Technical Data Sheet

Product name: MetalFil™ - Ancient Bronze

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MetalFil™ - Ancient Bronze is an incredible new metal-filled PLA-based filament with approximately 80% of bronze filling. This incredible high filling with bronze powders enables every FDM 3D printer user to 3D print bronze objects which are almost indistinguishable from genuine bronze casted objects.
MetalFil™ - Ancient Bronze is a printer- and user friendly metal-filled filament and 3D printed objects can very easily be post-processed allowing one to create amazing bronze objects with various patina effects.

Properties	Typical value	Test Method	Test condition
Physical			
Specific gravity	3.5 g/cc	ISO 1183	-
Melt flow rate	-	-	-
Water absorption	-	-	-
Moisture absorption	-	-	-
Mechanical			
Impact strength	11.3 KJ/m²	ISO 179	Charpy Notched @23° C (73° F)
Tensile strength	19.0 Mpa	ISO 527	@Yield 50mm/min (2 inch/min)
Tensile modulus	3990 Mpa	ISO 527	1mm/min
Elongation at break	8%	ISO 527	@ Break 50mm/min (2 inch/min)
Flexural strength	-	-	-
Flexural modulus	-	-	-
Hardness	-	-	-
Thermal			
Print temperature	± 190 - 220° C	-	-
Melting termperature	± 210 ± 10° C	ISO 294	-
Viscat softening temp.	± 65° C	ISO 306	VST/A/50 (50° C/h, 10N)
Optical			
Haze	-	-	-
Transmittance	-	-	-
Gloss	-	-	-

Product details, certifications and compliance	
HS Code	39169090
REACH compliant	Yes
RoHS certified	Yes
FDA compliant	No

Diameter	Tolerance	Roundness
1.75mm	± 0.05mm	≥ 95%
2.85mm	± 0.10mm	≥ 95%

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