

TECHNICAL DATA SHEET

Pellet WOOD

MATERIAL PROPERTIES

| Density | 1.15 gcm ³ | ISO 1183 |
|--------------------------------------|-----------------------|----------------|
| Melt flow rate (190°C/2.16kg) | 2.5-5.0 g/10 min | ISO 1133 |
| Melting temperature | > 155°C | ISO 3146-C |
| Mechanical Properties | | |
| Modulus of elasticity | 2900 MPa | ISO 527 |
| Tensile strength | 47 MPa | ISO 527 |
| Tensile strain at tensile strength | 5,00% | ISO 527 |
| Tensile stress at break | 38MPa | ISO 527 |
| Tensile strain at break | 6,50% | ISO 527 |
| Notched impact strength (Charpy), RT | 4.4 kJ/m2 | ISO 179-1/1 eA |
| Impact Strength (Charpy), RT | 21 kJ/m2 | ISO 179-1/1 eU |

GUIDELINE FOR PRINT SETTINGS*

| Nozzle temperature | 190-220°C | |
|-------------------------|------------------|--|
| Bed temperature | 0-45°C | |
| Active cooling fan | YES (up to 100%) | |
| Closed chamber | not necessary | |
| Dry box | not necessary | |
| Ruby or hardened nozzle | not necessary | |
| Recommended nozzle | ≥ 0.4 mm | |

^{*} settings are based on a 0,4 mm nozzle.

DESCRIPTION

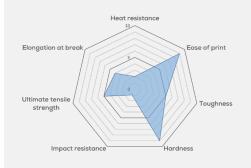
Spectrum FGF Pellet W00D is a material designed for 3D printing based on pure PLA blended with natural wood particles. Spectrum FGF Pellet W00D filament is a 100% organic and biodegradable product. Besides the visual aspects which imitate the appearance of wood, items manufactured of this material have a structure resembling the one of chipboards.

FEAUTURES

- made of biodegradable raw materials
- natural wood content
- perfect side surface of prints
- very good thermal insulation properties
- allows for grinding and varnishing
- typical smell and appearance of wooden chipboards

STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4-77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at support@spectrumfilaments.com

Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectum Group Sp. z o.o. materials in any particular application.



^{**} depending on the geometrical complexity