

# PROfila

## ProFila Filament Datasheet Material: ULTRA X

### PREMIUM FILAMENT

Suggested printing specs.	Value	Unit	Standard
extruder temp	235-250	°C	internal
plate temp	90	°C	internal
min. nozzle diameter	0,4	mm.	internal
fan	0	%	internal
print speed	30-60	mm/1°	internal

Material Properties	Value	Unit	Standard
<b>Physical</b>			
Specific gravity	1.05	g/cm3	ISO 1183
<b>Mechanical at 23°C / 50% rh</b>			
Tensile modulus	2200	MPa	ISO 527-2
Tensile stress	47	MPa	ISO 527-2/50
Charpy impact (23°C)	no break	kJ/m2	ISO 179
Charpy impact (-30°C)	no break	kJ/m2	ISO 179
Notched Izod impact strenght 23°	21	kJ/m2	ISO 180 / A
<b>Thermal</b>			
H.D.T.	103	°C	ISO 75-2
Vicat softening temp.	104	°C	ISO 306

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