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PVA Filament Technical Data Sheet

Features			Application	
• Support material • Dissolve quickly • Good adhesion • Low warpage			• Cultural and creative • Toys • Gifts • Industrial	
Physical	Typical Value	Unit	Method	Test Condition
Density	1.27	g/cm ³	ISO 1183	23°C
Melt Flow Rate	9	g/10min	ISO 1133	190°C/2.16KG

Mechanical	Typical Value	Unit	Method	Test Condition
Tensile Strength	14	MPa	ISO 527	50mm/min
Elongation at Break	50	%	ISO 527	50mm/min
Flexural Strength	42	MPa	ISO 178	5mm/min
Flexural Modulus	850	MPa	ISO 178	5mm/min
Unnotched Izod Impact Strength	14	KJ/m ²	ISO 180	23°C

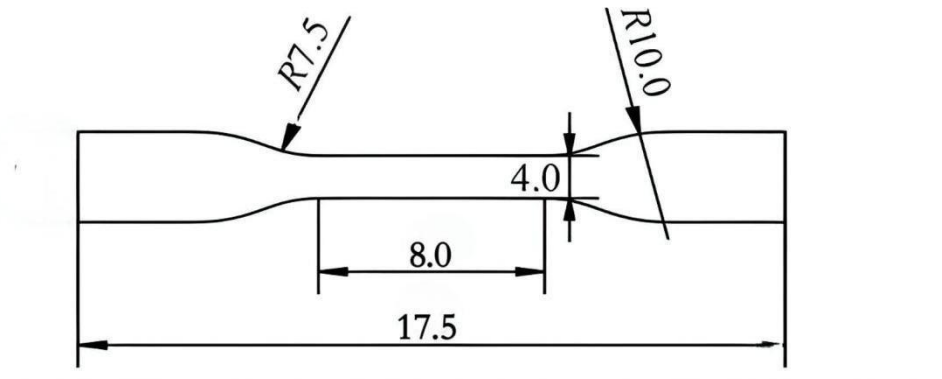
Thermal	Typical Value	Unit	Method	Test Condition
Melting Temperature	175	°C	DSC	10°C/min
Heat Deflection Temperature	65	°C	ASTM D648	120°C/h, 0.45MPa

Printing Temperature	190-210	°C	/	/
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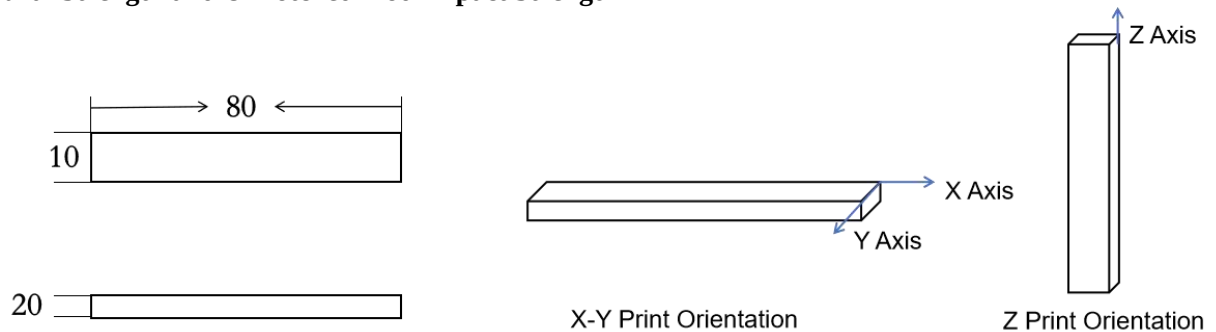
Notice The data contained in this document is based on trials carried out by our Research Centers. Properties are dependent upon process conditions and machine used, so these figures are only given for information.

Testing Model and Printng Parameters

1.1 Tensile Strength



1.2 Flexural Strength and Unnotched Izod Impact Strength



1.3 Printing parameters

Printing parameters	Data
Nozzle Printing temperature	200°C
Plate Temperature	60°C
Printing Speed	100 mm/s
Infill Density	100%

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