

SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	235-250	internal
plate temp	C°	70-90	internal
min. nozzle diameter	mm.	0,3	internal
fan	%	0-5	internal
print speed	mm/l°	30-40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.22	ISO 1183
Mechanical			
Tensile modulus	MPa	2050	ISO 527
Tensile stress at Yield	MPa	52	ISO 527
Tensile strain at Yield	%	44	ISO 527
Flexural modulus	MPa	2050	ISO 527
Charpy impact (23°C)	kJ/m <sup>2</sup>	25	ISO 179
Charpy impact (-30°C)	kJ/m <sup>2</sup>	20	ISO 179
Thermal			
Vicat softening temp.	°C	155	ISO 306
HDT-Be	°C	105	ISO 75
Electrical			
Volume resistivity	Ohm-cm.	>1.E+14	IEC 60093
Flame characteristic			
UL compliant , 94 HB	mm.	1,5	UL94

### Disclaimer

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### ADDITIONAL INFORMATIONS

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

PC-PBT is a special compound developed for 3D printing, to obtain best results we recommend pre drying the filaments at 80° for 2-4 hours. Increase drying time for spools 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. if that down the temperature under 200°, 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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