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Data Sheet

DAHLTRAM® C-250GF

Medium temperature additive manufacturing

DESCRIPTION

Dahltram® C-250GF is a cost effective, low to medium temperature use, additive manufacturing polymer with a maximum recommended use temperature of 135°C. It is a modified Poly Carbonate (PC) based material and is reinforced with glass fibre for maximum strength and long-term performance. Dahltram® C-250GF is ideal for room temperature tooling solutions, stretch forming and low 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-250GF is a cost effective solution ideal for 121°C cure systems and much more.
- Provides higher strength, higher temperature performance and higher throughput.
- Glass reinforcement offers lower cost and higher impact strength.

TECHNICAL DATA

Physicals	Typical Values	Test Method
Base Polymer	Modified PC	
Reinforcements	Glass Fibre	
% Fibre Loading	20%	
Tensile Stress		
X Direction	84,8 MPa	Modified ASTM D638
Z Direction	50,3 MPa	Modified ASTM D638
Tensile Modulus		
X Direction	5,24 GPa	Modified ASTM D638
Z Direction	3,03 GPa	Modified ASTM D638
Flexural Strength		
X Direction	139,3 MPa	Modified ASTM D790
Z Direction	115,1 MPa	Modified ASTM D790
Flexural Modulus		
X Direction	5,72 GPa	Modified ASTM D790
Z Direction	3,03 GPa	Modified ASTM D790
HDT, 1.82 MPa, 3.22 mm	139°C	ASTM D648
Density as Printed	1,24 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®

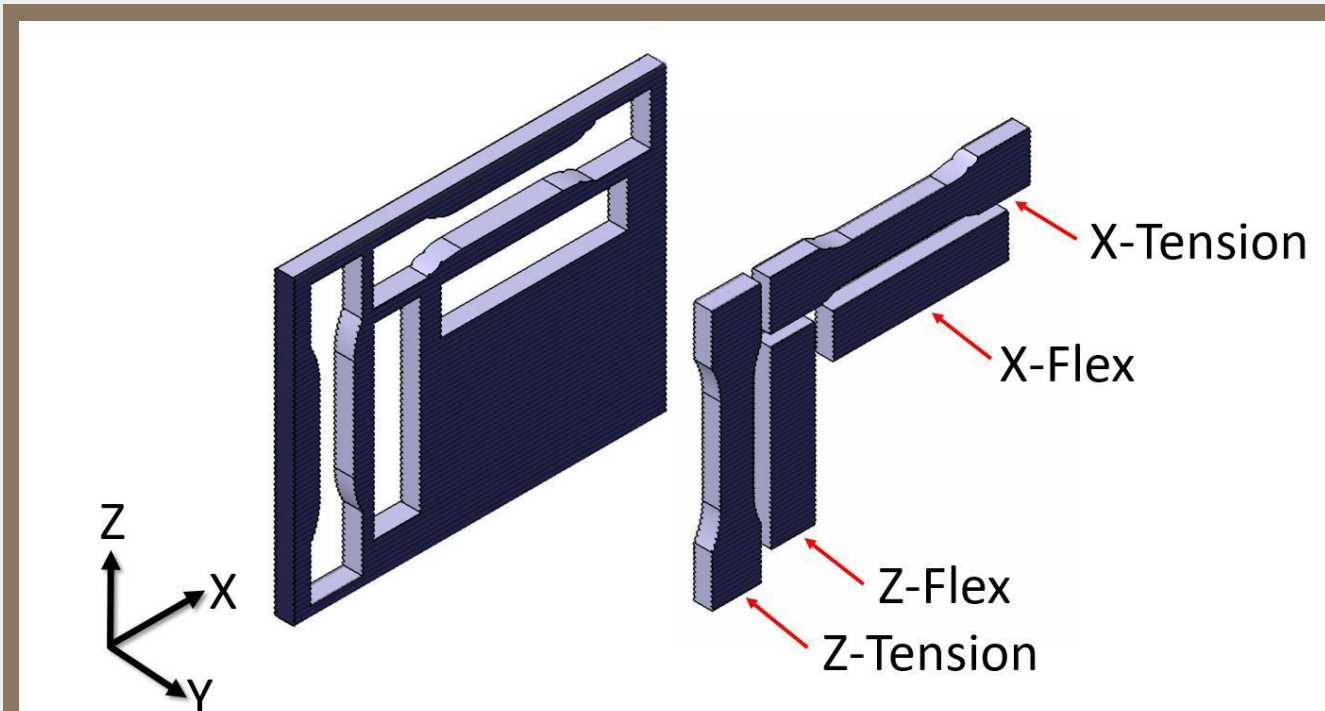
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*All samples are machined to remove bead cusps. They are shown for reference on coupons.

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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