

FIL-A-GEHR PPA®

Filaments for professional 3D printing

Technical Data

Melt volume rate (MVR) <i>ISO 1133 275 °C / 5 kg</i>	12 cm ³ / 10 min
Notched Impact Strength (Charpy +23°) <i>ISO 179</i>	8 KJ / m ²
Tensile Stress at Yield <i>ISO 527</i>	85 MPa
Tensile Modulus <i>ISO 527</i>	3000 MPa
Density <i>ISO 1183</i>	1180 kg / m ³
Water absorption <i>similar ISO 62</i>	7 %
Moisture absorption <i>similar ISO 62</i>	2 %
Glass transition temperature <i>ISO 11357</i>	125 °C
Drying	16 - 20 h 80 °C

Data based on raw material



Printing Recommendations

Optimal Nozzle Temperature	260 - 275 °C
Bed Temperature	110 °C
Bedrock	Pertinax plate