POM

- Temperature print: 260-280 °C for 2,90 mm filament / 230-250 °C for 1,75 mm filament
- Temperature pad is 110 °C

Material data sheet for POM:

Physical properties	Value	Unit	Test Standard
Density	**1410**	kg/m³	ISO 1183
Melt volume rate (MVR)	**2.5**	cm³/10min	ISO 1133
MVR test temperature	**190**	°C	ISO 1133
MVR test load	**2.16**	kg	ISO 1133

Mechanical properties	Value	Unit	Test Standard
Tensile modulus (1mm/min)	**2400**	MPa	ISO 527-2/1A
Tensile stress at yield (50mm/min)	**61**	MPa	ISO 527-2/1A
Tensile strain at yield (50mm/min)	**11**	%	ISO 527-2/1A
Flexural modulus (23°C)	**2400**	MPa	ISO 178
Charpy notched impact strength @ 23°C	**8.5**	kJ/m²	ISO 179/1eA

Thermal properties	Value	Unit	Test Standard
Melting temperature (10°C/min)	**163**	°C	ISO 11357-1,-2,-3
DTUL @ 1.8 MPa	**91**	°C	ISO 75-1/-2
Coeff.of linear therm. expansion (parallel)	**1.1**	E-4/°C	ISO 11359-2
Coeff.of linear therm. expansion (normal)	**1**	E-4/°C	ISO 11359-2

Test specimen production	Value	Unit	Test Standard
Processing conditions acc. ISO	**9988-2**	-	Internal