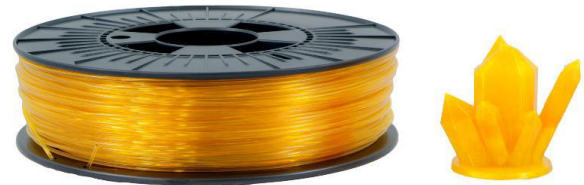


## ICE FILAMENTS ICE-PET PRODUCT CARD

ICE Filaments ICE-Pet is a strong, high clarity, odor neutral and easy to print filament for 3D printing. These characteristics, together with the high impact strength, excellent flexibility and practically no shrinkage makes ICE-Pet an excellent material which combines the advantages of both PLA and ABS. The filament is hydrophobic and therefore does not absorb water. In short, ICE-Pet has many great features and is the perfect addition to any filament assortment.

### FEATURES:

- ∞ High clarity
- ∞ Strong and flexible
- ∞ Almost no “warping”
- ∞ Hydrophobic (does not absorb water)
- ∞ Food contact acceptable
- ∞ Odor neutral printing



### COLOURS:

ICE Filaments ICE-Pet is available from stock in a variety of colors. Other colors on request.



FILAMENT SPECS		
Size	Ø tolerance	Roundness
1.75mm	± 0,05mm	≥ 95%
2.85mm	± 0,10mm	≥ 95%

MATERIAL PROPERTIES		
Description	Testmethod	Typical value
Specific Gravity	ISO 1183	1,27 g/cc
MFR 190°C/2,16 kg	ISO 1133	6,4gr/10 min
Tensile strength at yield	ISO 527	50,4 Mpa
Strain at yield	ISO 527	5,9%
Strain at break	ISO 527	22,7 %
Tensile Modulus	ISO 527	2020 MPa
Flexural Modulus	ISO 178	2050 MPa
Flexural Strength	ISO 178	69 MPa
Impact Strength – Charpy notched 23°C	ISO 179	8,1 kJ/m <sup>2</sup>
Rockwell hardness	ASTM D785	105
Moisture absorption	ISO 62	1104 ppm
Printing temperature	ICE FILAMENTS	195 – 220°C
Heat deflection temperature	ASTM 648	70°C
Transparency	ASTM D1003	90%

### ADDITIONAL INFO:

Recommended heated bed temperature is ± 35 – 60°C. Adhesion is possible on different surfaces.

ICE-PET can be used on most common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry (15 – 25°C) and away from UV Light. This enhances shelf life significantly.