

Fillamentum CPE CF112 Carbon

(Co-Polyester filled with 12.5% of milled carbon fibers)

Printing temperature: 250 - 270 °C

Heated bed temperature: 70 - 85 °C

Speed: 30 - 50 mm/s

Part cooling fan: 0 - 15 %

Heated bed surface: PEI, mirror / glass

Adhesive: Magigoo PC, 3DLac, PVA glue

Raft / skirt / brim: Skirt, Brim 5mm

Heated chamber / enclosure: not needed

Nozzle - It's necessary to use hardened steel/Ruby or any wear-resistant nozzle for printing this material due to carbon fibers in this material.

Cooling - It is not recommended to use more than 15 % of fan speed, as too much cooling could lead into improper layer bonding. We recommend to use no cooling for standard objects, which leads into stronger parts. For bridges and big overhangs is it possible to go up to 50% for the desired layer.

Storing - Airtight bag with desiccant.
In case of moist material, re-dry it in appropriate device. The conditions to achieve optimal level of moisture are 75 °C for 3 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing etc.

Surface - For achieving more structural carbon fiber surface use higher layer height.