### SUGGESTED PRINT SETS (I)

<table>
<thead>
<tr>
<th>Suggested print sets</th>
<th>unit</th>
<th>value</th>
<th>test method</th>
</tr>
</thead>
<tbody>
<tr>
<td>extruder temp</td>
<td>°C</td>
<td>230-250</td>
<td>internal</td>
</tr>
<tr>
<td>plate temp</td>
<td>°C</td>
<td>90-110</td>
<td>internal</td>
</tr>
<tr>
<td>min. nozzle diameter</td>
<td>mm.</td>
<td>0.35</td>
<td>internal</td>
</tr>
<tr>
<td>fan</td>
<td>%</td>
<td>0-25</td>
<td>internal</td>
</tr>
<tr>
<td>print speed</td>
<td>mm/1°</td>
<td>60-70</td>
<td>internal</td>
</tr>
</tbody>
</table>

### PROPERTY

#### Physical
- **Density**
  - g/cm³: 1.14, ASTM D792

#### Mechanical at 23°C / 50% rh
- **Tensile strength at yield**
  - kg/cm²: 428, ASTM D638
- **Flexural modulus**
  - kg/cm²: 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

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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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