



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	230-250	internal
plate temp	C°	30-60	internal
min. nozzle diameter (2)	mm.	0.5	internal
fan	%	0	internal
print speed	mm/l°	40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1,4	ISO 1183
Water absorption at equilibrium	%	<0,3	23°C / 24 h
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	80	ISO 527
Elongation	%	2,5	ISO 527
Modulus of elasticity	GPa	9	ISO 527
Flexural strength	MPa	130	ISO 178
Flexural elongation at max. force	%	3,5	ISO 178
Flexural modulus	GPa	8	ISO 178
Charpy impact strength	kJ / m2	40	ISO 179 1eU
Thermal			
Service temp.	°C	125	lifetime max. 200h

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with CA PET (pet carbon) can be processed on conventional 3D printer using FDM / FFF technology.

CA PET is a pet carbon fiber reinforced developed for 3D printing and to obtain best results we recommend pre drying the filaments at 120° for 4-6 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 .

(2) 0.5 mm is the mininum diameter of the nozzle with carbon fibers reinforced.
Carbon fibers are abrasive, we suggest to use a nozzle in hardened or tempered metal, like Widia, or wear resistance internal surface, like ceramics or other.
NO tefloned surface!

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