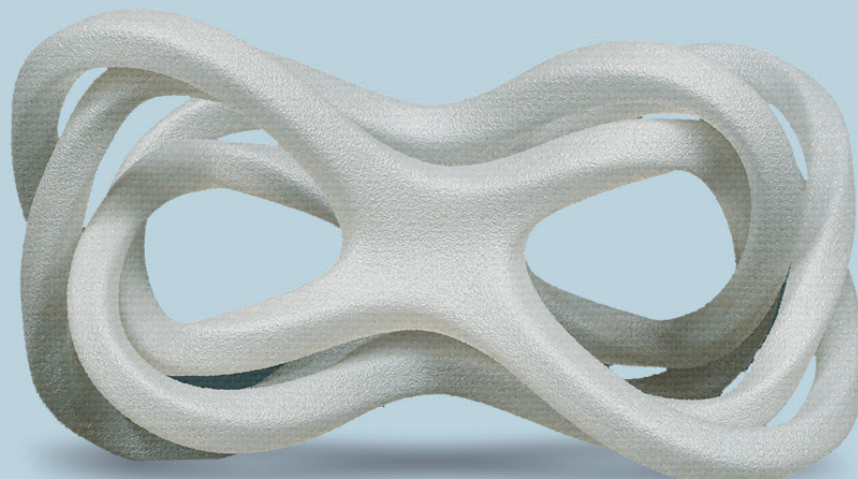




PEI-9085 KIMYA



PEI-9085 FILAMENT is heat resistant and flame retardant UL94-V0

| CHEMICAL RESISTANCE | HEAT RESISTANCE
| FLAME RETARDANT UL94-V0

FILAMENT PROPERTIES

DESCRIPTION	TEST METHODS	UNITS	VALUES
Diameter	INS-6712	mm	1.75 ± 0,1 2.85 ± 0,1
Specific gravity	ISO 1183	g/cm ³	1.34
Moisture rate	INS-6711	%	< 1
Water Absorption (24h)	ISO 62	%	0.39
MVR (@360°C – 5kg)	ISO 1182	cm ³ /10min	65
Glass transition T _g	ASTM E1356	°C	217
HDT (1,8 MPa)	ASTM D648	°C	153
T°C max of use	-	°C	170
Vicat Softening T°C (Rate B/120)	ISO 306	°C	173

PRINT PARAMETERS

PRINT SPEED	20-35 MM/S
EXTRUSION T°	350-380°C
PLATFORM T°	120-160°C

PRINTED SPECIMENS PROPERTIES

	PROPERTIES	TEST METHODS	UNITS	VALUES
FLAME CHARACTERISTICS	FAA Flammability	FAR 25.853	FAR 25.853	<5
	OSU total heat release (2min)	FAR 25.853	kw.min/m2	16
	OSU peak heat release rate (5min)	FAR 25.853	kw/m2	36
	Vertical burn (60s)	FAR 25.853	s	2
TENSILE	Oxygen Index (LOI)	ASTM D2863	%	49
	Tensile modulus	ASTM D738	MPa	3440
	Tensile stress @ yield	ASTM D738	MPa	84
	Tensile stress @ break	ASTM D738	MPa	74
	Elongation @ yield	ASTM D738	%	7
BENDING TEST	Elongation @ break	ASTM D738	%	72
	Flexural modulus	ASTM 790	MPa	2920
IMPACT RESISTANCE	Flexural strength	ASTM 790	MPa	138
	Izod Impact Strength / Notched	ISO 180/1A	kJ/m2	13
	Charpy Impact Strength / Notched	ISO 179/2C	kJ/m2	11

CERTIFICATION

FLAMMABILITY

UL 94 V0 & FAR 25.853