

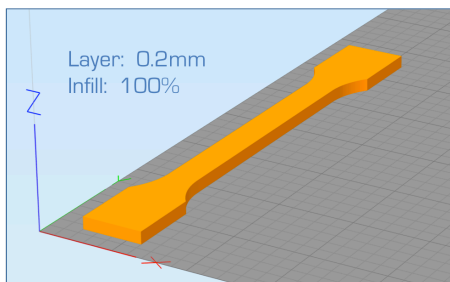


3DXSTAT™ ESD-Safe PC 3D Filament

3DXSTAT™ ESD-Safe PC (polycarbonate) is a high-performance 3D printing filament formulated utilizing state-of-the-art conductive additives and premium PC. This filament is ideal for applications that require consistent and reliable electrostatic dissipation (ESD) protection. 3DXSTAT™ ESD-Safe PC is an high-temperature amorphous polymer that offers excellent dimensional stability and high thermal properties with a Tg of 143°C. Suitable for use in practically all consumer-grade FDM/FFF printers. Made by 3DXTECH® in the USA.

The reported technical data was generated from printed ISO test specimen. The general print parameters utilized are noted below.

- Desktop FDM/FFF Printer
- Nozzle: 0.4mm A2 hardened
- Layer height: 0.2mm
- Infill: 100%, +/- 45°
- Extrusion temp: 290°C
- Bed temp: 120°C
- Bed prep: PEI Sheet
- Print speed: 50 mm/sec



Disclaimer: The technical data contained on this data sheet is furnished without charge or obligation and accepted at the recipient's sole risk. This data should not be used to establish specifications limits or used alone as the basis of design. The data provided is not intended to substitute any testing that may be required to determine fitness for any specific use.

General Property	Unit	Standard	Typical Value
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Density	g/cc	ISO 1183	1.24
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Mechanical Property	Unit	Standard	Typical Value
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Tensile Strength	MPa	ISO 527	68
Tensile Modulus	MPa	ISO 527	2300
Tensile Elongation, Break	%	ISO 527	6
Flexural Modulus	MPa	ISO 178	2410
Flexural Strength	MPa	ISO 178	95

Thermal Property	Unit	Standard	Typical Value
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Glass Transition Temperature (Tg)	°C	DSC	143
Heat Distortion Temperature (HDT) @ 0.45MPa	°C	ISO 75	135

Electrical Property	Unit	Standard	Typical Value
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Surface Resistivity	Ohm/sq	IEC 60093	>10 ⁹ - 10 ⁹ <
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Printing Recommendation	Typical Range
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Extruder Temperature	270 - 300°C
Bed Temperature	110 - 120°C
Print Speed	50 - 70 mm/sec