



TECHNICAL DATA SHEET

GreenTEC Pro

DESCRIPTION

GreenTEC Pro is a high-performance biopolymer, with optimized characteristics for technical and mechanical applications. This material offers excellent temperature resistance and layer adhesion, as well as an appealing semi-matt finish. GreenTEC Pro is in compliance with the FDA-, REACH- and RoHS-Standards.

FEATURES

- Made from renewable raw materials
- Excellent tensile strength
- Heat resistance up to 160°C VICAT A / 115°C HDT/B*
- Low warping tendency
- Biodegradable (DIN EN ISO 14855)

PROPERTIES ¹

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ISO 527	MPa	4300
Tensile strength	ISO 527	MPa	58
Elongation at strength	ISO 527	%	2.8
Stress at break	ISO 527	MPa	53
Notched impact strength	ISO 179/1eA	kJ/m ²	4
Unnotched impact strength	ISO 179/1eU	kJ/m ²	71
VICAT A (VST)	ISO 306	°C	160*
Melting temperature	ISO 3146-C	°C	180-200
MFR	ISO 1133	g/10min	9
HDT/B	ISO 75	°C	115*
Shrinking	ISO 294-4	%	0.4
Density	ISO 1183	g/cm ³	1.35

*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	10
	EASE OF PRINTING	7
	VISUAL QUALITY	9
	LAYER ADHESION	8
	IMPACT RESISTANCE	8
	MAXIMUM STRESS	9
	ELONGATION AT BREAK	5

PRINT SETTINGS

Nozzle	210-230°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