

## THE FILAMENT PLA CF

## MATERIAL PROPERTIES

## Physical

Specific Gravity	1.25 g/cm <sup>3</sup>	D 792
MFR	4 g/10min (190°C, 2.16kg)	D 1238

## Mechanical Properties

Tensile Strength at Yield	57.5 MPa	ISO 527
Tensile Strength at Break	14.2 MPa	ISO 527
Impact strength - Charpy method	3.6 kJ/m <sup>2</sup>	ISO 179

## Thermal Properties

Heat Distortion Temperature	55°C	E 2092
Glass Transition Temperature	60°C	D3418

## GUIDELINE FOR PRINT SETTINGS\*

Nozzle temperature	200-230°C
Nozzle temperature (High Speed)	
Bed temperature	35-45°C
Closed chamber for printing	not necessary
Dry box recommended	No
Ruby or hardened nozzle recommended	Yes
Adhesive	not necessary (if increased adhesion needed or to prevent warping: glue stick, Dimafix, 3DLac, Magigoo)
Cooling	Up to 100%
Surface finish	matte, carbon appearance
Features	3% CF for durability and flexibility; optimized formula; beginner-friendly

\* settings are based on a 0,4 mm nozzle.

\*\* depending on the geometrical complexity

## STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.

## SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at [support@spectrumfilaments.com](mailto:support@spectrumfilaments.com)

## Disclaimer

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