

## Overview XILOY™ 3D grades

Additive manufacturing ABS grades for technical use

Typical data	SI units	XILOY™ 3D 100	XILOY™ 3D 105
Glass content	%	0	0
<b>Impact properties</b>			
Charpy notched impact strength (23°C)	kJ/m <sup>2</sup>	NB	7
Charpy notched impact strength (-40°C)	kJ/m <sup>2</sup>	20	5
Charpy unnotched impact strength (23°C)	kJ/m <sup>2</sup>	NB	20
Charpy unnotched impact strength (-40°C)	kJ/m <sup>2</sup>	NB	
<b>Tensile properties</b>			
Tensile stress at break	N/mm <sup>2</sup>	23	28
Elongation at break	%	50	11
E-modulus	N/mm <sup>2</sup>	1320	1800
<b>Flexural properties</b>			
Flexural strength	N/mm <sup>2</sup>	50	55
Flexural modulus	N/mm <sup>2</sup>	1310	1700
<b>Thermal properties</b>			
Heat deflection temperature at 1.80 MPa	°C	68	72
Heat deflection temperature at 1.80 MPa (Annealed)	°C	84	
Vicat softening temperature (50N)	°C	79	105
<b>Specific properties</b>			
Density	g/cm <sup>3</sup>	1.07	1.10
MFI at 240°C and 100N	dg/min	9.5	4.5
Spiral flow length	cm	32	28
Surface resistivity	Ohm.cm		10E+8



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