

# Technical data sheet –3D PETG Carbone filament

Printing Features	Settings
Extrusion temperature	240 to 250°C
Bed temperature	70 to 250°C
Bed type	Perforated or mirrored
Bed surface treatment	Dimafix on mirror
Chamber temperature	Ambient temperature
Ventilation	0% - 100% for bridges
Printing speed	40 to 60 mm/sec
Shrinkage speed	80 mm/sec
Shrinkage distance	Min.1 mm
Min. 3D printing skills	For all levels

Printing may vary between printers and printheads

## Recommendations :

- This filament is brittle due to the fibre content so we recommend using a printer with a direct-drive extruder that pulls the material rather than pushes it to avoid breaking.
- Use reinforced steel nozzles to avoid wear on brass nozzles caused by the carbon fibres.

## **THESE VALUES ARE INDICATIVE AND MAY VARY**

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<b>PHYSICAL PROPERTIES - Typical values</b>	<b>STANDARDS</b>	<b>SI UNITS</b>
Density	ISO 1183	1.32 g/cm <sup>3</sup>
<b>MECHANICAL PROPERTIES - Typical values</b>		
<b>CHARPY impact strength (sample 80x10x4 mm)</b>		
Unnotched, at +23°C	ISO 179-1eU	50 kJ/m <sup>2</sup>
Notched, at +23°C	ISO 179-1eA	6 kJ/m <sup>2</sup>
<b>Tensile elongation (speed 5 mm/min)</b>		
At break	ISO 527 (1)	4.5 %
<b>Tensile strength (speed 5 mm/min)</b>		
At break	ISO 527 (1)	95 MPa
<b>Elastic modulus</b>		
Tensile (speed 1 mm/min)	ISO 527 (1)	8800 MPa