

## TECAFIL PEEK EV CF30 black - 1.75 mm - Filament

### Chemical Designation

PEEK (Polyetheretherketone)

### Colour

black opaque

### Density

1.41 g/cm<sup>3</sup> (\*2)

### Fillers

carbon fibres, 30% carbon fibres

### Main features

- very high stiffness
- inherent flame retardant
- good chemical resistance
- high dimensional stability
- hydrolysis and superheated steam resistant

### Target Industries

- oil and gas industry
- automotive industry
- chemical technology
- mechanical engineering
- aircraft and aerospace technology

General material information	parameter	value	unit	norm	comment
Diameter		1,75 +/- 0,05	mm	-	(1) standard spool body
Spool measurements	outer diameter	Ø 200	mm	-	1) (2) do not dry spool >120°C (3) Ø 1,75mm
Spool measurements	width	55	mm	-	
Spool measurements	holder	Ø 52	mm	-	
Spool Material		Polycarbonate		-	2)
Filament Load per Spool		500	g	-	
Filament Length per Spool		141	m	-	3)

Mechanical properties	parameter	value	unit	norm	comment
Tensile strength	5mm/min, Orientation XY	169,0	MPa	DIN EN ISO 527-2	1) (1) (*5), (*6)
Tensile strength	5mm/min, Orientation ZX	72,7	MPa	DIN EN ISO 527-2	2) (2) (*5), (*6)
Modulus of elasticity (tensile test)	5mm/min, Orientation XY	17310,0	MPa	DIN EN ISO 527-2	3) (3) (*5), (*6)
Modulus of elasticity (tensile test)	5mm/min, Orientation ZX	4258,0	MPa	DIN EN ISO 527-2	4) (4) (*5), (*6)
Elongation at yield (tensile test)	5mm/min, Orientation XY	2,6	%	DIN EN ISO 527-2	5) (5) (*5), (*6)
Elongation at yield (tensile test)	5mm/min, Orientation ZX	4,1	%	DIN EN ISO 527-2	6) (6) (*5), (*6)
Elongation at break (tensile test)	5mm/min, Orientation XY	2,7	%	DIN EN ISO 527-2	7) (7) (*5), (*6)
Elongation at break (tensile test)	5mm/min, Orientation ZX	4,2	%	DIN EN ISO 527-2	8) (8) (*5), (*6)
Impact strength (Charpy)	max. 7,5J - 23°C	55	kJ/m <sup>2</sup>	DIN EN ISO 179-1eU	9) (9) (*1)

Thermal properties	parameter	value	unit	norm	comment
Glass transition temperature		143	°C	ASTM D 3418	1) (1) (*2)
Melting temperature		343	°C	DIN EN ISO 11357	2) (2) (*2)
Deflection temperature	HDT-A	162	°C	ISO-R 75 Method A	3) (3) (*2)
Service temperature	short term	300	°C	-	4) (4) (*2)
Service temperature	long term	260	°C	-	5) (5) (*2)
Thermal expansion (CLTE)		6	10 <sup>-5</sup> K <sup>-1</sup>	DIN EN ISO 11359-1:2	6) (6) (*2)

Other properties	parameter	value	unit	norm	comment
Moisture absorption		0,5	%	DIN EN ISO 62	1) (1) (*2)
Flammability (UL94)	125x13x1,5mm	V0		DIN IEC 60695-11-10;	2) (2) (*2)
Melt flow index (MFI)	380°C / 5kg	2,9	g/10 min	DIN EN ISO 1133	3) (3) (*2)

Processing parameter	parameter	value	unit	norm	comment
Nozzle temperature		420 - 460	°C	-	(1) required
Max. melt temperature		470	°C	-	
Print bed temperature		160 - 250	°C	-	
Build chamber temperature		160 - 230	°C	-	1)
Nozzle diameter		0,4 - 0,6	mm	-	
Print speed		20 - 30	mm/s	-	
Fan speed		0	%	-	

Predrying	parameter	value	unit	norm	comment
Drying temperature		120	°C	-	1) (1) (*4)
Drying time		8	h	-	

→ To achieve optimum mechanical properties, it is recommended to pre-dry the material with the above mentioned parameters.

- (\*1) Values measured on injection moulded test specimens
- (\*2) Values measured on the raw material
- (\*3) The exact parameters depend on the printer used.
- (\*4) Do not exceed maximum drying temperature of 120°C
- (\*5) Properties tested on printed specimens
- (\*6) Specimens printed on Kumovis R1

→ The filament should preferably be stored in dry, normal temperature rooms and protected from direct sunlight.

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