



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	235-250	internal
plate temp	C°	90	internal
min. nozzle diameter	mm.	0,4	internal
fan	%	0	internal
print speed	mm/l°	30-60	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.05	ISO 1183
Mechanical at 23°C / 50% rh			
Tensile modulus	MPa	2200	ISO 527-2
Tensile stress	MPa	47	ISO 527-2/50
Charpy impact (23°C)	kJ/m <sup>2</sup>	no break	ISO 179
Charpy impact (-30°C)	kJ/m <sup>2</sup>	no break	ISO 179
Notched Izod impact strenght 23°	kJ/m <sup>2</sup>	21	ISO 180 / A
Thermal			
H.D.T.	°C	103	ISO 75-2
Vicat softening temp.	°C	104	ISO 306

### Disclaimer

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### ADDITIONAL INFORMATIONS

In General filaments made with T Mat can be processed on conventional 3D printer using FDM / FFF technology.

T Mat is a special ABS alloy developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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