

Technical datasheet

colorFabb_HT

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colorFabb_HT is made with Amphora HT5300 and is a low-odor and styrene-free material uniquely suited for advanced 3D printing users, particularly those who need their models to exhibit excellent durability, toughness and high temperature resistance with a Tg of over 100°C. colorFabb_HT empowers professional users to create more durable and useful items, making prototyping truly functional.

colorFabb_HT is enabled by Eastman Tritan™ copolyester technology

TYPICAL MATERIAL PROPERTIES

Physical properties	Unit	Value	Method
Density	g/cm ³	1,18	D 792
Tensile Stress @ Yield	MPa	43	D 638
Tensile Stress @ Break	MPa	52	D 638
Elongation @ Yield	%	7	D 638
Elongation @ Break	%	210	D 638
Flexural Modulus	MPa	1575	D 790
Flexural Strength	MPa	64	D 790
Rockwell Hardness, R Scale	-	111	D 785
Izod Impact strength, notched @ 23 °C	J/m	860	D 256
Izod Impact strength, unnotched @ 23 °C	J/m	NB	D 4812
Deflection Temperature @ 0.455 MPa	°C	94	D 648
Deflection Temperature @ 1.82 MPa	°C	81	D 648

FILAMENT SPECIFICATION

Nominal diameter:	Diameter tolerance	Ovality
1,75 mm	± 0,05	≥ 95%
2,85 mm	± 0,05	≥ 95%

Netto filament weight 750 grams / 2200 grams

GUIDELINE FOR PRINT SETTINGS

Advised 3D printing temperature	250 – 280 °C
Advised bed temperature	100 – 120 °C
Bed surface / modification	colorFabb_HT gives best results on a heated build platform, 100C to about 120C is usually needed for proper adhesion to a glass plate. When this is not enough it's possible to use buildTak plate for stronger adhesion
Active cooling fan	0 – 100 %
Advised 3D printing speed	30 – 50 mm/sec

Disclaimer

The product- and technical information provided in this datasheet is correct to the best of our knowledge. The information given is provided as a guidance for good use, handling and processing and is not to be considered as a quality specification. The information only relates to the specific product and the material properties.