



**FIL-A-GEHR®**

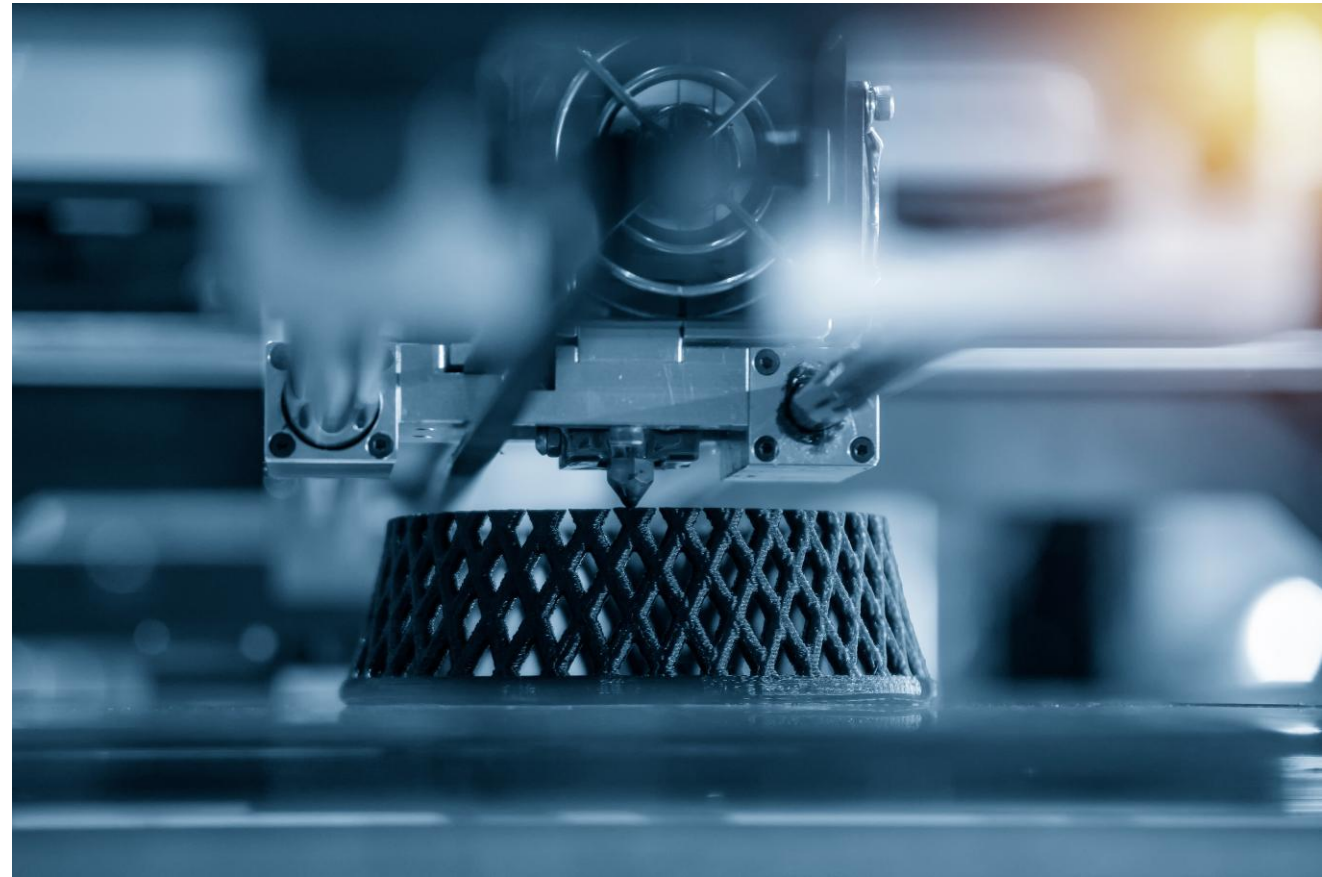
**FOR ADDITIVE MANUFACTURING**



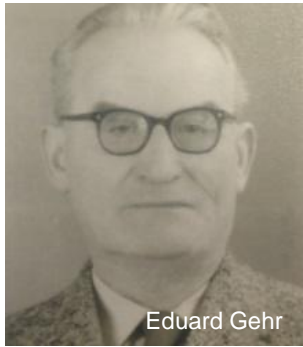
# CONTENT

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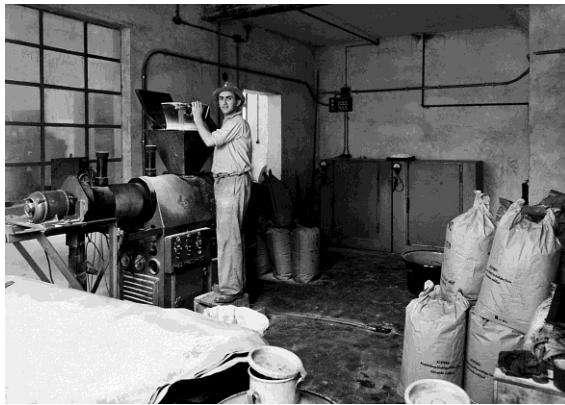
- » Our Company
- » **FIL-A-GEHR®** General Information
- » **FIL-A-GEHR®** Shop
- » **FIL-A-GEHR®** Technical Datasheets
- » **FIL-A-GEHR®** Materials
- » **FIL-A-GEHR®** Food Contact Suitable
- » Contact



# » FAMILY OWNED AND OPERATED COMPANY WITH TRADITION SINCE 1932



Eduard Gehr



Werner Gehr



# » GEHR – AN INTERNATIONAL COMPANY

» US headquarters  
and production site  
**Philadelphia, PA, USA**



» World headquarters and  
production site  
**Mannheim, Germany**



» Asia headquarters  
and warehouse  
**Hong Kong**

# » QUALITY AND INNOVATION



**GEHR GMBH**

wurde von FOCUS-Business in Kooperation mit dem Recherchepartner FactField als Top-Arbeitgeber Mittelstand identifiziert.

Folgende Kriterien\* lagen der Empfehlung u. a. zugrunde:

- Mindestens 10 Bewertungen von Arbeitnehmern über alle Datenquellen hinweg
- Bewertungsdurchschnitt von mindestens 3,5 von 5 möglichen Punkten
- Mitarbeiteranzahl zwischen 11 und 500
- Unternehmensstandort in Deutschland



**Andrea Key**  
Geschäftsführung

**FOCUS BUSINESS**

\*FOCUS-Business vergibt sein Siegel an Unternehmen der größten Empfehlungsliste für Top-Arbeitgeber Mittelstand. Die Aufnahme erfolgt anhand von Bewertungen durch das Recherchepartner FactField GmbH. Die Empfehlungsliste enthält keine Aussagen zur Vollständigkeit. Die Ergebnisse sind nicht repräsentativ. Der Kollaborations-Erwerb ist ein Lizenzvertrag. Eine weitere Nutzung der FOCUS-Business-URkunde ist nicht gestattet.

