

BioCir_{3D}

BioCir is a unique combination of high molecular weight bio-degradable polymers, naturally occurring bio-based constituents and other biodegradable modifiers that enable its functionality as footwear and beyond.

Property	Test Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.16
Hardness	ISO 868	Shore A	84
Biobased content	¹⁴ C	%	50

Print Recommendation (Filaments)

Nozzle Temperature: 195-205°C

Bed Temperature: 70-80 °C

Print speed: 20 mm/s

Cooling Fan: 100 %

Retraction Distance: 0 mm

The removal of the printed parts is best achieved at print bed temperature of approx. 60 °C

Notes

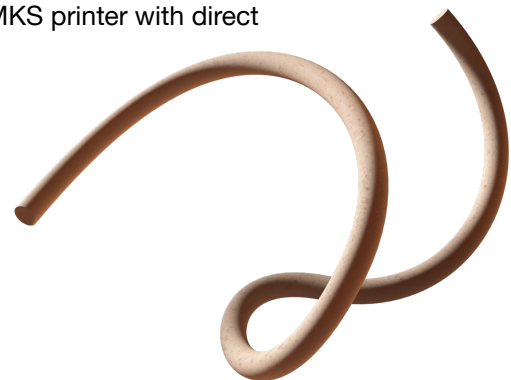
BioCir 3D filament is based on FDM technology, with a commonly used diameter of 1.75 mm.

The 3D printed parameters were determined by using a PRUSA i3 MKS printer with direct drive, PEI surface, a 0.8 mm nozzle and layer height of 0.2 mm.

The TDS data is constantly being extended by Balena.

Drying

BioCir is supplied dry, in sealed bags. When left open, drying is recommended @ 60°C, for 6hr.



Disclaimer

Typical properties and recommendations should be regarded as guideline values and not specifications. It is on the user responsibility to carefully evaluate the suitability of the material and its properties to the application.

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