

Electrafil® PC 2219 3DP

 Techmer Polymer Modifiers - *Polycarbonate*
General Information
Product Description

Electrafil® PC 2219 3DP is a specially formulated, grey colored, and compounded thermoplastic material designed for general purpose additive manufacturing applications. This product has been optimized for maximum printability in additive manufacturing and contains additives for outdoor exposure.

General

Material Status	<ul style="list-style-type: none"> Commercial: Active
Availability	<ul style="list-style-type: none"> North America
Filler / Reinforcement	<ul style="list-style-type: none"> Filler
Additive	<ul style="list-style-type: none"> UV Stabilizer
Features	<ul style="list-style-type: none"> UV Stabilized
Uses	<ul style="list-style-type: none"> Additive Manufacturing (3D Printing)
Appearance	<ul style="list-style-type: none"> Grey

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.40		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	15000	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	1.50E+6	psi	ASTM D790
Flexural Strength	20000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	260	°F
Drying Time	2.0 to 6.0	hr
Cylinder Zone 1 Temp.	500 to 520	°F
Cylinder Zone 2 Temp.	510 to 530	°F
Cylinder Zone 3 Temp.	520 to 550	°F
Cylinder Zone 4 Temp.	520 to 550	°F
Melt Temperature	500 to 550	°F
Die Temperature	520 to 550	°F

Extrusion Notes

If drying for longer than 6 hours, recommend reducing the temperature to 140°F in a dessiccant dryer to avoid degradaton of the material.

Notes

¹ Typical properties: these are not to be construed as specifications.