# OUR COMPETENCES

STOCK SHAPES



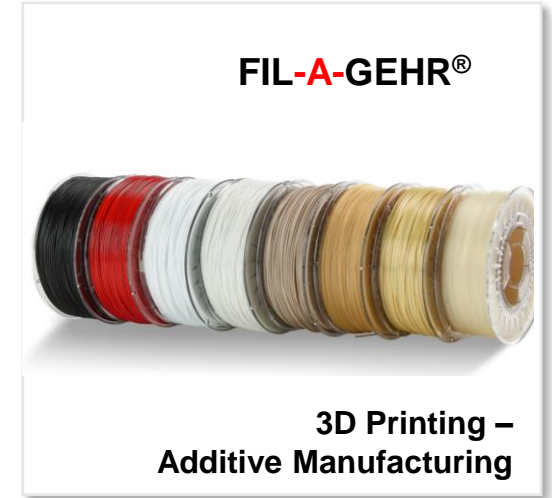
Industrial



Medical

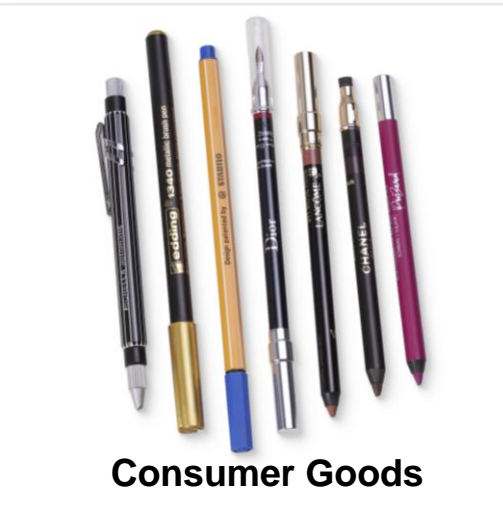


Aerospace & Defence



3D Printing –  
Additive Manufacturing

