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Data Sheet

DAHLTRAM® C-250CF

Medium temperature additive manufacturing

DESCRIPTION

Dahltram® C-250CF is a cost effective, low to medium temperature use, additive manufacturing polymer with a maximum recommended use temperature of 135°C. It is reinforced with carbon fibre for maximum strength and long term performance. Dahltram® C-250CF is ideal for room temperature tooling solutions and low to medium temperature master moulds. Additionally, it is vacuum tight and autoclave capable in all forms and can be machined to the tolerances and surface finish required.

BENEFITS

- Additive manufactured tools can go from conception to the production floor in days not weeks.
- Dahltram® C-250CF is a cost effective solution ideal for 121°C cure systems and much more.
- Provides higher strength, higher temperature performance and higher throughput.
- Carbon reinforcement offers greater stiffness versus glass and low warpage for predictable results.

TECHNICAL DATA

Physicals	Typical Values	Test Method
Base Polymer	Modified PC	
Reinforcements	Carbon Fibre	
% Fibre Loading	20%	
Tensile Strength		
X Direction	112,4 MPa	Modified ASTM D638
Z Direction	50,3 MPa	Modified ASTM D638
Tensile Modulus		
X Direction	11 GPa	Modified ASTM D638
Z Direction	3,0 GPa	Modified ASTM D638
Flexural Strength		
X Direction	180 MPa	Modified ASTM D790
Z Direction	93,8 MPa	Modified ASTM D790
Flexural Modulus		
X Direction	10,8 GPa	Modified ASTM D790
Z Direction	3,8 GPa	Modified ASTM D790
HDT, 1,82 MPa, 3,22 mm	144°C	ASTM D648 (Annealed)
Density as Printed	1,21 g/cc	ASTM D792

*Where X is the bead print direction and Z is through the bead thickness.

SIZES

Weight	Packaging	Form
25 kg (55 lb)	Bag	Pellet
100 kg (220 lb)	Drum	Pellet
590 kg (1,300 lb)	Box	Pellet

Last updated : 2024-01-09

Catalogue position : Print-Tech®

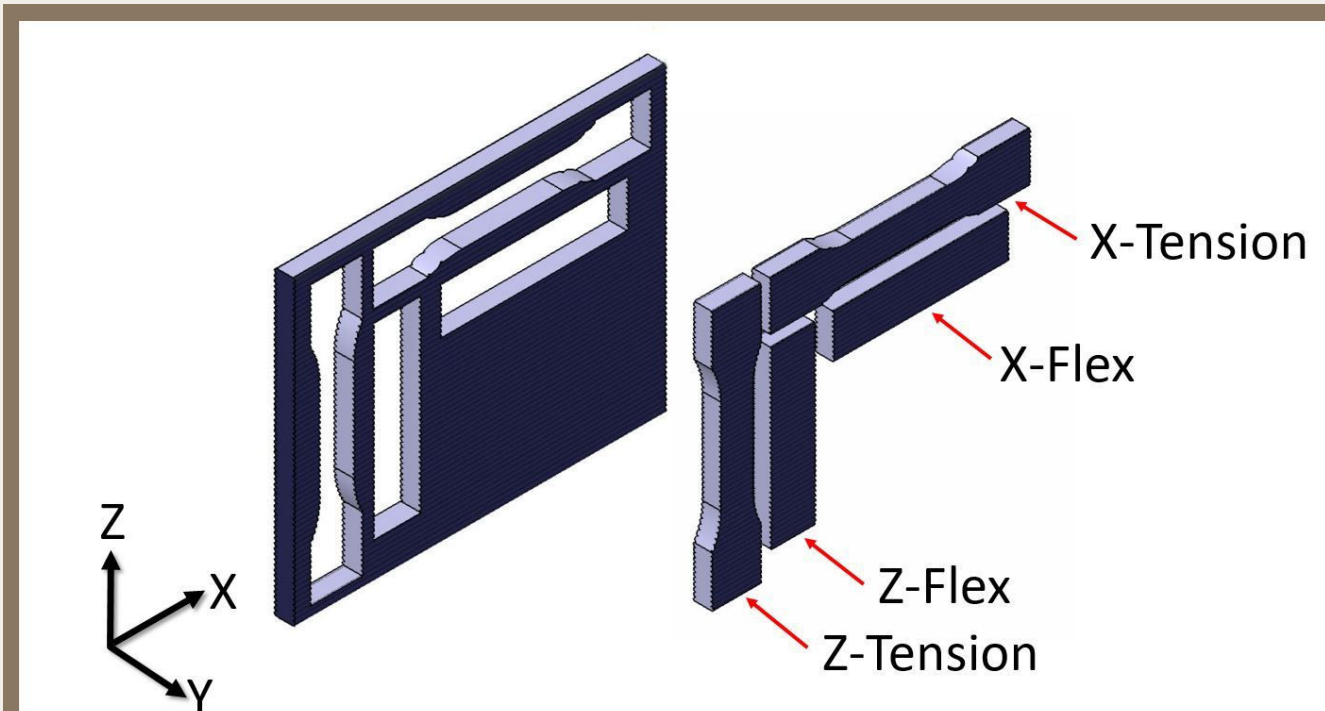
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*All samples are machined to remove bead cusps. They are shown for reference on coupons.

NOTES

- The maximum use temperature is dependent upon the duration at maximum temperature, and is process specific, Airtech recommends testing prior to use.
- Shelf life unlimited when stored in original packaging at 22°C.

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