

## Technical Data Sheet

PolyWood™

[www.polymaker.com](http://www.polymaker.com)

V5.4



PolyWood™

PolyWood™ is a wood mimic filament without actual wood powder, which removes all risks of nozzle clogs. PolyWood™ is made entirely with PLA using a special foaming technology. It exhibits the same density and appearance as wood.

### PHYSICAL PROPERTIES

Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	0.9 g/cm <sup>3</sup> at 23°C
Melt index	N/A	N/A
Light transmission	N/A	N/A
Flame retardancy	N/A	N/A

### CHEMICAL RESISTANCE DATA

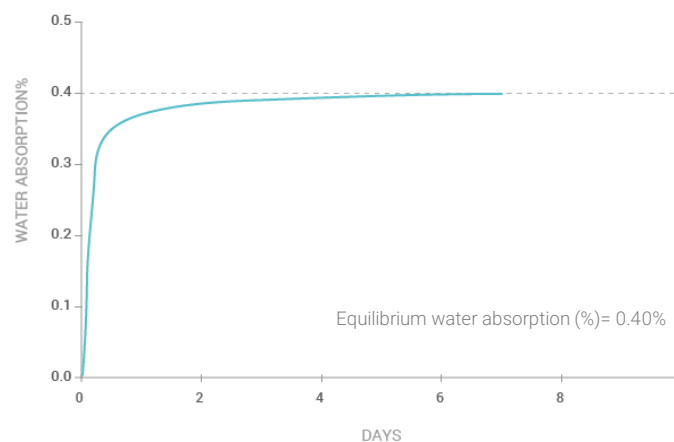
Property	Typical Value
Effect of weak acids	Good
Effect of strong acids	Poor
Effect of weak alkalis	Fair
Effect of strong alkalis	Poor
Effect of oils and grease	Good

**Note:**

- Good: Material may get minor attack after long periods of storage with chemical at ambient temperature
- Fair: Material can be used for short time contact with chemical at ambient temperature
- Poor: Material becomes unstable on contact with chemical at ambient temperature

### MOISTURE ABSORPTION CURVE

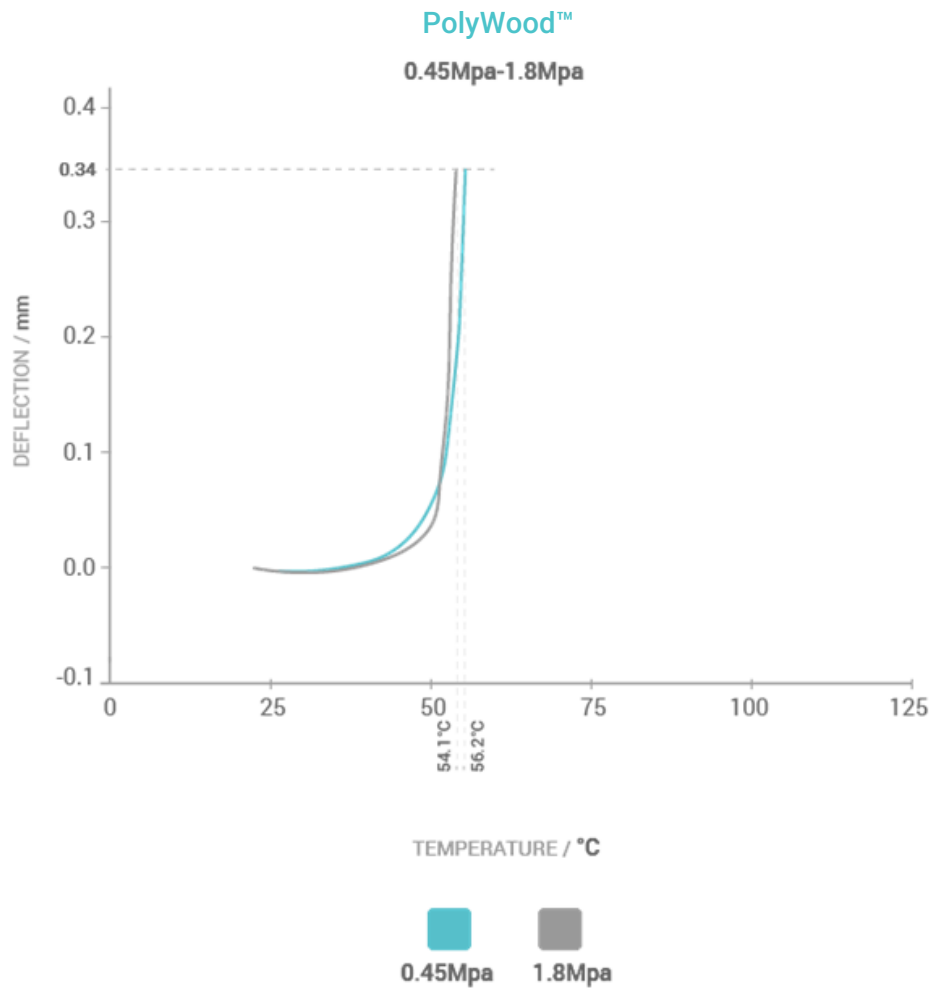
PolyWood™  
70%RH - 23°C



## THERMAL PROPERTIES

Property	Testing Method	Typical Value
Glass transition temperature	DSC, 10°C/min	59 °C
Melting temperature	DSC, 10°C/min	151 °C
Crystallization temperature	DSC, 10°C/min	N/A
Decomposition temperature	TGA, 20°C/min	N/A
Vicat softening temperature	ISO 306, GB/T 1633	60 °C
Heat deflection temperature	ISO 75 1.8MPa	50 °C
Heat deflection temperature	ISO 75 0.45MPa	54 °C

