

**PRODUCT NAME:** 3D FILAMENT PCTG 1,75mm

**PRODUCT DESCRIPTION:** Refill PCTG filament is co-polyester designed for 3D printing using the FFF/FDM method. Filament coiled on Refill for spools (no spool) on paper core, vacuum-packed with desiccant in a PA/PE bag, and then in a box. Main attributes: High transparency, high impact strength, high chemical resistance.

**STORAGE:** Store in dry area. Store in a closed container.

## PRODUCT PARAMETERS

Parameter	Value	
Filament diameter [mm]	1,75	
Diameter tolerance [mm]	+/- 0,05	
Oval tolerance [mm]	+/- 0,02	
Net weight [g]	<b>300</b>	<b>1000 (ReFill)</b>
Weight with packaging [g]	520	1200
Spool weight [g]	Transparent PC: 150	Cardboard core: 30
Spool dimensions [mm] ( $\phi$ / height / hole $\phi$ )	Transparent PC: 160/45/52	Cardboard core: 99/57/94
Box dimensions [mm]	175/164/46	220/210/65

## RECOMMENDED PRINTING PARAMETERS

Parameter	Value
Print temperature [°C]	240-270
Bed temperature [°C]	60-80
Cooling [%]	0-60
Closed chamber	Not necessary, but recommended for improve impact
Drying conditions: [°C/h]	60/4

## PHYSICAL PARAMETERS OF THE MATERIAL

Parameter	Value	Unit	Test method
Density	1,24	g/cm <sup>3</sup>	ASTM D 792
Tensile modulus at Yield	44	MPa	ISO 527-2
Tensile strength at break	46	MPa	ISO 527-2
Flexural Modulus	1,600	Mpa	ISO 178
Flexural Strength	60	Mpa	ISO 178
Izod impact strength (notched)	92	kJ/m <sup>2</sup>	ISO 180
HDT (0,455 MPa/ 1,82 Mpa)	76/64	°C	ISO 75
Hardness Rockwell	105	R-Scale	ASTM D785
Transmittance	<0,1	%	ASTM D1003
Food Contact Approval	-	-	FCA declaration in separate document

The values above have been measured using standard test specimens made of non-colored material at room temperature. The figures should be considered as indicative values only. Actual properties of PCTG parts can be affected by the printing parameters, design of the model, ambient conditions, application of the printout etc. It is essential that users test our products to determine whether they are suitable for their intended use. ROSA PLAST Sp. z o.o. accepts no liability for any health detriment or material losses or any other losses related to the use of the material.



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