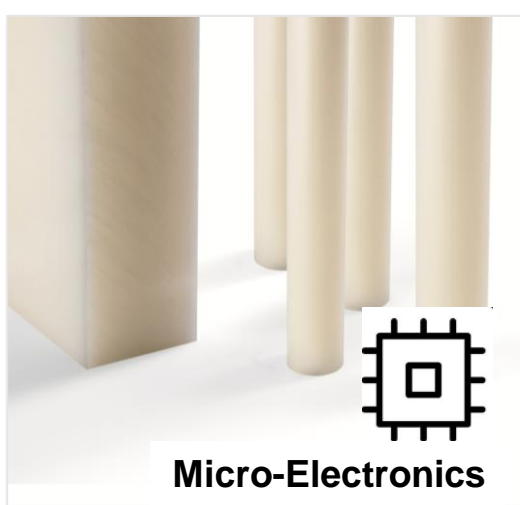
CUSTOMER SOLUTIONS



Consumer Goods



Sustainable Materials



Micro-Electronics

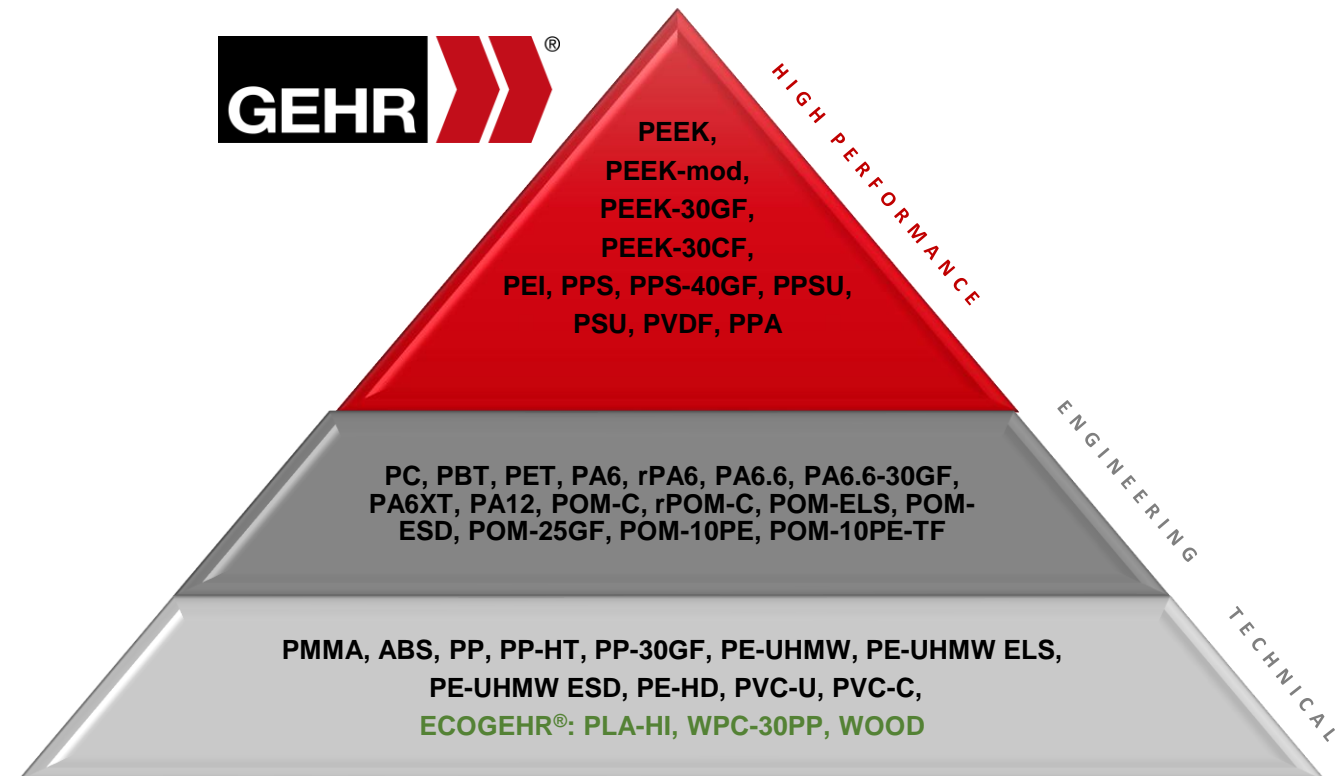
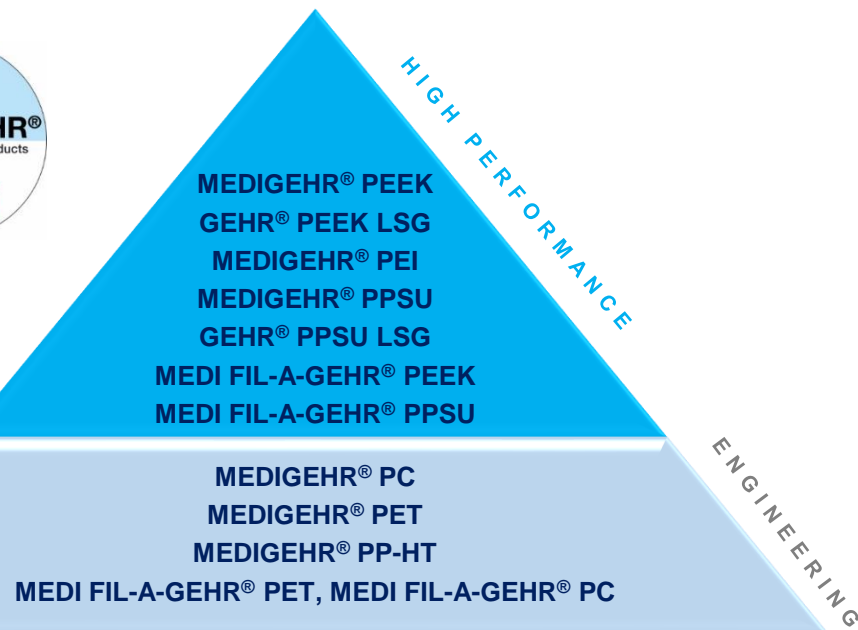


