

## TECHNICAL DATE SHEET

BIOFLEX

BASE MATERIAL: Polylactic acid

### PROPERTIES

	PROPERTIES	VALUE	METOD AND CONDICTION
PHYSICAL & MECHANICAL	Density	1,09 g/cm <sup>3</sup>	D792
	Hardness/ Flexure Modulus	27 SHORE D	ASTM D2240
	Tensile strength at break	16 Mpa	ISO D638
	Tensile Modulus	35 Mpa	ASTM D790
	Tensile Elongation	800%	ISO D638
THERMAL	Melting point	185°C	ASTM D3417
	Glass transition temperature	-70°C	/
	Viscat Softening Temperature	/	D3418
	<b>Electrical properties:</b>		
	Volume resistivity	> 10 <sup>13</sup> Ohm.cm at 23°C	ASTM D 257
	Dielectric strength	16 kV/mm at 23°C	ASTM D 149

### SUGGESTED PRINTER SETTING

	VALUE	UNIT
Extruder Temperature	210 – 230	°C
Print Speed	40 – 60	mm/sec
Bed Material	0 – 70	°C

### PRODUCT DETAILS & CERTIFICATION

Diameter	1,75 mm 2,85 mm	Tollerance ± 0,05mm Tollerance ± 0,10mm
REACH compliant		ND
FDA compliant		ND
ROHS certified		ND

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