



Pellets developed and manufactured for use in Large Format Additive Manufacturing (LFAM) applications offer several key advantages over many commonly used materials, including:



- **Low to zero warpage** for dimensional stability
- **Printable without a heated chamber**, enabling broader equipment compatibility
- **Recycled feedstocks** supporting circular manufacturing
- **Economical material solution** without compromising performance
- **Custom color options** to meet branding or aesthetic requirements

## Properties (PRINTED PARTS)

## PRINTING CONDITIONS

Property	Typical Value	Units	Method
Flexural Strength (XY)	15200	PSI	ASTM D790
Flexural Strength (XZ)	15900	PSI	ASTM 790
Flexural Strength (ZX)	4600	PSI	ASTM 790
Tensile Strength (XY)	11400	PSI	ASTM D638
Tensile Strength (XZ)	13300	PSI	ASTM D638
Tensile Strength (ZX)	3100	PSI	ASTM D638
Post - Pull (ZX)	3000	PSI	**ASTM 638
Coefficient of Thermal Expansion	1.15E-05	in/in°C	ASTM 6341
Melt Flow Index (230°C @ 2.16kg)	7.65	g/10 min	ASTM 1238
Heat Deflection Temperature	76.5	°C	ASTM 648
Specific Gravity	1.51	N/A	ASTM 792
Pellet Size	2.5 x 2.5	mm	Target

Setting	Typical Value	Units	Notes
Zone 1	150-200	°C	Inlet
Zone 2	185-230	°C	
Zone 3	205-235	°C	
Zone 4	220-235	°C	Nozzle
Chamber	0	°C	Not Required
Bed	0	°C	Not Required
Adhesion Promotor	LFAM Adhesive		
Flow Rate	125	%	
Extruder Torque	45-60%	%	
Nozzle Size	10	mm	As Tested
Bead Width	15	mm	As tested
Layer Height	5	mm	As Tested
Optimal Layer Time	2-3	Minutes	
Drying	4 hrs @ 150°F	°F	<.05% M.C

\*\*Based on ASTM D638 Procedural Guidelines (Non-Standard Specimen Geometry)

### Important Notice Regarding this Information

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