***Advanced Engineered Filaments***

***Technical Data Sheet***

Original release date: October 21, 2016

***Purge Filament***

Revision date: January 30, 2017

Description:

This purge filament, available in 1.75 mm and 2.95 mm diameter is specifically engineered to work in all 3-D Printers to clean, purge and lubricate the extruder head and nozzle. The purge filament is also designed to work with all plastic filaments including high temperature materials such as ULTEM and PEK.

***HD Polyethylene Copolymer Purge Filament***

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| --- | --- | --- | --- |
| ***Property*** | ***Nominal Value*** | ***Nominal Value*** | ***Test Method*** |
|  | ***(English)*** | ***(SI)*** |  |
|  |  |  |  |
| Density |  | 0.953g/cc | ASTM D4883  |
| Melt Index |  | 190°C / 2,160g | ASTM D1238 |
| Tensile Strength (yield) | 3,900 psi | 26.9 MPa | ASTM D638 |
| Tensile Elongation (break) | <600% | <600% | ASTM D638 |
| Flexural Modulus (Tangent Method) | 185,000 psi | 1,276 MPa | ASTM D790 |
| Notched Izod Impact Strength | 1.1 ft lb./in. | 58 J/m | ASTM D256 |
| Hardness | 65 Shore D | 65 Shore D | ASTM 2240 |
| Vicat Softening Point | 262°F | 128°C | ASTM D1525  |
| Brittleness Temperature | < -105°F | < -76°C | ASTM D746 |
| Deflection Temperature @66 psi | 171°F | 77°C | ASTM D648 |
|  |  |  |  |

These test results are based on reliable procedures. Due to variable conditions of fitness for a particular or methods of processing no guarantees or warrantees are expected or implied including warranty of fitness for a particular purpose. These are not product specifications, nor manufacturing minimums. Each user of the material should make appropriate tests to determine the suitability of the material for use.