XELIGHT® 17-87-P2-3DF

Lightweight PEBA

Material Properties	Test Condition	Standard	Unit	Dam / Cond.
Diameter			mm	**1,75**
Density		ISO 1183	g/cm^3	**0,87**
Hardness	Shore D, 15s	ISTR02L	ShD	**52**

Thermal Properties

Melting point	10 °C/min	ISO 11357	°C	**160**
Glass transition temperature	10 °C/min	ISO 11357	°C	**<0**
HDT – heat deflection temperature	1,80 MPa a 120 °C/h	ISO 75	°C	**50**
Melt Flow Rate	220°C / 2,16kg	ISO 1133	g/10min	**4**
Melt Volume Rate	220°C / 2,16kg	ISO 1133	cm^3/10min	**5**

Suggested Printed Settings	Test Condition	Standard	Unit	Value
Nozzle temperature			°C	**220–240**
Bed temperature			°C	**80–95**
Printing speed			mm/s	**≤40**
Nozzle type				**Brass/Steel**
Nozzle diameter			mm	**>0,25**
Bed type				**Glass/PEI**
Adhesive				**Suggested**
Closed chamber				**Suggested**

Drying Recommendations	Test Condition	Standard	Unit	Value
Drying temperature	desiccant dryer		°C	**85**
Drying time	desiccant dryer		h	**4–8**

Test values
Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note
Under the recommended processing condition small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

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