



TDS Rev 2.0

Technical Data Sheet: CX13 PCTG SERIES 3D PRINTING FILAMENT**BASE RESIN:** Selenis Mimesis PCTG Copolyester

Physical Properties	Standard	Unit	Typical Value
Specific Gravity - Density	ASTM D792	g/cc	1.27
Melt Density @200°C	ASTM D1238	g/cm ³	N/A
UL Flammability Class. @1.14mm	UL 94	N/A	N/A

Mechanical Properties	Standard	Unit	Typical Value
Tensile Yield Strength	ASTM D638	MPa	50
Tensile Modulus	ASTM D638	MPa	2175
Tensile Elongation	ASTM D638	%	84
Flexural Stress	ISO 178	MPa	61
Notched Izod Impact	ASTM D256	J/m	5.2
Shrinkage Rate < 1%	ASTM D955	mm/mm	0.2 - 0.5

Thermal Properties	Standard	Unit	Typical Value
Glass Transition Temperature (Tg)	DSC	°C	80 - 85
Heat Distortion Temp @ 0.45MPa	ASTM D648	°C	71
Decomposition Temperature	ASTM 3418	°C	N/A

SPECIFICATIONS				
Filament Size:	1.75mm	0.0689 in	2.85mm	0.1122 in
MIN Diameter:	1.72mm	0.0677 in	2.79mm	0.1098 in
MAX Diameter:	1.78mm	0.0701 in	2.91mm	0.1146 in
Tolerance				
Standard Dev.	+/- .03mm	+/- 0.0012 in	+/- .06mm	+/- 0.0024 in
Ovality				

CERTIFICATIONS	
Meets ISO 10992 and/or USP Class VI biocompatibility requirements; Food Contact Status compliant	

Printed Specimen Conditions
Printer: Open Source FDM/FFF
Nozzle: 0.4mm
Layer Height: 0.25mm
Infill: 100%, +/-45°
Extrusion Temp: 250°C
Bed Temp: 80°C
Specimen Orientation: XY Flat
Unannealed

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