

# TIGITAL® 3D-Set | Technical Data Sheet

## PPP 371/80004



## General Information

### Product Description

TIGITAL® 3D-Set PPP 371/80004 is a thermoset powder material for selective laser sintering (SLS). It exhibits high flame retardancy and is easy to print with vastly lower printing temperatures than standard printing materials on all SLS devices. The moisture uptake is minimal, the reuse-rate is >70% and no pre drying step is necessary. The material is available in black.

### Features

- Flame retardancy (non-dripping, UL 94 V0)
- Vastly lower printing temperatures
- High reuse-rate
- Minimal moisture uptake

### Applications

- Electric and Electronic devices
- Automotive
- Aerospace and Defense

## Material Properties

General Properties*	Test Method	Typical Values
Printed Part Density [kg/m³]	ISO 1183-3	1.25 ± 0.02
Particle Size d10 [µm]	Laser Diffraction	15
Particle Size d50 [µm]	Laser Diffraction	44
Particle Size d90 [µm]	Laser Diffraction	80

Thermal Properties*	Test Method	Typical Values
HDT/A (1.8 MPa) [°C]	ISO 75	80

Mechanical Properties*	Test Method	Typical Values
Tensile Strength [N/mm <sup>2</sup> ]	ISO 527	40
Tensile Modulus [N/mm <sup>2</sup> ]	ISO 527	3200
Elongation at Break [%]	ISO 527	2.1
Shore-Hardness [D]	ISO 868	73.2
Charpy impact strength [kJ/m <sup>2</sup> ]	ISO 179	8.5
Charpy impact strength notched [kJ/m <sup>2</sup> ]	ISO 179	1.4
IZOD impact strength [kJ/m <sup>2</sup> ]	ISO 180	7.8
IZOD impact strength notched [kJ/m <sup>2</sup> ]	ISO 180	2.0

Burning Behaviour*	Test Method	Typical Values
UL 94	ISO 60695-11-10 (UL 94)	V0 [3.2mm]

\* All properties are measured on printed ISO specimen (properties correspond to printing parameters)

## Product Safety

Relevant industrial safety precautions and hygiene procedures must be followed (e.g. powder handling). For additional information please read the corresponding Material Safety Data Sheet (MSDS).

## Compatibility

The product is compatible with all SLS printing machines. For specific printing parameters and additional post-curing steps please read the corresponding Processing Data Sheet (PDS).

## Storage

The powder should be stored at temperatures from 15-25 °C in its originally sealed package in a clean and dry environment for 6 months upon delivery date.

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## Disclaimer

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