

## Technical Data Sheet: CreatBot PEI 1010

Print parameters	
Project	Data
Pre-printing drying conditions	100-120°C , 6-8 H
Nozzle temperature	360-390°C
Nozzle Diameter	0.4 / 0.6 / 0.8 / 1.0 mm
Print bed surface treatment	3D Printing Spray / PVP Glue Stick / Specialized Adhesive
Print bed temperature	150-240°C
Chamber temperature	90-220°C
Cooling fan speed	OFF
Print speed	30-60 mm/s

Physical Properties	Test method	Data
Density	ISO1183	1.28g/cm <sup>3</sup>
Saturated water absorption rate	25°C , 55%RH	/
Melt index	340°C , 2.16 kg	36g/10 min
Melting temperature	DSC, 10°C/ min	320°C
Vicat softening temperature	ISO 306,GB/T 1633	210°C
Determination of temperature	ISO 75 , 0.45MPa	208°C

Mechanical Properties	Test method	Data
Tensile strength XY	ISO 527, GB/T 1040	89 MPa
Tensile strength Z	ISO 527, GB/T 1040	/
Young's modulus XY	ISO 527, GB/T 1040	4800 MPa
Young's modulus Z	ISO 527, GB/T 1040	/
Elongation at break XY	ISO 527, GB/T 1040	5.3%
Elongation at break Z	ISO 527, GB/T 1040	/
Bending strength XY	ISO 178, GB/T 9341	165 MPa
Bending strength Z	ISO 178, GB/T 9341	/
Bending modulus XY	ISO 178, GB/T 9341	4000 MPa
Bending modulus Z	ISO 178, GB/T 9341	/
Impact strength XY	ISO 179, GB/T 1043	40 kJ/m <sup>2</sup>
Impact strength Z	ISO 179, GB/T 1043	/

### Disclaimer:

The above material performance data is from the CreatBot Laboratory and is intended solely for reference and comparison.

Actual 3D-printed model performance varies based on multiple factors, such as the printer, printing conditions, model geometry, and slicing software settings.

Users assume full responsibility for the legality and safety of their 3D printing when using CreatBot materials.

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