

VICTREX AM™ 200 FIL



Product Description

High performance thermoplastic material, PolyArylEtherKetone (PAEK), semi crystalline, filament for Additive Manufacture by filament fusion and other melt extrusion 3D printing processes. Colour natural/beige.

Typical Application Areas

Additive manufacturing processing. Filament Fusion printed parts, to achieve improved printed part strength and printability compared to PEEK polymer on most machines. For use in higher temperature applications and chemically aggressive environments. Low outgassing, suitable for sterilisation. Not suitable for medical implant applications. Product supplied vacuum packed with desiccant and dry when produced. Drying before use is recommended.

Dimension	Test Method	Units	Typical Value
Diameter	3 axis laser micrometer	mm	1.75
Linear density	Victrex test method VSH-STM-01	g/10000 m	31,000

Packaging	
Spool Dimensions	200mm diameter 70mm width 55mm centre bore
Spool Material	Heat-resistant Polycarbonate
Nominal Weights	1kg, 0.5 kg respectively
Nominal Lengths	322m, 161m respectively

Typical Material Properties	CONDITIONS	TEST METHOD	UNITS	Orientation		
				XY	YZ	ZX
Tensile Strength	Yield, 23°C	ISO 527	MPa	65	70	45
Tensile Modulus	23°C	ISO 527	GPa	3.3	2.5	2.7
Tensile Elongation	Break, 23°C	ISO 527	%	15	15	5.0

Thermal Data				
Melting Point	DSC	ISO 11357	°C	303
Glass Transition (Tg)	DSC (Onset)	ISO 11357	°C	151
	DSC (Midpoint)	ISO 11357	°C	154
Crystallisation Point	DSC	ISO 11357	°C	249

FLOW				
Melt Viscosity	400°C, 100s ⁻¹	ISO 11443	Pa.s	400

Example Processing Conditions	
Drying Temperature / Time	120°C / 5h (residual moisture <0.02%)
Extrusion Temperature	380-400°C (Nozzle)
Chamber/Build-Space Temperature	Printing directly semi-crystalline: 150-180°C (see note below) Printing amorphous: 40-80°C
Bed Temperature	20-40°C above chamber temperature
Annealing conditions	Slow heating rate (3°C/min ramp rate). 170-180°C, 2-4hours. Optimization may be required.

Notes

Best results may be expected from elevated build-space temperatures and are machine specific. This datasheet represents properties that may be expected from build-space temperatures between 50-120°C. Samples have been successfully produced on <120°C build-space temperatures, however higher performance may be expected from machines with >120°C build space temperatures. Results vary widely from machine to machine.

Annealing may be required to generate semi-crystalline parts, depending on the machine and process conditions used in printing. Semi-crystalline parts can be made in some machines by using chamber temperatures >150°C, however in other machines the best results may be achieved by printing parts with reduced crystallinity and subsequently annealing. Annealing temperatures between 170-180°C are recommended. Parts may deform if higher annealing temperatures are used. Depending on the print parameters, annealing conditions may require adjustment for best results.

Important notes:

1. Typical values only. Not product specification.
2. Printing condition details are available on request.

Detailed data are available on our website www.victrex.com or upon request.

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