



TECHNICAL DATA SHEET

BioFusion

DESCRIPTION

Extruder BioFusion is a new generation bio-based material specially developed for designers and makers. The material is offered in vivid colors. The raw material is approved according to the REACH-, RoHS- and FDA-Standards.

FEATURES

- Distinctive metallic shine
- Good impact strength
- Low warping tendency
- Recyclable

PROPERTIES ¹

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ASTM D882	MPa	3200
Tensile strength	ASTM D882	MPa	55
Breaking stress	ASTM D882	%	5
Elongation at break	ISO 527	MPa	41
E-Modulus	ISO 178	MPa	2200
Impact resistance	ASTM D256	kJ/m ²	12 J/m
MFR	ASTM D1238	g/10min	7
Melting temperature	ISO 3146-C	°C	200-210
VICAT A (VST)	ASTM D1525	°C	75*
Shrinking	ASTM D955	%	0.3
Density	ASTM D792	g/cm ³	1.25

*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.

Metric	Score
TEMPERATURE RESISTANCE	5
EASE OF PRINTING	8
VISUAL QUALITY	10
LAYER ADHESION	6
IMPACT RESISTANCE	5
MAXIMUM STRESS	6
ELONGATION AT BREAK	5

PRINT SETTINGS

Nozzle	210-220°C
Heatbed	20-60°C
Adhesive	not required
Speed	20-40mm/s
Cooling	0-30%

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@extruder.com