

PRODUCT NAME: 3D FILAMENT PCTG+CF10 1,75mm

PRODUCT DESCRIPTION: Refill PCTG+CF10 filament is co-polyester with 10% of carbon fiber additive, designed for 3D printing using the FFF/FDM method. Filament coiled on spool or cardboard core (no spool) on paper core, vacuum-packed with desiccant in a PA/PE bag, and then in a box. Main attributes: improved stiffness, high impact strength, high chemical resistance.

STORAGE: Store in dry area. Store in a closed container.

PRODUCT PARAMETERS

Parameter	Value	
Filament diameter [mm]	1,75	
Diameter tolerance [mm]	+/- 0,05	
Oval tolerance [mm]	+/- 0,02	
Net weight [g]	300	1000 (ReFill)
Weight with packaging [g]	520	1200
Spool weight [g]	Transparent PC: 150	Cardboard core: 30
Spool dimensions [mm] (\varnothing / height / hole \varnothing)	Transp. PC: 160/45/52	Cardboard core: 99/57/94
Box dimensions [mm]	175/164/46	220/210/65

RECOMMENDED PRINTING PARAMETERS

Parameter	Value
Print temperature [°C]	250-280
Bed temperature [°C]	70-90
Cooling [%]	0-60
Closed chamber	Not required, but recommended for higher impact resistance
Recommended nozzle	Steel
Drying conditions: [°C/h]	60/4

PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,28	g/cm ³	ASTM D 792
Tensile modulus at Yield	70	MPa	ISO 527-2
Tensile strength at break	65	MPa	ISO 527-2
Izod impact strength (unnotched)	45	kJ/m ²	ISO 180
Izod impact strength (notched)	4	kJ/m ²	ISO 180
HDT (0,455 MPa/ 1,82 Mpa)	77/65	°C	ISO 75

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PCTG+CF10 parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.

