



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	220-240	internal
plate temp	C°	90-110	internal
min. nozzle diameter	mm.	0,35	internal
fan	%	0-20	internal
print speed	mm/l°	60-70	internal
PROPERTY			
Physical			
Water absorption	%	0,2	ISO 179
Mechanical at 23°C / 50% rh			
Tensile modulus	MPa	2500	ISO 527
MFR	g/10 min	4	ISO 1133
Charpy impact (23°C)	ft · lb/in <sup>2</sup>	8	ISO 179
Charpy impact (-30°C)	ft · lb/in <sup>2</sup>	3	ISO 179
Thermal			
Vicat softening temp.	°C	102	ISO 96

### Disclaimer

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### ADDITIONAL INFORMATIONS

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

All parameters are concerned for: Monumental, Clay, Sandy, Dark Stone, Ceamentum and Heritage Brick

ARCHITECTURAL is a dedicated polymer blend developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° 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 190°, 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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