Spectrum FILAMENTS

TECHNICAL DATA SHEET

PC 275

MATERIAL PROPERTIES

Specific Gravity	1.20 g/cm³	D 792
Mechanical Properties		
Tensile Strength at Yield*	630 kg/cm²	D 638
Tensile Elongation at Break*	>100 %	D 638
Flexural Strength**	920 kg/cm²	D 790
Flexural Modulus**	24.000 kg/cm²	D 790
Izod Impact Strength, Notched		
@ 23°C	70 kg•cm/cm	D 256
Thermal Properties		
Heat Deflection Temperature		
0.45mn/m2	139°C	D 648
1.81mn/m2	128°C	D 648
Vicat Softening Temperature	150°C	D 1525

*50mm/min
**15mm/min

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	250 - 290°C
Bed temperature	90 - 130°C
Active cooling fan	0 - 20%
Layer height**	0.05 - 0.30 mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	30 - 200 mm/s
Closed chamber	recommended for larger prints
Dry box	not necessary
Ruby or hardened nozzle	not necessary
Drying (if wet)	recommended***
Adhesive required	YES (Magigoo PC)

* settings are based on a 0.5mm nozzle
** depending on the geometrical complexity
*** at least 5h at 120°C using a hot dry air oven

Disclaimer
The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectum Group Sp. z o.o. materials in any particular application.

DESCRIPTION

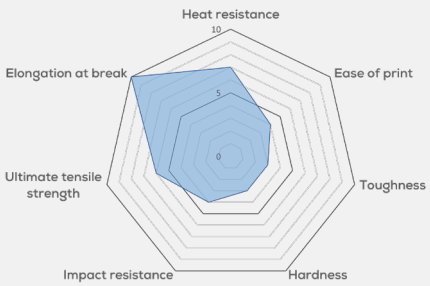
PC 275 is a professional, high-class filament offering exceptional stability and precision during printing, even at high speeds, thanks to its improved composition. With outstanding mechanical and thermal properties, PC 275 is ideal for demanding projects, ensuring both quality and durability.

FEAUTURES

- High impact strength and durability
- Excellent mechanical properties
- Ability to print at high speeds
- Dimensional stability
- Reduced shrinkage effect
- Wide range of applications

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**