

3D Printing Filament

TECHNICAL DATA SHEET Bio Make

Commercial name: Make a Shape - Bio Make
 Raw material: Mater-Bi[®]
 Designation: 3D printing applications
 Manufacturer: Make a Shape srls - Via Delle Centurie 39 - 03100 Frosinone - Italy

Material specifications

Property	Value	Test Method - ISO
Density	1,32 g/cm ³	ASTM D792
Vicat Softening Temperature	53 °C	ASTM D648
Tensile Modulus (Yung)	2263 MPa	EN ISO 527
Tensile Strength	28 MPa	EN ISO 527
Melt Flow Rate	5 g/10'	ISO 1133

Filament specifications

Property	Value and Tolerances
Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Roundness deviation	max 3%
Suggested print temperature (guideline)	190 – 230°C
Suggested print speed	40 – 70 mm/s
Suggested bed temperature	0 - 20 °C