



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	230-250	internal
plate temp	C°	90-110	internal
min. nozzle diameter	mm.	0,35	internal
fan	%	0-25	internal
print speed	mm/l°	60-70	internal
PROPERTY			
Physical			
Density	g/cm ³	1.14	ASTM D792
Mechanical at 23°C / 50% rh			
Tensile strength at yield	kg/cm ²	428	ASTM D638
Flexural modulus	kg/cm ²	20.500	ASTM D790
IZOD impact strength (23°C)	kg · cm/cm	41	ASTM D256
IZOD impact strength (-30°C)	kg · cm/cm	5.5	ASTM D256
Thermal			
Vicat softening temp.	°C	96	ASTM D1525
Heat deflection	°C	100	ASTM D648

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with ARCHITECTURAL EVO can be processed on conventional 3D printer using FDM / FFF technology.

All parameters are concerned for: Monumental, evolution and Clay evolution

ARCHITECTURAL EVO is a dedicated polymer blend developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 2 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 190°, 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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