



TDS Rev 3.0

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

Physical Properties	Standard	Unit	Typical Value
Density	ISO 1183	g/cc	1.26

Mechanical Properties	Standard	Unit	Typical Value
Tensile Strength, Break	ISO 527	MPa	55
Tensile Modulus	ISO 527	MPa	2560
Tensile Elongation, Break	ISO 527	%	10
Flexural Strength	ISO 178	MPa	95
Flexural Modulus	ISO 178	MPa	2980

Thermal Properties	Standard	Unit	Typical Value
Glass Transition Temperature (Tg)	DSC	°C	60
Deflection Temperature at 0.45 MPa (66psi)	ISO 75	°C	55

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

Printed Specimen Conditions
Printer: Open Source FDM/FFF
Nozzle: 0.4mm
Layer Height: 0.25mm
Infill: 100%, +/- 45°
Extrusion Temp: 210°C
Bed Temp: 23°C
Specimen Orientation: XY Flat

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