

Technical Data Sheet: 3DXSTAT™ ESD-Ultem™ 3D Printing Filament

Physical Properties	Standard	Unit	Typical Value
Density	ISO 1183	g/cc	1.34

Mechanical Properties	Standard	Unit	Typical Value
Tensile Strength, Break	ISO 527	MPa	62
Tensile Modulus	ISO 527	MPa	2710
Tensile Elongation, Break	ISO 527	%	4
Flexural Strength	ISO 178	MPa	115
Flexural Modulus	ISO 178	MPa	2690

Thermal Properties	Standard	Unit	Typical Value
Glass Transition Temperature (Tg)	DSC	°C	217
Deflection Temperature at 0.45 MPa (66psi)	ISO 75	°C	205

Electrical Property	Standard	Unit	Typical Value
Surface Resistance	ASTM D257	Ohm/sq	>10 ⁷ - 10 ⁹ <

Printed Specimen Conditions
Printer: Open Source FDM/FFF
Nozzle: 0.4mm
Layer Height: 0.25mm
Infill: 100%, +/- 45°
Extrusion Temp: 395°C
Bed Temp: 150°C
Specimen Orientation: XY Flat