

XEGREEN® 23-C20-3DF

20% carbon fiber reinforced PET-G

Material Properties	Test Condition	Standard	Unit	Dam / Cond.
Diameter			mm	1,75
Density		ISO 1183	g/cm ³	1,35
Hardness	Shore D, 15s	ISTR02L	ShD	83

Thermal Properties

Melting point	10 °C/min	ISO 11357	°C	Not applicable
Glass transition temperature	10 °C/min	ISO 11357	°C	75
HDT – heat deflection temperature	1,80 MPa a 120 °C/h	ISO 75	°C	73
Melt Flow Rate	250°C / 2,16kg	ISO 1133	g/10min	11
Melt Volume Rate	250°C / 2,16kg	ISO 1133	cm ³ /10min	9

Suggested Printed Settings

Test Condition	Standard	Unit	Value
Nozzle temperature		°C	230–250
Bed temperature		°C	55–70
Printing speed		mm/s	40
Nozzle type			Steel
Nozzle diameter		mm	>0,6
Bed type			Glass/PEI
Adhesive			Not necessary
Closed chamber			Not necessary

Drying Recommendations

Test Condition	Standard	Unit	Value
Drying temperature	desiccant dryer	°C	Not necessary
Drying time	desiccant dryer	h	Not necessary

Our advice does not release you from the obligation to verify the information currently provided - especially that contained in our safety data and technical information sheets, and to test our products as to their suitability for the intended processes and uses. The application, use and processing of our products and the products manufactured by you on the basis of our technical advice are beyond our control and, therefore, entirely your own responsibility. Our products are sold in accordance with the current version of our General Conditions of Sale and Delivery.

Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the coloring.

Processing note

Under the recommended processing condition small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.

Edition: October 2024