



## Technical specification

### Everfil™ PCABS.T01

#### DESCRIPTION

**Everfil™ PCABS.T01** (polycarbonate-ABS) engineering filament give exceptional impact even at low temperatures and have high heat distortion temperature. This material used in a wide range of applications where a balance of low temperature toughness, high heat distortion and easy processing are required. Some examples are automotive instrument panels, automotive interior/exterior trim, small appliance and electrical application, pillars, storage/load floors/ glove box

#### TYPICAL PROPERTY VALUES

Filament	Nominal Value	Unit	Test Method
Filament diameter	1,75 , 2,85	mm	-
Diameter tolerance	+/- 0,03	mm	-
Spool weight	1,0 , 2,5, 4,5	kg netto	-
Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1,12	g/cc	ISO 1183/A
MFR:			
230°C/3,8 kg	3,0	g/10min	ASTM.D1238
250 °C/5,0 kg	12,00		
260 °C/5,0 kg	17		
Molding Shrinkage (Flow), 3.2mm	0.3 ~0.7	%	ASTM.D955
Water absorption		%	ISO.62
Equilibrium, 73F(23°C), 50%RH	0,2-0,6		
Clarity	Non transparent		
Mechanical	Nominal Value	Unit	Test Method
Tensile Yield Strength	52	MPa	ISO 527-2/5
Rockwell Hardness	105	-	DIN 53459
Tensile Modulus	2,20	MPa	ISO 527-2
Charpy Impact Strength			
-22F (-30°C)	45	kJ/m2	ISO179/1eA
73F (23)	50		
Tensile Strain (Break)	>80	%	ISO 527-2/5
Flexural Stress	82	MPa	ISO 178
Flexural Modulus	2,1	MPa	ISO 178
Heat Deflection Temp.	126 (0.45 MPa)	°C	ISO 75-2/B





## PRINT CONDITIONS **Everfil™ PCABS.T01**

(may be different for different printers)

3D Printers	Typical Value	Unit
Printing temperature	255 – 275	°C
Bed temperature (if needed)	85 – 100	°C
Cooling (according to design)	10 – 30	%

## STORAGE

Filament can't handle moisture very well and that is why we recommend storing your filament in a cool, dry environment, ideally in a package vacuum sealed with silicate.