

Thermal Properties of FDM

	ABSi	ABS-ESD7	ABS-M30	ABS-M30i	ASA	ESD PEKK	Nylon 12	PC	PC-ABS	PC-ISO	PPSF	ULTEM 1010	ULTEM 9085
Heat Deflection (HDT) @ 66 ps	86°C	96°C	96°C	96°C	98°C	154°C	75°C	138°C	110°C	133°C		216°C	
Heat Deflection (HDT) @ 264 psi	73°C	82°C	82°C	82°C	91°C	149°C	55°C	127°C	96°C	127°C	189°C	213°C	153°C
Vicat Softening Temperature		99°C	99°C	99°C	103°C			139°C	112°C	139°C		214°C	
Glass Transition Temperature	116°C	108°C	108°C	108°C	108°C			161°C	125°C	161°C	230°C	215°C	186°C
Melting Point	N/A	N/A	N/A	N/A		303°C	178°C	N/A	N/A	N/A	N/A	N/A	N/A