

PC-ABS

PC-ABS is an incredibly strong filament with an even higher impact resistance than our regular ABS. This is a consequence of the addition of the proper amount of polycarbonate in this modification, which also creates a nearly perfect interlayer adhesion and a beautiful surface gloss. The above features, combined with a highly stable printing process makes PC-ABS the perfect material for mechanical parts and tools, which should be light and strong and show minimal wear after prolonged use.

Material features:

- Improved interlayer adhesion
- High impact resistance
- High surface gloss
- Stable printing process



Filament specs.

Size	Ø tolerance	Roundness
1,75mm	± 0,05mm	≥ 95%
2,85mm	± 0,10mm	≥ 95%

Material properties

Description	Testmethod	Typical value
Specific gravity	ISO 1183	1,04 g/cc
MFI 240°C/5 kg	ISO 1133	0,47 g/10min
Tensile strength at yield	ISO 527	37,2 MPa
Tensile strength at break	ISO 527	30 MPa
Elongation strain at break	ISO 527	18%
Elongation strain at yield	ISO 527	3%
Tensile (E) modulus	ISO 527	1900 MPa
Impact Strength - Charpy method 23°C	ISO 179	27 kJ/m ²
Printing temp.	Internal method	270±10°C
Melting temp	ISO 294	250±10°C
Heat deflection temp.	ISO 75	108°C

Additional info:

Recommended temperature for heated bed is 100-110°C. We recommend kapton and / or pva glue stick for adhesion. PC-ABS can be used on all common desktop FDM or FFF technology 3D printers.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.

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