%	70	ISO 527-2/50
Flexural modulus ^{2,3}	MPa	1850	ISO 178
Thermal			
Vicat softening temp.	°C	135	ISO 306/A120
Heat deflection temp B (0.45 MPa, unannealed)	°C	110	ISO 75-2/B
Heat deflection temp B (1.8 MPa, unannealed)	°C	58	ISO 75-2/A
CLTE - flow	cm/cm/°C	8.5E-5	ASTM D696
Impact			
Notched izou impact strength 0°C	kJ/m ²	8	ISO 180/1A
Notched izou impact strength 23°C	kJ/m ²	15	ISO 180/1A
Multi-axial instrumented impact energy	J	70	ISO 6603-2

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ADDITIONAL INFORMATIONS

In general filaments made with PLENET15 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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