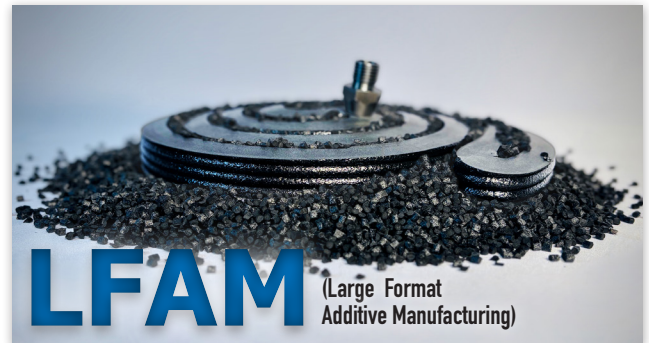




Pellets developed and manufactured for use in Large Format Additive Manufacturing (LFAM) applications offer several key advantages over many commonly used materials, including:

- **Low to zero warpage** for dimensional stability
- **Printable without a heated chamber**, enabling broader equipment compatibility
- **Recycled feedstocks** supporting circular manufacturing
- **Suitable for various applications** including construction, furniture, automotive, and more



Properties (PRINTED PARTS)

Property	Typical Value	Units	Method
Flexural Strength (XY)	12200	PSI	ASTM D790
Flexural Strength (XZ)	12800	PSI	ASTM 790
Flexural Strength (ZX)	4100	PSI	ASTM 790
Tensile Strength (XY)	10700	PSI	ASTM D638
Tensile Strength (XZ)	10400	PSI	ASTM D638
Tensile Strength (ZX)	2200	PSI	ASTM D638
Post - Pull (ZX)	3300	PSI	**ASTM 638
Coefficient of Thermal Expansion	1.65E-05	in/in°C	ASTM 6341
Melt Flow Index (300°C @ 2.16kg)	26.23	g/10 min	ASTM 1238
Heat Deflection Temperature	125.9	°C	ASTM 648
Specific Gravity	1.42	N/A	ASTM 792
Pellet Size	2.5 x 2.5	mm	Target

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

PRINTING CONDITIONS

Setting	Typical Value	Units	Notes
Zone 1	240-250	°C	Inlet
Zone 2	250-260	°C	
Zone 3	255-285	°C	
Zone 4	265-295	°C	Nozzle
Chamber	0	°C	Not Required
Bed	0	°C	Not Required
Adhesion Promotor	Infinite™ LFAM Adhesive		
Flow Rate	125	%	
Extruder Torque	25-35	%	
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 @ 250°F	°F	<.05% M.C

Important Notice Regarding this Information

The statements, technical information and recommendations contained herein are believed to be accurate. However, Interfacial Consultants makes no guarantee or warranty and does not assure any liability with respect to the accuracy or completeness of such information. Suitability of the product for a specific final end use is the sole responsibility of the user. The data contained herein are typical properties only and are not to be used as a specification.