



# PET CF

## Property Data

Property	Test Method	Value
Density (g/cm <sup>3</sup> )	ASTM D792	1.4
Water absorption/ %	ISO 62 (23 °C/24hr)	<0.3
Service Temperature (during lifetime max 200 hr)/ °C	*	125
Tensile Strength/ kpsi	ISO 527	11.6
Tensile Elongation/ %	ISO 527	2.5
Modulus of elasticity/ kpsi	ISO 527	1305
Flexural Strength/ kpsi	ISO 178	18.8
Flexural Elongation/ %	ISO 178	3.5
Flexural Modulus	ISO 178	1160
Charpy Impact Strength/ kJ/m <sup>2</sup>	ISO 179	40

## Recommended Printer Settings

Parameter	Value
Nozzle temperature	245 - 270 °C
Heated bed temperature	>50 °C
Speed	40-60 mm/s
Infill	As needed, up to 100 %
Layer thickness	0.2 mm or higher
Nozzle Material	Abrasion resistant
Bed material	PEI, glass with glue stick, PET tape; other typical materials used for nylons should work as well
Drying	70 °C; keep filament in dry, sealed bag/container for storage

*These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters. Generally, slower speeds, larger nozzles and layers are beneficial. PET CF is moisture sensitive, take care to dry and maintain filament and store in a sealed container.*