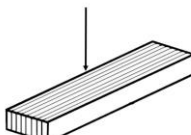
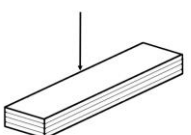
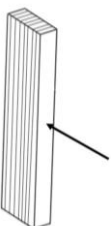
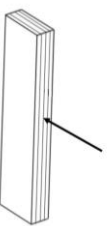


FLEXURAL TEST – STANDARD ISO 178				
Test specimens printed on Ultimaker 2+ with the following setup: <ul style="list-style-type: none"> - Nozzle type: Olsson Ruby - Nozzle Temperature: 260 °C - Heat bed Temp: 70 °C - Print speed: 40 mm/s - Infill orientation: 45 °C 	zy- parallel		xy- normal	
				
Infill	50%	100%	50%	100%
Flexural strength (Mpa)	107,7	125,0	81,0	110,3
Flexural Modulus (Mpa)	2616	3131	1969	2820
Deformation (%)	6,0	5,9	6,2	6,2

IMPACT TEST IZOD – STANDARD ISO 180				
Test specimens printed on Ultimaker 2+ with the following setup: <ul style="list-style-type: none"> - Nozzle type: Olsson Ruby - Nozzle Temperature: 260 °C - Heat bed Temp: 70 °C - Print speed: 40 mm/s - Infill orientation: 45 °C 	zy- normal		xy- parallel	
				
Infill	50%	100%	50%	100%
Impact strength (KJ/m²)	46,5	53,6	32,9	52,8
Impact Energy (J)	1,86	2,15	1,31	2,11

THERMAL PROPERTIES	VALUE		STANDARD
Melting Point	180°C		ISO 11357
Heat Deflection Temp.	160°C		ISO 75
Max Usage Temperature	Long Term	90 – 120°C	ISO 2578
Max Usage Temperature	Short Term	150°C	ISO 2578

OTHER PROPERTIES	VALUE	STANDARD
Dielectric Strength	35 kV/mm	IEC 60243-1
Flammability	HB	ISO 1210

FILAMENT SPECIFICATIONS AND PRINT SETTINGS	
Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Roundness deviation	max 2%
Suggested Print Temperature	250 – 265 °C
Suggested Print Speed	40 mm/s
Suggested Bed Temperature	60 – 70°C
Cooling fan	20-60%