



| SUGGESTED PRINT SETS (1) | | | |
|---------------------------------|-------------------|---------|-------------|
| Suggested print sets | unit | value | test method |
| extruder temp | C° | 250/270 | internal |
| plate temp | C° | 90 | internal |
| min. nozzle diameter | mm. | 0,4 | internal |
| fan | % | 0 | internal |
| print speed | mm/l° | 30-60 | internal |
| PROPERTY | | | |
| Physical | | | |
| Specific gravity | g/cm3 | 1.36 | ISO 1183 |
| Mechanical | | | |
| Tensile stress, break, 5mm/min. | MPa | 78 | ISO 527 |
| Tensile modulus | MPa | 6100 | ISO 527 |
| Flexural modulus 1mm/min | MPa | 6000 | ISO 178 |
| Impact | | | |
| Charpy impact (23°C) | kJ/m ² | 16 | ISO 179 TeA |
| Charpy impact (-30°C) | kJ/m ² | 8 | ISO 179 TeA |
| Thermal | | | |
| Thermal conductivity | W/m-°C | 0,20 | ISO 8302 |
| H.D.T. 0,45 MPa | °C | 156 | ISO 75- Be |
| H.D.T. 1.8 MPa | °C | 120 | ISO 75-Ae |

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ADDITIONAL INFORMATIONS

In General filaments made with PCPBT GF can be processed on conventional 3D printer using FDM / FFF technology.

PCPBT GF is a special polymer alloy developed for 3D printing and to obtain best results we recommend pre drying the filaments at 85° for 2 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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