Made to Order

# » GEHR EXPERTISE

**EXTRUDED RODS, SHEETS, TUBES,  
PROFILES AND FILAMENTS**

- » Rods up to 700 mm diameter
- » Thick plates up to 300 mm thickness
- » Calendered sheets from 1 mm
- » Decorative precision tubes
- » Semi-finished products for medical applications
- » Filaments for professional 3D printing



# ENVIRONMENTAL PROTECTION AND SUSTAINABILITY

## CO<sub>2</sub>-NEUTRAL PRODUCTION

- Conversion to green electricity and green gas in Mannheim and Philadelphia.
- Achievement of the implementation packages of Katowice Scope1 and Katowice Scope1 and 2

## SINCE 2016: 100% RENEWABLE ELECTRICITY

Since 2016, total electricity requirements covered by renewable energies - mainly from hydropower in Norway.

## COOLING PROCESS OPTIMIZED

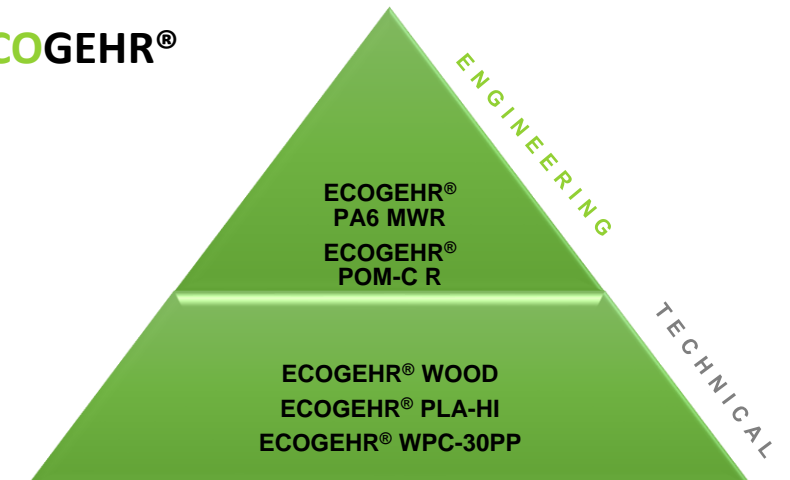
In order to sustainably conserve water as a resource, we have also made mechanical adjustments to our plants. This has enabled us to significantly reduce the amount of water required in the cooling system as well as the supply of fresh water.

## RECYCLING CONCEPT FOR THE AVOIDANCE OF PRODUCTION WASTE

The returned material is sorted, ground, recycled and reused in production wherever possible and permitted.



**ECOGEHR®**



# » SUSTAINABILITY REPORT 2024

## CERTIFICATIONS

- » ISO 9001, ISO 13485, ISO 14001, ISO 50001, ISO 45001
- » ISCC Plus
- » ECOVADIS Rating 2023: Silver



## CORPORATE PHILOSOPHY

- » Long-term independence
- » Extensive sustainable portfolio
- » Quality leadership
- » Innovation
- » Corporate social responsibility in terms of sustainable management, CSR responsibility

## REDUCTION OF ENERGY CONSUMPTION

Since 2013 10% reduction of energy per kg extruded material thru:

- » new efficient extruders
- » optimized annealing processes
- » new compressed air systems
- » energetic refurbishment of buildings
- » new photovoltaic system to be installed in 2023 that will cover approx. 15% of demand

## SOCIAL RESPONSIBILITY

- » Below industry average for „1000-man quota“ (accident rate per 1000 full-time workers)
- » Cooperation with the University of Mannheim
- » Flexible working hours / mobile working stations
- » Sponsoring local sport events / teams

## RECYCLING

- » Recycling rate increased to 7,8%
- » Reduced scrap rate by 2%
- » Strategic partnership with plastic recovery company

## LIFECYCLE ASSESSMENT

- » Status Quo carbon footprint analysis based on GHG protocol
- » Currently emissions are 2145t CO<sub>2</sub> eq.

