Technical data sheet

Product name: **AzureFilm 3D Wood Pine**
Date of issue: 06 March 2017 Version: 1.0

Designation of product, preparation and manufacturer

Trade name:	AzureFilm Wood Pine 1.75mm or 2.85mm diameter
Use of product:	Biodegradable polymer compound suitable for 3D printing. The biobased carbon content is > 75 % (calculated). Contains wood fibers.
Manufacturer:	AzureFilm d.o.o. Orleška cesta 16 6210 Sežana Phone: + 386 (0)31 718 800 Mail: info@azurefilm.com Web: www.azurefilm.com

Mechanical properties

Modulus of elasticity	2,900	[MPa]	ISO 527
Tensile strength	47	[MPa]	ISO 527
Tensile strain at tensile strength	5	[%]	ISO 527
Tensile stress at break	38	[MPa]	ISO 527
Tensile strain at break	6.5	[%]	ISO 527
Flexural modulus	2,950	[MPa]	ISO 178
Flexural strain at break	no break	[%]	ISO 178
Flexural stress at 3.5 % strain	64	[MPa]	ISO 178
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

The values listed have been established on standardized test specimens (DIN EN ISO 3167, type A) at standard temperature and humidity conditions.

Physical properties

Melt flow rate (190 °C/2.16 kg)	2.5 - 4.5	[g/10 min]	ISO 1133
Melt volume rate (190 °C/2.16 kg)	2.2 - 4.0	[cm³/10 min]	ISO 1133
Melting temperature	> 155	[°C]	ISO 3146-C
Density	n/a	[g/cm³]	ISO 1183

Printing Recommendations:

Nozzle temperature: 200 – 230 °C
Heated bed: recommended 0-60 °C
Print speed: 30 – 100 mm/s
Build platform: Blue tape, Kapton tape. Recommended: Glass bed + spray 3D Lac 400ml
We recomended also to use nozzle 0,6mm and 0,15 to 0,20mm layer height

Legal notice