

PRODUCT NAME: 3D FILAMENT PCTG+10GF 1,75mm

PRODUCT DESCRIPTION: 3D filament PCTG+10GF is co-polyester with 10% glass fiber additive, designed for 3D printing using the FFF/FDM method. Filament coiled on spool, vacuum-packed with desiccant in a PA/PE bag, and then in a box. Main attributes: increased stiffness and tensile strength, 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
Weight with packaging [g]	520
Spool weight [g]	Transparent PC: 150
Spool dimensions [mm] (\varnothing / height / hole \varnothing)	Transp. PC: 160/45/52
Box dimensions [mm]	175/164/46

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(\geq 0,5mm)
Drying conditions: [°C/h]	60/4

PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,31	g/cm ³	-
Tensile modulus at Yield	55	MPa	ISO 527
Tensile strength at break	25	MPa	ISO 527
Izod impact strength (unnotched)	60	kJ/m ²	ISO 179-1eU
Elongation at break	8	%	ISO 527
HDT (0,455 MPa/ 1,82 Mpa)	76/64	°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+10GF 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.

