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PC Filament

Technical Data Sheet

Features		Application		
●High toughness ●High strength ●Low warpage ●Good adhesion		● Cultural and creative ● Toys ● Gifts ● Industrial		
Physical	Typical Value	Unit	Method	Test Condition
Density	1.19	g/cm ³	ISO 1183	23°C
Melt Flow Rate	76	g/10min	ISO 1133	300°C/1.2KG

Mechanical	Typical Value	Unit	Method	Test Condition
Tensile Strength	61	MPa	ISO 527	50mm/min
Elongation at Break	4.5	%	ISO 527	50mm/min
Flexural Strength	95	MPa	ISO 178	5mm/min
Flexural Modulus	2500	MPa	ISO 178	5mm/min
Unnotched Izod Impact Strength	45	KJ/m ²	ISO 180	23°C

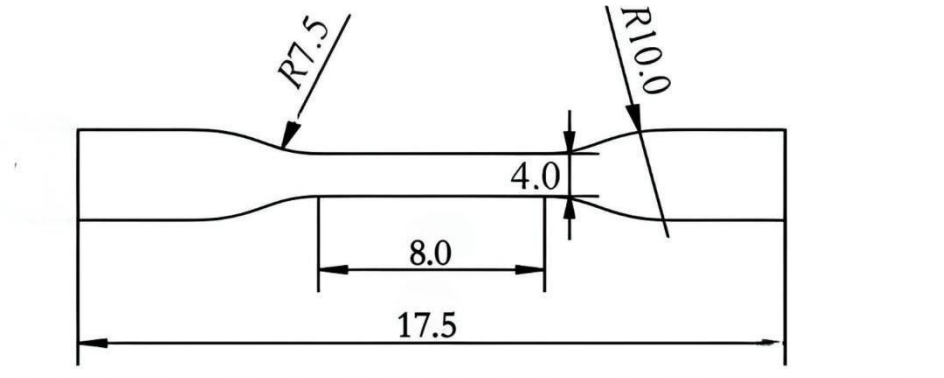
Thermal	Typical Value	Unit	Method	Test Condition
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Melting Temperature	220	°C	DSC	10°C/min
Heat Deflection Temperature	130	°C	ASTM D648	120°C/h, 0.45MPa
Printing Temperature	240-260	°C	/	/
Bed Temperature	100-110	°C	/	/

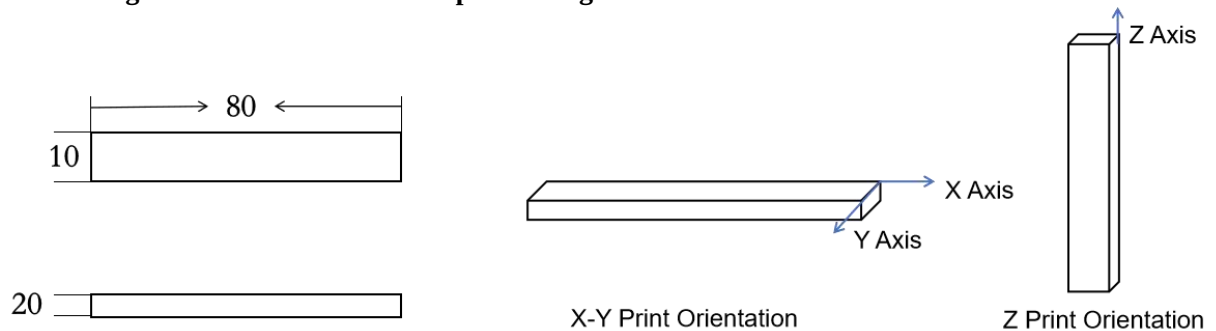
Notice The data contained in this document is based on trials carried out by our Research Centers. Properties are dependent upon process conditions and machine used, so these figures are only given for information.

Testing Model and Printing Parameters

1.1 Tensile Strength



1.2 Flexural Strength and Unnotched Izod Impact Strength



1.3 Printing parameters

Printing parameters	Data
Nozzle Printing temperature	250°C
Plate Temperature	100°C
Printing Speed	100 mm/s
Infill Density	100%

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