



TECHNICAL DATA SHEET

GreenTEC

DESCRIPTION

GreenTEC Pro is a biopolymer specially developed for high-performance applications where high temperature resistance and good mechanical properties are needed. In addition, the raw material is approved according to the FDA-, REACH- and RoHS- Standards.

FEATURES

- Made from renewable raw materials
- Excellent tensile strength
- Heat resistance up to 115°C VICAT A*
- Low warping tendency
- Biodegradable (DIN EN ISO 14855)

PROPERTIES ¹

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ISO 527	MPa	3200
Tensile strength	ISO 527	MPa	46
Elongation at strength	ISO 527	%	3
Stress at break	ISO 527	MPa	18
Nominal elongation at break	ISO 527-2	%	14
Notched impact strength	ISO 179/1eA	kJ/m ²	19
Unnotched impact strength	ISO 179/1eU	kJ/m ²	218
VICAT A (VST)	ISO 3146-C	°C	115*
Melting temperature	ISO 1133	°C	180-200
MFR	ISO 75	g/10min	8
Shrinking	ISO 294-4	%	0.5
Density	ISO 1183	g/cm ³	1.3

*Temperature resistance tested at a minimum wall thickness of 4 mm.

CERTIFICATIONS & ADDITIONAL INFORMATION ²



STORAGE AND SHELF LIFE

Store in a dry room at room temperature (18-27°C / 65-80°F). Keep out of direct heat and sunlight. When stored correctly, this material has a shelf life of 2 years.

1. Additional info in our regulatory, additional information and chemical resistance data sheets.
 2. Certifications depend on colors in final product. More info in the additional information sheet.

	TEMPERATURE RESISTANCE	7
	EASE OF PRINTING	7
	VISUAL QUALITY	9
	LAYER ADHESION	8
	IMPACT RESISTANCE	8
	MAXIMUM STRESS	7
	ELONGATION AT BREAK	5

PRINT SETTINGS

Nozzle	200-230°C
Heatbed	20-90°C
Adhesive	not required
Speed	40-60mm/s
Cooling	30-80%

Recommended settings for printers with a 0.4mm Nozzle. Max. 50% layerheight. Optimal print settings may vary between different printers and also depend on environmental factors.

NEED HELP?

If you have any question about the product and/or you are experiencing an issue, please contact us via support@extrudr.com