



3D PRINTING FILAMENT

(Filament specification: 1.75mm / 2.85mm)

FILAMENT	Print Temp(°C)	Bed Temp(°C)	Density (g/cm ³)	Distortion Temp (°C,0.45MPa)	Melt Flow Index (g/10min)	Tensile Strength (MPa)	Elongation at Break (%)	Bending Strength (MPa)	Flexural Modulus (MPa)	IZOD Impact Strength (kJ/m ²)
PLA	190-210	No Heat/(60-80)	1.24	56	5(190°C/2.16kg)	65	8	97	3600	4
PLA+	205-225	No Heat/(60-80)	1.24	52	2(190°C/2.16kg)	60	29	87	3642	7
ABS	220-260	110	1.04	78	12(220°C/10kg)	43	22	66	2348	19
ABS+	220-260	110	1.06	73	15(220°C/10kg)	40	30	68	2443	42
eABS MAX	200-240	100-110	1.18	85	60(220°C/10kg)	45	30	55	2400	48
eASA	220-260	70-110	1.0	105	10-15(220°C/10kg)	50	30	35	4300	19
HIPS	220-260	110	1.05	80	3(200°C/5kg)	27	55	39	2280	11
PETG	230-250	No Heat/80	1.23	64	20(250°C/2.16kg)	49	228	68	2027	8
PVA	180-210	No Heat/(60-80)	1.25	/	/	22	360	/	/	/
eSmooth	190-210	45-55	/	63.5	4-6(190°C/2.16kg)	46.16	273.14	71.41	2799.32	4.39
eClean	160-300	/	0.95	45	/	23	580	/	/	29
Wood	190-220	No Heat/80	0.70	45	15(190°C/2.16kg)	/	/	/	/	/
eBamboo	200-220	25-70	1.2	48	10-18(220°C/10kg)	28	3-7	35	2000	10
Color Change	190-220	No Heat/(60-80)	1.24	58	11(190°C/2.16kg)	65	5	97	3600	4
Bronze	180-210	No Heat/60	1.27	50	62(190°C/2.16kg)	66	16	106	4442	4
eCopper	200-220	40	2.46	52	/	40	4	64	4954	4
eAl-fill	200-220	No Heat/40	1.48	52	/	45	5	74	4885	4
eSteel	200-220	40	2.46	48	14(190°C/2.16kg)	42	11	52	4520	7
ePA (Nylon)	240-260	80-110	1.12	50	5(230°C/2.16kg)	57	196	57	1495	15
ePA-CF	240-260	80	1.2	160	8(250°C/5kg)	118	5	164	8500	11.5
ePA-GF	240-260	60-90	1.25	120.7	15(220°C/10kg)	100.96	16.72	126.45	3213.96	13.67
ePC	235-260	110	1.20	93	45(300°C/1.2kg)	57	160	80	2333	48
eFlex (TPU)	210-230	No Heat	1.12	/	/	52	500	/	/	/
eLastic (TPE)	210-230	No Heat	1.14	/	/	32	420	/	/	/
eMate (PCL)	80-110	45	1.33	51	4(110°C/2.16kg)	17	228	25	849	23
CERTIFICATION	   									



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