

Facilan™ HT

Facilan™ HT is a material with a heat deflection temperature of 89 °C and comparatively high tensile strength. The raw material has food contact approval and is not based on Bisphenol-A. Facilan™ HT has been created as a higher performance replacement for PET, PET-G and other copolymers. High stiffness, high strength and high gloss combine to give this material good characteristics to be used in machine building, construction and for end use consumer parts. HT has been created to make parts that survive real life.

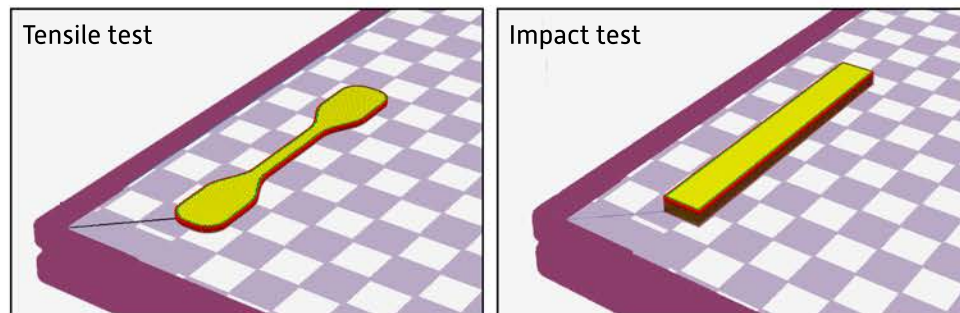
| MATERIAL PROPERTIES | TYPICAL VALUE | TEST METHOD |
|--------------------------------|-----------------------|-------------|
| Density | 1.3 g/cm ³ | ISO 1183-1 |
| Tensile Strength | 62 MPa | ISO 527-1* |
| Elongation at yield | 7 % | ISO 527-1* |
| Tensile Modulus | 2100 MPa | ISO 527-1* |
| Flexural Strength | 86 MPa | ISO 178 |
| Flexural Modulus | 2304 MPa | ISO 178 |
| Izod impact strength (notched) | 3 kJ/m ² | ISO 180-1 |
| Shore D Hardness | 76 | ISO 868 |
| Heat Deflection Temperature | 89°C | ISO 75 B** |

*Tensile sample thickness 1.5 mm

** 120 K/h

| PRINT RECOMMENDATIONS | |
|-----------------------|-------------------|
| Nozzle Temperature | 240 - 250 °C |
| Bed Temperature | 75 - 85 °C |
| Print Speed | 40 - 70 mm/s |
| Bed Adhesion | PEI Sheet / Glass |

Disclaimer : ElogioAM makes no warranties what so ever, either expressed or implied, including but not limited to, any implied fitness for any particular purpose. From the moment the product is shipped it is beyond our control. The information in this document is believed to be correct at the time of writing. However, handling, processing, settings, the type of 3D printer, slicing and other variables are completely up to the user. The method through which the product is used can be varied. It is up for the customer to determine how it is 3D printed and whether it is fit for purpose or suited to a particular application.



- ☺ Printer : Ultimaker 2
- ☺ Nozzle temp : 240°C
- ☺ Bed temp : 80°C
- ☺ Infill : 100%
- ☺ Layerheight : 0.1 mm
- ☺ Print speed : 50 mm/s
- ☺ Wall thickness : 0.7 mm
- ☺ Wall line count : 2

Additional info : For many 3D printers, HT will print best at approximately 240°C with a bed temperature of 80°C and a speed of 50 mm/s. In designs with significant overhangs and bridges best results are obtained with fans at 80%. If your model has no overhangs then putting your fans at 0% improves interlayer bonding and in so doing the final mechanical strength of your part. To get the best results while printing we advise you to keep the 3D printer in a room where there is hardly any draft and/or temperature fluctuations. Keep the 3D printer out of direct sunlight. When the 3D printer is not being used it is important to keep the ElogioAM Facilan™ HT filament in a bag and stored in a cool, dry and dark place until it is used again.