

ISOFORCE

Thermoforming conditions

Melting temperature (°C)	184 – 187	°C
Melting temperature (°F)	363 – 369	°F
Decomposition temperature (°C)	350	°C
Decomposition temperature (°F)	662	°F
Heat deflection temperature	86 (187)	°C (F)

Mechanical properties at 21°C

Flexural modulus	1500	MPa
Tensile modulus	1650	MPa
Tensile strength	45 - 51	MPa
Strain at break	15 - 25	%
Shore D hardness	73 - 77	
Impact resistance		
Charpy – Impact strength (DIN EN ISO179)	49.2 – 56.8	kJ/m ²
Charpy – Notched (DIN EN ISO179)	4.5 – 5.1	kJ/m ²
Izod – Notched (DIN EN ISO180)	4.0 – 4.8	kJ/m ²

General properties

Density	0.95	g.cm ⁻³
Color	grey	
Odor	none	
Biocompatible	yes	

- Please note : actual (mechanical) values may vary depending on the 3D build conditions.

INFORMATION

The flexural modulus indicates the material stiffness in bending.

Aging: the indicated time (h) denotes the start of yellowing in an aging accelerator. 250 h equals 1 year of solar energy in Belgium.

The tensile modulus indicates the material stiffness in tensile.

The tensile strength is the pulling force required to break the material.

The strain at break is the length increase of the material when stretched until failure.

The hardness indicates the resistance of the material to compression.

The impact resistance is the susceptibility of the material to fracture under stresses applied at high speeds.

The degradation temperature is determined in helium.

Note:

Although the information in this publication is believed to be accurate and reliable, the data shown are for guidance only. Orfit Industries gives no guarantees about the results and assumes no liability in connection with them. The properties reported here are intended primarily to facilitate comparison among Orfit products. Standard testing methods often allow alternative measuring methods. Therefore, data from other sheet manufacturers may not be directly comparable. For additional information, please contact Orfit Industries.



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