## GREENHOUSE GAS EMISSIONS

- » Scope 1: 7%      Scope 2: 1%      Scope 3: 92%
- » **Reduction of 30% in 2024** (compared to 2023)

## ACCOMPLISHED ACTIONS

- » **ECOGEHR®** & **ECO FIL-A-GEHR®**
- » Since 2016: green electricity
- » Since 2020: green gas
- » ECOVADIS Rating 2022/2023/2024: Silver
- » ISCC+ biocircular PP for writing instruments
- » Member of Mannheim climate protection alliance

## CORPORATE GOVERNANCE

- » Corporate Environment, culture, leadership
- » Dealing with business partners, customers, suppliers
- » Supply chains
- » Anti Trust, compliance, confidentiality
- » Whistleblowing

## MOBILITY OF THE FUTURE

## TUM HYPERLOOP

In collaboration with TU Munich and Evonik, we are ensuring that the Hyperloop project moves into the next phase. Hyperloop - originally developed as the Space X Hyperloop concept by Elon Musk - is a new concept for transporting goods and people at almost the speed of sound. The train travels like a maglev train in a low-pressure tube above the earth's surface.



In this team, we produced sheets made of VESTAMID® (PA12 filled with glass fibers + special additive) for a 24-m-long test track. After extrusion, these sheets are machined before installation to hold the magnetic coils in position for the train.

SOLUTIONS ENGINEERED BY



**EVONIK**  
Leading Beyond Chemistry

## » GENERAL INFORMATION ABOUT FIL-A-GEHR®

- » Extremely close tolerances
- » Filaments made of high-quality raw materials
- » Compatible with all standard 3D printers
- » Low-emission and odour free
- » Shrinkage-free
- » Good layer adhesion
- » Optimal flow behavior while printing
- » Carefully spooled and packed in easy to use re-sealable zip bags

### PRODUCT RANGE:

- » Diameter: 1.75, 1.80 and 2.85 mm
- » Spools from 200g up to 10kg (Standard: 1kg)



# FIL-A-GEHR® SHOP



FIL-A-GEHR®

Q ⓘ 🇬🇧 🛒 €0.00 \*





FILAMENTS BY GEHR  
WE ENGINEER HIGH  
PERFORMANCE FILAMENTS.



FILAMENTS MADE IN GERMANY  
FIL-A-GEHR Presentation

» OUR PRODUCTS



FILTER <span>▼</span>		SORTING Productname <span>▼</span>	
	<b>ECO-FIL-A-GEHR PLA</b>  ECO-FIL-A-GEHR PLA® is made by NatureWorks and consists of high-quality Ingeo™ biopolymer. It stands out for its great dimensional stability, its high level of stiffness as well as its high elastic modulus. Longterm tests have shown...		<b>FIL-A-GEHR ABS</b>  FIL-A-GEHR ABS is a high-quality thermoplastic polymer with excellent mechanical properties. Aftertreatment or surface treatment can easily be applied to components made of FIL-A-GEHR ABS. The components are specifically suitable for the...
	€16.80 *		From €20.50 *
	<b>FIL-A-GEHR PA 12</b>  Compared to other polyamides, FIL-A-GEHR PA 12 has the lowest moisture absorption. The very low tendency to warping combined with very good layer adhesion and low processing temperature makes PA 12 an ideal material for 3D printing... Content 1 Kilogramm		<b>FIL-A-GEHR PA12 CF15</b>  FIL-A-GEHR PA 12-CF15 is a 15 percent carbon fiber reinforced filament that achieves very high mechanical strength with low water absorption. Furthermore, the filament is characterized by very high rigidity and impact strength. This...
	€45.01 *		€83.57 *

[Filament | FIL-A-GEHR SHOP \(filagehr.com\)](https://filagehr.com)

# » TECHNICAL DATASHEETS FIL-A-GEHR®

## FIL-A-GEHR®

Filaments for professional 3D printing



» PEEK

The semi-crystalline polyether ether ketone **FIL-A-GEHR® PEEK** offers outstanding mechanical, thermal and chemical resistance. Thanks to its well-balanced property profile, PEEK is one of the most capable high-performance thermoplastics available.

