

# GreenyHT

## MATERIAL PROPERTIES

Density	1,54 g/cm <sup>3</sup>	EN ISO 1183-1/A
MFR (190°C, 2,16kg)	20g/10min	EN ISO 1133
<b>Mechanical properties</b>		
Tensile strength	52 MPa	EN ISO 527-1
Tensile modulus	900 MPa	EN ISO 527-1
Tensile Break at Strain	4,70%	EN ISO 527-1
Flexural Modulus	3000 MPa	EN ISO 178
<b>Thermal Properties</b>		
Heat Deflection Temperature		
0,45 MPa	87°C	EN ISO 75-1
VICAT Softening Temperature	98°C	EN ISO 306

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	190-220°C
Bed temperature	0-45°C
Active cooling fan	50-85%
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	30-100 mm/s
Closed chamber	not necessary
Dry box	not necessary
Ruby or hardened nozzle	recommended

\* settings are based on a 0,4 mm nozzle.

\*\* depending on the geometrical complexity

### Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectrum Group Sp. z o.o. materials in any particular application.

## DESCRIPTION

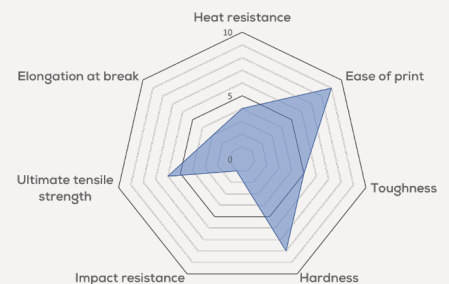
Spectrum GreenyHT is a new filament based on high-performance biopolymer. In terms of rigidity and hardness, it significantly outperforms classic PLA grades. The surface irregularity and matt look effectively mask the layers of printed part. GreenyHT filament is intended for users who demand ease of printing, delivered with enhanced thermal resistance, high rigidity and a matt, rough surface.

## FEAUTURES

- rough, matt print finish
- plasticiser-free
- GMO-free
- biodegradable and compostable
- base material approved for food contact
- increased rigidity and hardness
- option to print on desktop printers without a

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)