

PPS Filament

Technical Data Sheet

Features	Application
• Impact modified • High strength • Heat-resistant • Low water uptake	• Cultural and creative • Toys • Gifts • Industrial

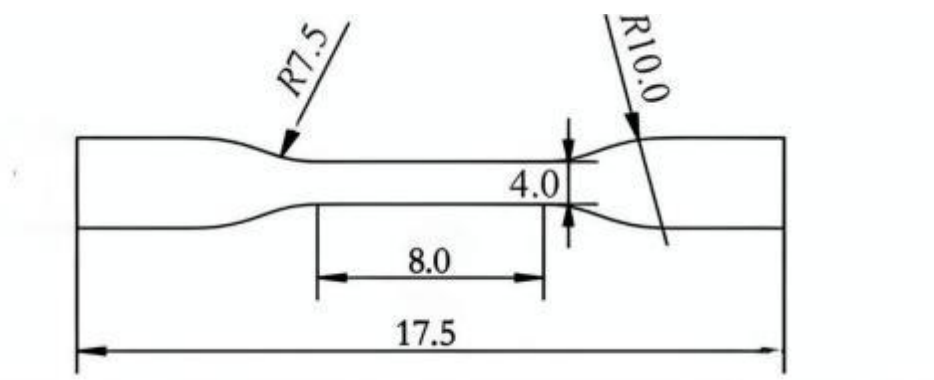
Physical	Typical Value	Unit	Method	Test Condition
Density	1.38	g/cm ³	ISO 1183	23°C
Melt Flow Rate	38	g/10min	ISO 1133	300°C/2.16KG

Mechanical	Typical Value	Unit	Method	Test Condition
Tensile Strength(XY)	57	MPa	ISO 527	50mm/min
Elongation at Break	2.5	%	ISO 527	50mm/min
Flexural Strength(XY)	95	MPa	ISO 178	5mm/min
Flexural Strength(XY)	3185	MPa	ISO 178	5mm/min
Flexural Modulus(Z)	27	MPa	ISO 178	5mm/min
Flexural Modulus(Z)	2210	MPa	ISO 178	5mm/min
Unnotched Izod Impact Strength(XY)	25	KJ/m ²	ISO 180	23°C
Unnotched Izod Impact Strength(Z)	3	KJ/m ²	ISO 180	23°C

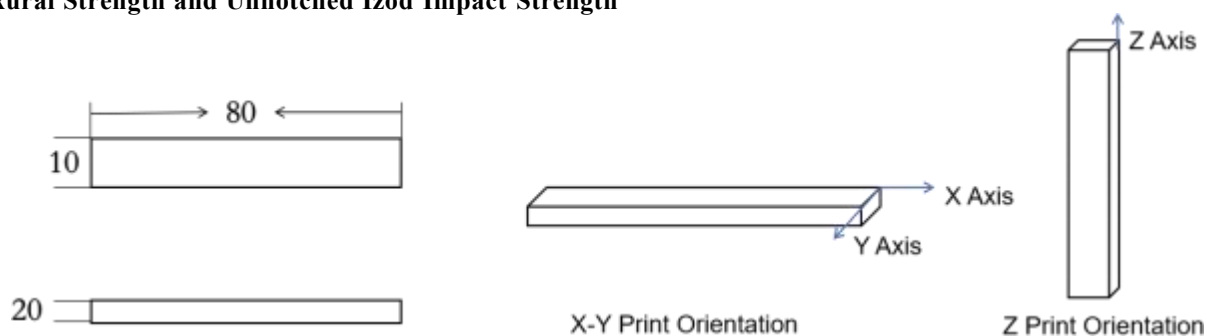
Thermal	Typical Value	Unit	Method	Test Condition
Melting Temperature	300	°C	DSC	10°C/min
Heat Deflection Temperature	110	°C	ASTM D648	120°C/h, 0.45 MPa
Printing Temperature	290-330	°C	/	/
Chamber Temperature	70	°C	/	/
Bed Temperature	100-110	°C	/	/

Testing Model and Printing Parameters

1.1 Tensile Strength



1.2 Flexural Strength and Unnotched Izod Impact Strength



1.3 Printing parameters

Printing parameters	Data
Nozzle Printing temperature	300°C
Plate Temperature	100°C
Printing Speed	100 mm/s
Infill Density	100%

Notice The data contained in this document is based on trials carried out by our Research Centers. Properties are dependent upon process conditions and machine used, so these figures are only given for information.