



# Technical Data Sheet

## InnoCircle rPET Blue

Monofilament suitable for all commercially available leading brands 3D FDM/FFF printers

### IDENTIFICATION OF THE MATERIAL

Trade name	InnoCircle rPET Blue (Recycled PET)
Chemical name	PET copolymer compound
Chemical family	PET copolymer
Use	3D-Printing
Origin	Recycled, 100% traceable postindustrial PET
Company	Innofil3D BV

### MATERIAL PROPERTIES

		Test Method
Melting Point	210°C	ASTM D1003
Density	1270 kg/m <sup>3</sup>	ASTM D1505
Tensile Strength	145 MPa	ASTM D683 on 250 micron foil
Elongation at Break	130%	ASTM D683 on 250 micron foil
Tensile modulus	2100 MPa	ASTM D683 on 250 micron foil
Food Contact	EC approved	EC 282/2008; 1935/2004EC; EC 10/2011; 2023/2006/EC

### MONOFILAMENT DATA

		Test Method
Diameter 1.75	1.75 ± 0.05 mm	Innofil3D
Diameter 2.85	2.85 ± 0.10 mm	Innofil3D
Max. roundness deviation 1.75	0.05 mm	Innofil3D
Max. roundness deviation 2.85	0.10 mm	Innofil3D
Color	Natural blue translucent	Innofil3D
Print temperature guideline	235 ± 10°C	Innofil3D
Print speed guideline	40 - 80 mm/s	Innofil3D
Heated bed temperature guideline	± 75 – 80 °C	Innofil3D