



TDS Rev 4.0

Technical Data Sheet: ThermaX™ PEI [Made using ULTEM™ 1010]

| Physical Properties | Standard | Unit | Metric |
|---------------------|----------|------|--------|
| Density | ISO 1183 | g/cc | 1.27 |

| Mechanical Properties | Standard | Unit | Metric |
|-----------------------|----------|------|--------|
| Tensile Strength | ISO 527 | MPa | 56 |
| Tensile Modulus | ISO 527 | MPa | 2500 |
| Tensile Elongation | ISO 527 | % | 3 |
| Flexural Strength | ISO 178 | MPa | 110 |
| Flexural Modulus | ISO 178 | MPa | 2510 |

| Thermal Properties | Standard | Unit | Metric |
|--|----------|------|--------|
| Glass Transition Temperature (Tg) | DSC | °C | 217 |
| Deflection Temperature at 0.45 MPa (66psi) | ISO 75 | °C | 208 |

| Fire Testing* | Standard | Unit | Typical Value |
|----------------------------------|----------|------|---------------|
| Flamability Rating (*Base Resin) | UL 94 | - | V-0 @1.5mm |

| Printed Specimen Conditions |
|-------------------------------|
| Printer: Open Source FDM/FFF |
| Nozzle: 0.4mm |
| Layer Height: 0.25mm |
| Infill: 100%, +/- 45° |
| Extrusion Temp: 380-400°C |
| Bed Temp: 130-140°C |
| Specimen Orientation: XY Flat |

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