

Technical data sheet- HOMECOMPOST-3D filament

Printing features	Settings
Extrusion temperature	170 to 250°C
Bed temperature	0 to 250°C
Bed type	Mirror and Builtak
Bed surface treatment	None
Chamber temperature	Ambient temperature
Ventilation	0% to 170°C 0% for first layers at 180°C then 100%
Printing speed	50 to 70 mm/sec
Shrinkage speed	40 mm/sec
Shrinkage distance	Min.1 mm
Min. 3D printing skills	For all levels

Printing may vary between printers and printheads

Recommendations :

- Ideal extrusion temperature of 170° without cooling or 180° with 100% cooling from the 2nd layer
- Respect melting temperature of 170°- 180° to avoid stringing
- Use a printer with a direct-drive extruder to pull rather than push the material

THESE VALUES ARE INDICATIVE AND MAY VARY

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Mechanical Properties	Test Standard *	Unit	Typical Value	Remarks
Tensile modulus	ISO 527	MPa	1300	Tensile modulus measured with a testing speed of 1 mm/min
Tensile strength	ISO 527	MPa	23	After the measurement of the tensile modulus, the test speed was increased during the current measurement to a value of 50 mm/min
Strain at tensile strength	ISO 527	%	8	
Tensile stress at yield	ISO 527	MPa	23	
Tensile strain at yield	ISO 527	%	8	
Tensile stress at break	ISO 527	MPa	12	
Tensile strain at break	ISO 527	%	126	
Charpy impact strength (23 °C)	ISO 179/1eU	kJ/m ²	NB	If the break occurs only partially or if there is no break at all, it will be expressed by "PB" (Partial Break) or by "NB" (No Break)
Charpy notched impact strength (23 °C)	ISO 179/1eA	kJ/m ²	PB	
Rheological Properties	Test Standard *	Unit	Typical Value	Remarks
MVR (190 °C / 2,16 kg)	ISO 1133	cm ³ /10 min	2	-
MVR (230 °C / 2,16 kg)	ISO 1133	cm ³ /10 min	-	-
Thermal Properties	Test Standard *	Unit	Typical Value	Remarks
HDT / B	ISO 75	°C	47	-
VST A 120	ISO 306	°C	77	-
Other Properties	Test Standard *	Unit	Typical Value	Remarks
Hardness	ISO 7619	Shore A	-	-
Hardness	ISO 7619	Shore D	-	-
Shrinkage	CS	%	0,6	CS: Company Standard
Density	CS	g/cm ³	1,28	CS: Company Standard