

# Technical Data Sheet (TDS): Guideline

## Guideline from taulman3D

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HS Code	3916.9
Printing Temperature	244-252C
Melting Temperature	220C
Tg Glass Transition	77C
Pyrolysis – Thermal Degradation	294C
Non-Destructive Evaluation	Yes
Print Bed Temperature	55C
Optimal Bed Surface	Glass
Shrinkage (in)	0.0021
Tensile Strength (PSI)	6,850
Ultimate Elongation when 3D Printed	5.9%
Modulus PSI when 3D Printed	28,146
Opacity	91%
Colors	Natural
UL 94 HB	No
UL 94 V2 at 1.5mm thickness	No
FDA Direct Food Contact	Yes
FDA Direct Drink Contact	Yes
Use of Taps for Threads	Very Good
CNC Finish Tooling	Carbide
CNC Coolant	Forced Air Only
Use in 3D Forging	Good
Robotic Assemblies	Very Good
Nominal Diameters	1.75mm and 2.85mm (3mm)

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High Strength Materials