### FEATURES FIL-A-GEHR®

- » Highest precision in diameter and roundness
- » Filaments made of high-quality raw materials
- » Compatible with all open-system 3D printers
- » Low-emission and odour free
- » Void-free
- » Good layer adhesion
- » Ideal flow behaviour while printing
- » Carefully spooled and packed in easy to use aluminium-laminated resealable zip bags

### PRODUCT RANGE

diameter	1 kg spool (~2.2 lbs)
1.75 mm	●
0.07"	

Colours: ● natural



### DISTINCTIVE FEATURES FIL-A-GEHR® PEEK

- » Excellent combination of strength, stiffness and toughness
- » Low moisture absorption
- » Exceptional chemical resistance
- » Maximum continuous operating temperature 260 °C
- » Excellent sterilisation and hydrolysis resistance
- » Self-extinguishing, low smoke emission
- » Pressure nozzle temperature 375°C, printing plate temperature 180°C
- » Printing room temperature 180°C

### TYPICAL APPLICATIONS

- » Aviation
- » Transport
- » Oil and gas (supporting rings and supply lines)



### GEHR, Specialist In Plastics – Premium Quality Since 1932

We extrude thermoplastic semi-finished materials and rank amongst the global leading producers of technical semi-finished products. FIL-A-GEHR® expands our product range with plastic filaments for 3D printers. GEHR produces the filaments in Mannheim and has been representing innovation and premium quality since 1932.

### TECHNICAL DATA FIL-A-GEHR® PEEK

Properties	Parameters	Units	Values
<b>General Properties</b>			
Specific gravity ( $\rho$ )	ISO 1183	g/cm <sup>3</sup>	1.32
Water absorption	ISO 62	%	0.
Moisture	ISO 62	%	0.07
Maximum permissible service temperature	UL746B	°C	260
Lower permissible service temperature	UL746B	°C	-40

<b>Mechanical Properties</b>			
Tensile strength at yield ( $\sigma_y$ )	ISO 527	MPa	115
Elongation at yield ( $\epsilon_y$ )	ISO 527	%	7
Tensile strength at break ( $\sigma_R$ )	ISO 527	MPa	67
Elongation at break ( $\epsilon_R$ )	ISO 527	%	16
Impact strength ( $a_k$ )	ISO 179	kJ/m <sup>2</sup>	no break
Notch impact strength ( $a_k$ )	ISO 179	kJ/m <sup>2</sup>	4
Ball indentation ( $H_k$ ) / Rockwell hardness	ISO 2039-1	N/mm <sup>2</sup>	250 / M 99
Shore-D	ISO 868		90
Flexural strength ( $\sigma_{B, 3.5\%$ )	ISO 178	MPa	170
Modulus of elasticity ( $E_t$ )	ISO 527	MPa	4210

<b>Thermal Properties</b>			
Vicat-softening point (VST/B/50)	ISO 306	°C	250
Heat deflection temperature (HDT/B)	ISO 75	°C	240
Coef. of linear thermal expansion ( $\alpha$ )	ISO 11359	K <sup>-1</sup> ·10 <sup>-4</sup>	0.47
Thermal conductivity at 20 °C ( $\lambda$ )	ISO 22007-4	W/(m·K)	0.25
Glass transition temperature ( $T_G$ )	ISO 3146	°C	143
Melting temperature ( $T_m$ )	ISO 3146	°C	340

<b>Printing Properties</b>			
Pressure nozzle temperature		°C	370-410
Printing plate temperature		°C	130-140
Build chamber temperature		°C	>80
Nozzle diameter	(hardend steel)	mm	0.40
Print speed		mm/s	50
Fan speed	(activated on layer 4)	%	50
Predrying temperature		°C	120
Predrying time		h	8

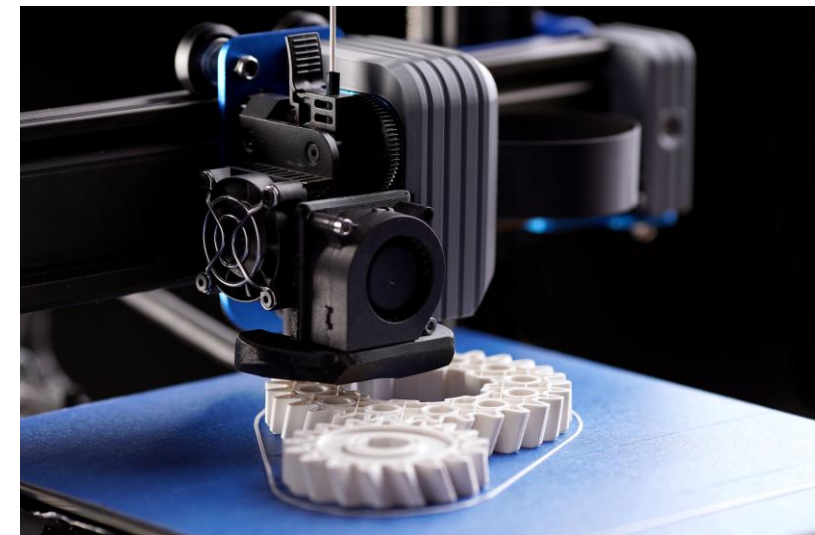
All properties are measured under laboratory conditions using the analytical method shown. The limits in these specifications apply only to data obtained using the specified test methods. Different analysis methods or analysis conditions can lead to different values.

