

PRODUCT NAME: 3D FILAMENT BioWOOD 1,75mm

PRODUCT DESCRIPTION: BioWOOD filament – thermoplastic polymer in the form of a thread, designed for 3D printing using the FFF/FDM method. Filament coiled on spools, vacuum-packed with desiccant in a PA/PE bag, and then in a box.

STORAGE: Store in dry area. Store in a closed container.

PRODUCT PARAMETERS

Parameter	Value
Filament diameter [mm]	1,75
Diameter tolerance [mm]	+/- 0,05
Oval tolerance [mm]	+/- 0,02

Net weight [g]	500	1000
Weight with packaging [g]	900	1400
Spool weight [g]	Transparent PC: 245	Transparent PC: 260
	ECO PP wood: 190	ECO PP wood: 205
Spool dimensions [mm](\varnothing / height / hole \varnothing)	Transp. PC: 200/55/52	Transp. PC: 200/68/52
	ECO PP wood: 200/57/52	ECO PP wood: 200/70/52
Box dimensions [mm]	220/210/65	220/210/75

RECOMMENDED PRINTING PARAMETERS

Parameter	Wartość
Print temperature [°C]	170-210
Bed temperature [°C]	30-50
Cooling [%]	100
Closed chamber	Not necessary
Recommended nozzle size [mm]	$\geq 0,5$
We recommend drying the filament before printing for 3-4 hours at 50°C	

PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,26	g/cm ³	-
VICAT	50	°C	-
Tensile modulus	3195	MPa	ISO 527 (1 mm/min)
Tensile strength	34	MPa	ISO 527 (5 mm/min)
Elongation at break	3	%	ISO 527 (5 mm/min)
Charpy impact strength	15	kJ/m ²	ISO 179/1 eU
Charpy impact strength (notched)	3	kJ/m ²	ISO 179/1 eA
Food Contact Approval	YES	-	-

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of BioWOOD parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.

