



Material DataSheet PLENE 4

TDS Nr.: 5047

Rev. 3.0 25/03/2025

Main features

Low warpage

Impact resistance

Low water absorption

High-strength and stiffness parts with low creep

Physical properties

Physical properties	Test method	Specimen	Units	Typical value
Specific gravity	ISO 1133-1		g/cm ³	0.9
Water absorption				

Mechanical Properties at 23°C

Tensile strength

Tensile modulus

Impact strength

Impact strength notched

Flexural modulus

Flexural strength

Flexural elongation F. max.

Elongation F. max.

Thermal properties

Heat distortion temperature	ISO 75B-1, -2		°C	62
Continuous service temperature				

Electrical properties

Insulation resistance

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SUGGESTED PRINT SETS (I)

Suggest print sets	Unit	Value	Test method
Extruder temp	C°	235-255	Internal
Plate temp	C°	80 - 100	Internal
Min. nozzle diameter	mm.	0,4	Internal
Fan	%	50 - 100	Internal
Print speed	mm/l°	40 - 60	Internal

ADDITIONAL INFORMATION

In General filaments made with PLENE 4 can be processed on conventional 3D printer using FDM / FFF technology.

(I) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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