



Innovate3Dglobal Pty Ltd

Westmead New South Wales 2145, Australia

sales@innovate3dglobal.com, +61-452 392 608

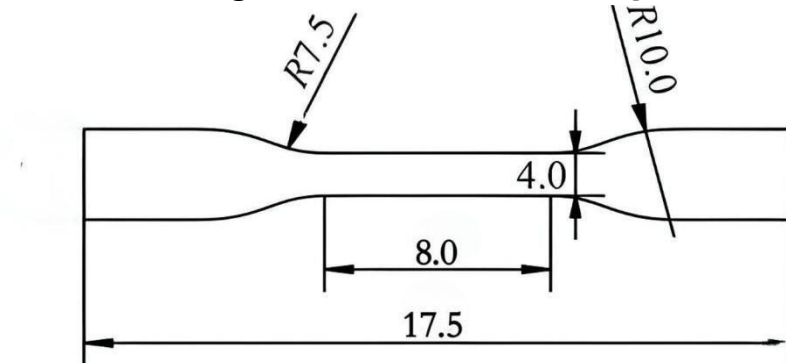
PA-GF10 Filament Technical Data Sheet

Features			Application	
• High strength • Glass filled • Anti impact • Low warpage			• Cultural and creative • Toys • Gifts • Industrial	
Physical	Typical Value	Unit	Method	Test Condition
Density	1.16	g/cm ³	ISO 1183	23°C
Melt Flow Rate	3.6	g/10min	ISO 1133	235°C/2.16KG

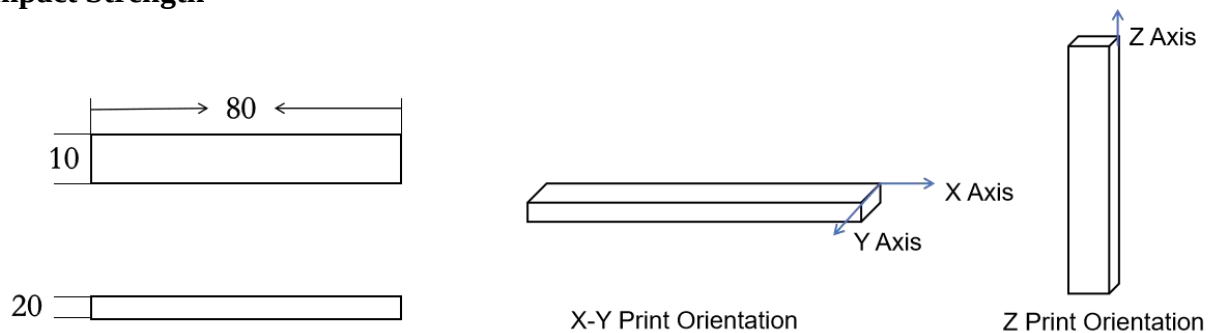
Mechanical	Typical Value	Unit	Method	Test Condition
Tensile Strength(XY)	56	MPa	ISO 527	50mm/min
Elongation at Break	18	%	ISO 527	50mm/min
Flexural Strength(XY)	71	MPa	ISO 178	5mm/min
Flexural Modulus(XY)	2200	MPa	ISO 178	5mm/min
Flexural Strength((Z)	55	MPa	ISO 178	5mm/min
Flexural Modulus(Z)	1428	MPa	ISO 178	5mm/min
Unnotched Izod Impact Strength(XY)	19	KJ/m ²	ISO 180	23°C
Unnotched Izod Impact Strength(Z)	14	KJ/m ²	ISO 180	23°C

Thermal	Typical Value	Unit	Method	Test Condition
Melting Temperature	195	°C	DSC	10°C/min
Heat Deflection Temperature	94	°C	ASTM D648	120°C/h, 0.45 MPa
Printing Temperature	220-260	°C	/	/
Bed Temperature	80-100	°C	/	/

Testing Model and Printing Parameters 1.1 Tensile Strength



1.2 Flexural Strength and Unnotched Izod Impact Strength



1.3 Printing parameters

Printing parameters	Data
Nozzle Printing temperature	260°C
Plate Temperature	100°C
Printing Speed	100 mm/s
Infill Density	100%

Notice The data contained in this document is based on trials carried out by our Research Centers. Properties are dependent upon process conditions and machine used, so these figures are only given for information.