## HDT CURVE



## MECHANICAL PROPERTIES

Property	Testing Method	Typical Value
Young's modulus (X-Y)	ISO 527, GB/T 1040	1688.5 ± 80.8 MPa
Young's modulus (Z)		1726.3 ± 199.8 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	24.4 ± 0.3 MPa
Tensile strength (Z)		20.8 ± 0.9 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	8.8 ± 0.3 %
Elongation at break (Z)		2.0 ± 0.4 %
Bending modulus (X-Y)	ISO 178, GB/T 9341	1958.9 ± 72.6 MPa
Bending modulus (Z)		N/A
Bending strength (X-Y)	ISO 178, GB/T 9341	50.2 ± 1.6 MPa
Bending strength (Z)		N/A
Notched Charpy impact strength (X-Y)	ISO 179, GB/T 1043	2.4 ± 0.3 kJ/m <sup>2</sup>
Notched Charpy impact strength (Z)		N/A

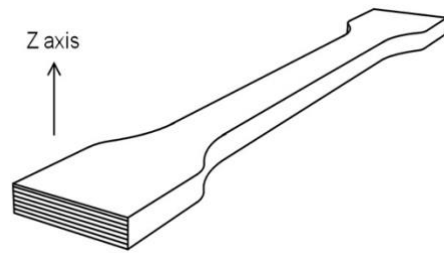
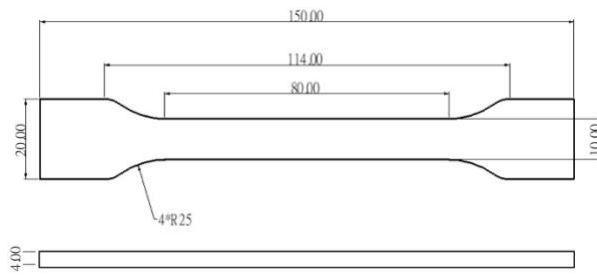
## RECOMMENDED PRINTING CONDITIONS

Parameter	
Nozzle temperature	190 – 210 (°C)
Build surface treatment	PC and Texture PEI (Glue when needed)
Build plate temperature	25 - 60 (°C)
Cooling fan	ON
Printing speed	50 - 100 (mm/s)
Retraction distance	3 - 6 (mm)
Retraction speed	40 - 60 (mm/s)
Closure Chamber	No Needed
Recommended support material	PolySupport™ and PolyDissolve™ S1
Drying setting	55°C for 6h
Annealing setting	-

\* Based on 0.4 mm nozzle. Printing conditions may vary with different nozzle diameters

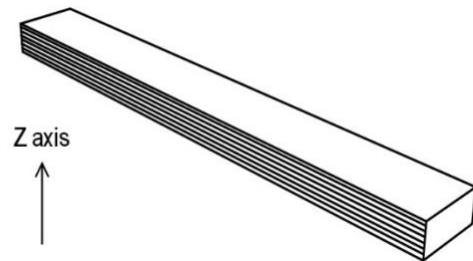
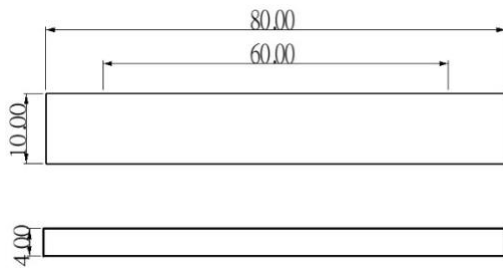
## TENSILE TESTING SPECIMEN

ISO 527, GB/T 1040



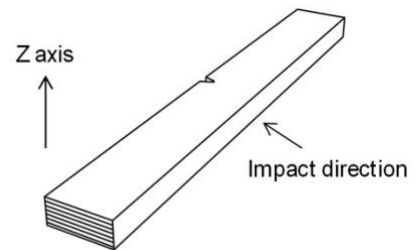
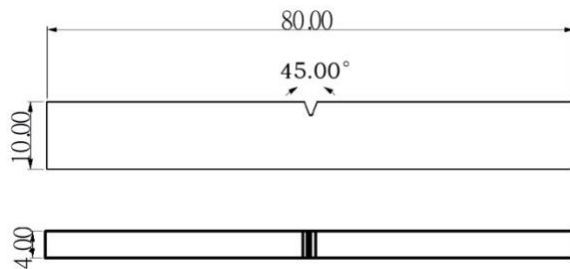
## FLEXURAL TESTING SPECIMEN

ISO 178, GB/T 9341



## IMPACT TESTING SPECIMEN

ISO 179, GB/T 1043



## HOW TO MAKE SPECIMENS

Printing temperature	210 °C
Bed temperature	50 °C
Shell	2
Top & bottom layer	3
Infill	100 %
Environmental temperature	Ambient temperature
Cooling fan	ON

**DISCLAIMER:**

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of Polymaker materials for the intended application. Polymaker makes no warranty of any kind, unless announced separately, to the fitness for any use or application. Polymaker shall not be made liable for any damage, injury or loss induced from the use of Polymaker materials in any application.