



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	235-255	internal
plate temp	°C	90-110	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-20	internal
print speed	mm/l°	50-60	internal
PROPERTY			
Physical			
Specific gravity	g/cm <sup>3</sup>	1,2	ISO 1183
Water absorption	%	0.15	23°C / 24 h
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	2340	ISO 527
Tensile stress at break	MPa	71	ISO 527
Charpy impact (23°C)	kJ/m <sup>2</sup>	no break	ISO 179
Charpy impact (-30°C)	kJ/m <sup>2</sup>	no break	ISO 179
Hardness	shore M	72	ASTM D785
Thermal			
Melting point	°C	220	ISO 11357
Vicat softening temp.	°C	96	ISO 306

### Disclaimer

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### ADDITIONAL INFORMATIONS

In General filaments made with P51 (polycarbonate) can be processed on conventional 3D printer using FDM / FFF technology.

P51 is a polycarbonate developed for 3D printing and to obtain best results we recommend pre drying the filaments at 85° for 3 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 210°, 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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