## » FIL-A-GEHR® MATERIALS

- » ECO FIL-A-GEHR® PA6 MWR ●
- » ECO FIL-A-GEHR® Wood ●
- » FIL-A-GEHR® PPSU ● ●
- » ULTEM™ AM1010F FILAMENT (PEI) ●
- » ULTEM™ 9085 FILAMENT (PEI) ● ●
- » FIL-A-GEHR® PEEK ●
- » MEDI FIL-A-GEHR® PEEK MG ●
- » MEDI FIL-A-GEHR® PPSU MG ●
- » MEDI FIL-A-GEHR® PC MG ⊕
- » MEDI FIL-A-GEHR® PET MG ⊕ ○

### Support filaments:

- » LNP™ ELCRES™ AMS9085 Support for ULTEM™ FILAMENT ○



## » FIL-A-GEHR® FOOD CONTACT SUITABLE

Material	EU 10/2011 EU1245/2020	FDA
FIL-A-GEHR® PEEK	✓	✓
FIL-A-GEHR® PPSU	✓	✓
ULTEM™ AM1010F FILAMENT (PEI)	✓	✓
ULTEM™ 9085 FILAMENT (PEI)	✓	✓
ECO FIL-A-GEHR® Wood	✓	✓
ECO FIL-A-GEHR® PA6 MWR	—	—
MEDI FIL-A-GEHR® PEEK MG	✓	✓
MEDI FIL-A-GEHR® PPSU MG	✓	✓
MEDI FIL-A-GEHR® PC MG	✓	✓
MEDI FIL-A-GEHR® PET MG	✓	✓



## » ECO FIL-A-GEHR® Wood

» **ECO FIL-A-GEHR® Wood** consists of recycled wood fibers mixed with a recycled biopolymer. The raw material is made by Sulapac®. The printed material is haptic, visual and odor like wood. Nevertheless, it can be used to print extremely robust / stable parts.

- » Filaments made of high-quality and renewable raw materials
- » Haptic, visual and odor like wood
- » Food contact approval on the raw material
- » High dimensional stability
- » High modulus of elasticity
- » Pressure nozzle temperature 210°C, printing plate temperature 60°C

### APPLICATION:

- » Cosmetic jar
- » Decorative components
- » Sustainable Displays

### PRODUCT RANGE:

- » Colour: Natural
- » Diameter: 1,75 mm and 2,85 mm
- » Size: 1 kg





## **ECO FIL-A-GEHR® PA6 MWR**

» **ECO FIL-A-GEHR® PA6 MWR** is made from marine waste recyclates (MWR). This is mainly obtained from fishing nets.

- » Good mechanical properties
- » Shrinkage values of approx. 0.3%
- » Very good tribological properties
- » High resistance to impacts, scratches and cracks
- » Resistance to many chemicals
- » Pressure nozzle temperature 260-280°C
- » printing plate temperature 80°C
- » Dry box highly recommended

### APPLICATION:

- » Automotive industry
- » Gear wheels
- » Sliding rails

### PRODUCT RANGE:

- » Colour: Natural
- » Diameter: 1,75 mm and 2,85 mm
- » Size: 1 kg





## » **FIL-A-GEHR® PPSU**

**FIL-A-GEHR® PPSU** is an amorphous material, with improved impact and hydrolysis resistance compared to PSU and PEI. The extremely high notch impact strength remains also after a heat aging.

- » High strength and rigidity
- » Very high toughness (also at low temperatures)
- » Very good dimensional stability
- » Very high chemical resistance
- » High operating temperature (approx. +170 °C)
- » Very good sterilizability
- » Pressure nozzle temperature 390-410°C, printing plate temperature 220°C
- » Printing room temperatur 170-210°C

### **APPLICATIONS:**

- » Instruments for microinvasive surgery
- » Pump impellers, pump parts
- » Sterilization cassettes
- » Valves

### **PRODUCT RANGE:**

- » Colours: Black, natural
- » Diameter: 1,75 mm
- » 1 kg Spools

## » ULTEM™ AM1010F FILAMENT (PEI)

**ULTEM™ AM1010F FILAMENT (PEI)** is a polyetherimide product for 3D printing applications manufactured from ULTEM™ 1010 resin.

