



# TECHNICAL DATA SHEET

## GREENTEC PRO CF

### 1. DESCRIPTION

GreenTEC Pro Carbon comes from our BIO Performance range and has been specially developed for ultra-high-performance applications. The composite material contains 10% carbon fibre, resulting in increased rigidity and heat distortion resistance. The material offers a high-quality carbon look. GreenTEC Pro Carbon is the ecologically harmless alternative to common industrial materials, consisting of renewable raw materials. In addition, the raw material is approved according to REACH and RoHS standards.

### 2. FEATURES

- Carbon composite material for performance applications
- Heat resistance up to 165°C VI-CAT A / 115°C HDT/B\*
- 100% sustainable and oil-free
- CO2 neutral
- Easy to process

### 3. PROPERTIES

TEST	METHOD	UNIT	VALUE
Tensile modulus (E-Modulus)	ISO 527	MPa	7120
Tensile strength	ISO 527	MPa	65
Elongation at strength	ISO 527	%	3
Stress at break	ISO 527	MPa	58
Nominal elongation at break	ISO 527-2	%	2.5
Notched impact strength	ISO 179/1eA	kJ/m <sup>2</sup>	4.6
Unnotched impact strength	ISO 179/1eU	kJ/m <sup>2</sup>	82
VICAT A (VST)	ISO 306	°C	165*
Melting temperature	ISO 3146-C	°C	180-200
MFR	ISO 1133	g/10min	4
HDT/B	ISO 75	°C	115
Shrinking	ISO 294-4	%	0.2
Density	ISO 1183	g/cm <sup>3</sup>	1.2

PRINT SETTINGS	
Nozzle	225-250°C
Heatbed	20-90°C
Adhesive	not required
Speed	20-200mm/s
Cooling	20-50%
Enclosed Space	no
Hardened Nozzle	yes
Max. Volumetric Speed	18 mm <sup>3</sup> /s

Recommended settings for printers with a 0.5mm Nozzle.  
Max. 50% layerheight. Optimal print settings may vary between different printers and also depend on environmental factors.

\*Temperature resistance tested at a minimum wall thickness of 4 mm.

### 4. CERTIFICATIONS & ADDITIONAL INFORMATION



Certifications depend on colors in final product. More info in the additional information sheet.

### 5. STORAGE AND SHELF LIFE

Store in a dry room at room temperature (18-27°C / 65-80°F). Keep out of direct heat and sunlight. When stored correctly, this material has a shelf life of 2 years. Additional info in our regulatory, additional information and chemical resistance data sheets.