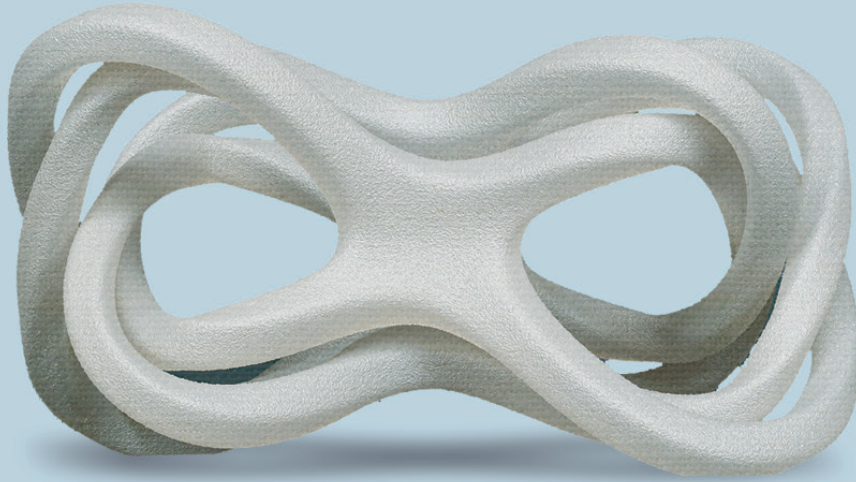




KIMYA PEI-9085 (ULTEM®)



PEI-9085 FILAMENT (ULTEM®) is heat resistant and flame retardant UL94-V0.

| CHEMICAL RESISTANCE | HEAT RESISTANCE
| FLAME RETARDANT: COMPLIANT WITH UL94-V0

FILAMENT PROPERTIES

DESCRIPTION	TEST METHODS	UNITS	VALUES
Diameter	INS-6712	mm	1.75 ± 0.1 2.85 ± 0.1
Density	ISO 1183-1	g/cm ³	1.34
Moisture rate	INS-6711	%	< 1
Glass transition temperature (Tg)	ISO 11357-1	°C	175
Heat distortion temperature (HDT) (1.8 MPa)	ASTM D648	°C	153
Max temperature usage	-	°C	170

PRINT PARAMETERS

PRINTING SPEED	15-30 MM/S
INFILL ANGLE	45°/-45°
EXTRUSION TEMPERATURE	360-400°C
BED TEMPERATURE	140°C

PRINTED SPECIMENS PROPERTIES

	PROPERTIES	TEST METHODS	UNITS	VALUES
MECHANICAL PROPERTIES	Tensile modulus	ASTM D738	MPa	3,440
	Tensile stress at break	ASTM D738	MPa	74
	Strain at yield	ASTM D738	%	7
	Tensile stress at break	ASTM D738	%	72
	Flexural modulus	ASTM 790	MPa	2,920
	Charpy impact resistance	ISO 179/2C	kJ/m ²	11

CERTIFICATION

FLAMMABILITY	UL 94 V0 & FAR 25.853
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