- » Excellent combination of high heat resistance and dimensional stability
- » High mechanical strength
- » Continuous service temperature 170 °C
- » High heat resistance
- » Inherently flame retardant (UL94-V0)
- » Print nozzle temperature 370-390°C
- » Pressure plate temperature 150°C
- » Pressure chamber temperature 90°C

### PRODUCT RANGE:

- » Colour: Natural
- » Diameter: 1,75 mm, 1,80mm
- » 1 kg (1,75mm) or 92ci (1,80mm) spools

### APPROVALS OF THE RAW MATERIAL:

- » Aerospace FAR25.853





## » ULTEM™ 9085 FILAMENT (PEI)

**ULTEM™ 9085 FILAMENT (PEI)** is a high-performance filament based on the well-known raw material ULTEM™ 9085.

- » Excellent combination of high heat resistance and mechanical strength.
- » High dimensional stability
- » Continuous service temperature 170 °C
- » Resistant to high-energy radiation
- » Inherently flame retardant (UL94-V0)
- » Print nozzle temperature 360°C
- » Pressure plate temperature 160°C
- » Pressure chamber temperature 90°C

### APPLICATIONS:

- » Rail
- » Aerospace
- » Automotive

### PRODUCT RANGE:

- » Colour: Natural and black
- » Diameter: 1,75 mm, 1,80mm
- » 1kg and 2kg (1,75mm) or 92ci (1,80mm) spools

### APPROVALS OF THE RAW MATERIAL:

- » Aerospace FAR25.853 and OSU55/55
- » Rail EN45545 R6-HL3





## » LNP™ ELCRES™ AMS9085 Support for ULTEM™ FILAMENT

**LNP™ ELCRES™ AMS9085 Support** is SABIC's breakaway support filament for use with ULTEM™ 9085 filament. The material maintains rigidity during printing and provides exceptional pliability during post processing to help enable easier removal of structural supports at room temperature, which can reduce the time required to produce finished parts. AMS31F and ULTEM™ 9085 PEI filaments are compatible with Stratasys® Fortus® Classic printers and open format industrial printers, subject to user testing.

- » Print nozzle temperature 380-420°C
- » Pressure plate temperature 160-185°C
- » Pressure chamber temperature 90-110°C

### PRODUCT RANGE:

- » Colour: Natural
- » Diameter: 1,75 mm, 1,80mm
- » 1 kg (1,75mm) or 92ci (1,80mm) spools



## » **FIL-A-GEHR® PEEK**

The semi-crystalline polyether ether ketone **FIL-A-GEHR® PEEK** offers outstanding mechanical, thermal and chemical resistance. Thanks to its well-balanced property profile, PEEK is one of the most capable high-performance thermoplastics available.

- » Excellent combination of strength, stiffness and toughness
- » Low moisture absorption
- » Exceptional chemical resistance
- » Maximum continuous operating temperature 260 °C
- » Excellent sterilisation and hydrolysis resistance
- » Self-extinguishing, low smoke emission
- » Pressure nozzle temperature 375°C, printing plate temperature 180°C
- » Printing room temperatur 180°C

### **APPLICATIONS:**

- » Aviation
- » Transport
- » Oil and gas (supporting rings and supply lines)

### **PRODUCT RANGE:**

- » Colour: Natural
- » Diameter: 1,75 mm
- » 1 kg Spools



## » MEDIFIL-A-GEHR®

**MEDIFIL-A-GEHR®** products are suitable for medical and pharmaceutical applications with direct body contact with tissue, bone, skin and mucosa for up to 24 hours. All materials meet the same requirements as the semi-finished products. Especially for our certificates and approvals:

**FDA\*, EU 10/2011\*, ISO 10993-1, -5, -12, -18 and USP Class VI**

\* only for raw material

### MATERIALS:

- » **MEDIFIL-A-GEHR®** PET MG (white and transparent)
- » **MEDIFIL-A-GEHR®** PC MG
- » **MEDIFIL-A-GEHR®** PPSU MG
- » **MEDIFIL-A-GEHR®** PEEK MG



**MEDIFIL-A-GEHR®** PPSU MG  
Arthroscope prototype



**MEDIFIL-A-GEHR®** PEEK MG  
Instrument holder prototype

## **CONTACT US**

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