



Technical Data Sheet

PPSU

| General Properties | | Standard |
|----------------------|--|------------|
| Printed Part Density | 1209 kg/m ³ / 75.4 lb/ft ³ | ISO 1183-1 |

| Thermal Properties | | Standard |
|----------------------------------|--|----------------|
| HDT at 1.8 MPa | 212 °C / 414 °F | ISO 75 - 2 |
| HDT at 0.4 MPa | 218 °C / 424 °F | ISO 75 - 2 |
| Vicat softening point at 50 N | 220 °C / 428 °F | ISO 306 |
| Glass Transition Temperature | 220 °C / 428 °F | ISO 11357 - 2 |
| Melt Volume Rate | 39 cm ³ /10min / 2.38 in ³ /10 min | ISO 1133 |
| Coefficient of Thermal Expansion | 55E-6/K | ISO 11359 - 2 |
| Flammability 12 s. vertical | Passed (thickness 1.59 and 6.35 mm) | FAR 25.853 (a) |
| Flammability 60 s. vertical | Passed (thickness 1.59 and 6.35 mm) | FAR 25.853 (a) |

| Mechanical Properties . Dried specimen | | | |
|--|-----------|-------------------------|------------------------|
| Print direction | Standard | XY | ZX |
| | | Flat | Upright |
| Tensile Strength | ISO 527 | 65.1 MPa / 9.4 ksi | 51.6 MPa / 7.5 ksi |
| Elongation at Break | ISO 527 | 6.50 % | 3.20 % |
| Young's Modulus | ISO 527 | 2037 MPa / 295 ksi | 2036 MPa / 295 ksi |
| Flexural Strength | ISO 178 | 92.6 MPa / 13.4 ksi | 96.5 MPa / 14.0 ksi |
| Flexural Modulus | ISO 178 | 2152 MPa / 312 ksi | 1999 MPa / 290 ksi |
| Impact Strength Charpy (notched) | ISO 179-2 | 13.8 kJ/m ² | 5.5 kJ/m ² |
| Impact Strength Charpy | ISO 179-2 | 200.7 kJ/m ² | 22.6 kJ/m ² |
| Impact Strength Izod (notched) | ISO 180 | 12.0 kJ/m ² | 5.5 kJ/m ² |
| Impact Strength Izod (unnotched) | ISO 180 | 119 kJ/m ² | 14.3 kJ/m ² |