

Main features

Low warpage

Impact resistance

Low water absorption

High-strength and stiffness parts with low creep

Physical properties

Physical properties	Test method	Specimen	Units	Typical value
Specific gravity	ISO 1183		g/cm ³	1.44
Water absorption	ISO 62		%	0.15

Mechanical Properties at 23°C

Tensile strength

Tensile modulus

ISO 527-2/1

MPa

8500

Impact strength

Impact strength notched

ISO 180/1A

Kj/m²

10

Flexurtal modulus

ISO 178

MPa

7750

Flexurtal strength

Flexural elongation F. max.

Elongation F. max.

Thermal properties

Heat distortion temperature

ISO 306/B120

°C

150

Continuous service temperature

Electrical properties

Insulation resistance

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SUGGESTED PRINT SETS (I)

Suggest 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

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.

(I) 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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