

## FIL-A-GEHR PC/ABS®

### Filaments for professional 3D printing

#### Technical Data

|                                             |                             |
|---------------------------------------------|-----------------------------|
| Melt volume rate<br>ISO 11357 260 °C / 5 kg | 18 cm <sup>3</sup> / 10 min |
| Tensile Stress at Yield<br>ISO 527          | 54 Mpa                      |
| Tensile Modulus<br>ISO 527                  | 2400 Mpa                    |
| Density<br>ISO 1183                         | 1130 kg / m <sup>3</sup>    |
| Water absorption<br>similar ISO 62          | 0,7 %                       |
| Drying                                      | ca. 4 h<br>100-110 °C       |

Data based on raw material



#### Printing Recommendations

|                            |                |
|----------------------------|----------------|
| Optimal Nozzle Temperature | 280 °C         |
| Bed Temperature            | 90 - 110 °C    |
| Bedrock                    | Pertinaxplatte |

#### Tensile Test ISO 527, Interlayer Adhesion

| Material                 | Orientation of test specimen (tensile bar) in build chamber | Tensile Strength | Tensile Modulus |
|--------------------------|-------------------------------------------------------------|------------------|-----------------|
| FIL-A-GEHR PC/ABS® black | z-direction                                                 | 18,3             | 2347            |
| FIL-A-GEHR PC/ABS® black | xy-direction                                                | 44,7             | 2237            |

To determine the FIL-A-GEHR PC/ABS® data, ISO 527 tensile test specimen were printed on a EVOTECH printer with the following parameters: T<sub>Print</sub> 280 °C, T<sub>Bed</sub> 90 °C, printing speed 55 mm/s, Slicer Simplify3D