

POM

- Temperature print: 220-230 °C for 2,90 mm filament / 210-230 °C for 1,75 mm filament
- Temperature pad is 90 - 110 °C

Material data sheet for POM:

Physical properties	Value	Unit	Test Standard
Density	1410	kg/m ³	ISO 1183
Melt volume rate (MVR)	2.5	cm ³ /10min	ISO 1133
MVR test temperature	190	°C	ISO 1133
MVR test load	2.16	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	2400	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	61	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	11	%	ISO 527-2/1A
Flexural modulus (23°C)	2400	MPa	ISO 178
Charpy notched impact strength @ 23°C	8.5	kJ/m ²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	163	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	91	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	1.1	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	1	E-4/°C	ISO 11359-2

Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	9988-2	-	Internal