



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	240-260	internal
plate temp	°C	90-110	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-20	internal
print speed	mm/l°	50-60	internal
PROPERTY			
Physical			
Specific gravity	g/cm ³	1.1	ISO 1183
Water absorption	%	0.9	23°C / 24 h
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	2000	ISO 527
Charpy notched impact (23°C)	kJ/m ²	50	ISO 179
Charpy notched impact (-30°C)	kJ/m ²	50	ISO 179
Tensile stress	MPa	43	ISO 527-2
Tensile strain (break)	%	80	ISO 527-2
Thermal			
Heat deflection temp.	°C	93	ISO 11357
Vicat softening temp.	°C	108	ISO 306

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with TENAX (PC-ABS) can be processed on conventional 3D printer using FDM / FFF technology.

TENAX (PC-ABS) is a 50/50 polymer alloy developed for 3D printing and to obtain best results we recommend pre drying the filaments at 80° for 3 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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