

KRONES creadditive FIL 11 02

Filament

Product description and application

This is a carbon fiber reinforced filament with perfectly matched material properties for a wide range of technical applications.

- High strength and stiffness
- High heat resistance
- Easy processing (high dimensional stability and low abrasiveness)
- Excellent surface finish

Technical product data:

Nozzle temperature	250 – 270°C
Bed temperature	65 – 85°C
Cooling	0 -25% (depending on part)
Print speed	Bis 60 mm/s
Retraction	7.5 mm mit 35-40 mm/s
Layer height	As needed
Extrusion width	>0,6 mm
Extrusion flow	100 – 105%
Color	black

Storage and shelf life

Please store the spool at 15 – 25°C in its originally sealed package in a clean and dry environment. If the recommended storage conditions are observed the products will have a minimum shelf life of 24 months.

After opening the original package: To ensure optimum printing results, it is recommended that the filament is always stored in appropriate drying boxes after opening the original packaging. This applies both during the printing processes and for intermediate storage. If the intermediate storage is extended over several weeks, it is also recommended to prepare the filament in a drying oven.

Use a cover when printing, as this increases the layer adhesion as well as the mechanical properties and reduces filament dragging (especially at visible starting points).

Recommended to use the filament on CC 0.6 printers, because due to the fibers standard brass glands will be damaged after some time.

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Tip: If there is a problem with the insertion of the filament, due to too much bending of the filament, heat it briefly and bend it straight again. Additionally, cut the filament at a 45° angle.

Material safety data sheets

The current material safety data sheets are available for you to download from our website: www.kic-krones.com/en/downloads.php

You are also welcome to request them by e-mail to kic@kic-krones.com.

Labelling

Please refer to the corresponding material safety data sheet for details on:

- Hazardous goods labelling (section 2)
- Transport regulations (section 14)
- Safety regulations (section 4-8)

Drying

Drying recommendation to ensure printability:

16 hours at 70°C in a hot air dryer or vacuum oven.

Product safety

Recommended: Process materials in a well-ventilated room or use professional extraction systems. For further and more detailed information please consult the corresponding material safety data sheets.

The contents of this product information are based on our general experience and to the best of our knowledge at the time of printing. The product information should provide hints for possible applications to the technically experienced reader. However, the product information is not intended to guarantee any properties of the described product, nor the suitability of the product for individual applications. It does not release the user from testing the selected product prior to application. We recommend individual consultation and are happy to provide samples on request, if possible. These products are continuously developed. We therefore reserve the right to change all technical data of this brochure at any time without notice.