

PPS AM230

MATERIAL PROPERTIES

Density	1.33 g/cm ³	ISO 1183
Mechanical properties		
Charpy impact strength, unnotched* (23°C)	18 kJ/m ²	ISO 179-1eU
Charpy impact strength, notched* (23°C)	1,3 kJ/m ²	ISO 179-1eA
Tensile Elongation at Break*	2,00%	ISO 527 (1)
Tensile Strength at Break*	65 MPa	ISO 527 (1)
Elastic modulus tensile* (speed 1mm/min)	3650 MPa	ISO 527 (1)
Thermal properties		
VICAT Softening point* 50N	236°C	ISO 306
Heat Deflection Temperature		
0.45mn/m ² *	129°C	ISO 75
1.81mn/m ² *	107°C	ISO 75

*injection moulding

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	300-330°C
Bed temperature	100-120°C
Active cooling fan	0 - 10%
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	30-70 mm/s
Closed chamber	active heated (60-80°C)
Dry box	not necessary
Ruby or hardened nozzle	not necessary
Adhesive required	YES (Magigoo Pro HT)
Drying (if wet)	recommended***

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

*** at least 3h at 90°C using hot dry air oven

** depending on the geometrical complexity

DESCRIPTION

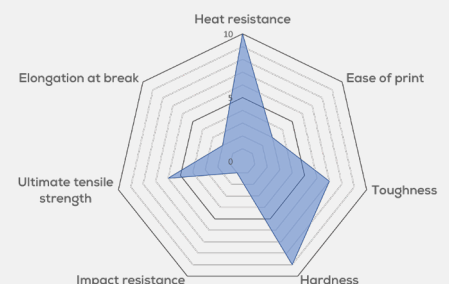
Spectrum PPS AM230 is a high-temperature filament based on an engineering polymer PPS offering exceptionally high mechanical properties. Even under continuous loading at high temperatures rigidity, strength and creep resistance remain unchanged. The filament also has remarkable chemical resistance – it is virtually insoluble in any known solvent, including concentrated acids and bases. A distinctive feature of Spectrum PPS AM230 is its inherent non-flammability, even without using flame-retardant additives.

FEAUTURES

- excellent chemical resistance
- very high dimensional stability
- solvent resistance
- high dielectric strength
- perfect bonding of the layers

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