

PC

Polycarbonate

Print Settings	
Extruder Temperature	300°C – 310°C
Bed Temperature	140°C - 145°C
Bed Preparation	WolfBite Mega
Cooling Fan	
Closed Chamber	Yes
Heated Chamber	Yes
Chamber Temperature	70°C – for medium to large parts
Notes	

Material Management	
Drying	
Recommended Support Material	<ul style="list-style-type: none"> • HIPS
Storage	<ul style="list-style-type: none"> • Moisture-free container with desiccant.
Compatible Materials	<ul style="list-style-type: none"> • PLA

Slicer Settings	APEX
Material Profile Name	PC PC Dual Color PC with HIPS PC with PLA

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Chemical Resistance Table

Resistance classes:

A High Resistance	B Limited Resistance	C Little or No Resistance	-- No Data Available
All materials in this class are almost completely inert to the specified chemical	Chemicals in this class are partially affected by the specified chemical and lead to a shortened lifetime	Not recommended for use with specified chemical	

Acids	
C	Acetic, 5%
C	Boric, 4%
C	Chromic
C	Citronic
C	Formic, 20%
C	Hydrochloric, 10%
C	Lactic
C	Nitric, >1%
C	Oleic
C	Phosphoric
B	Sulfuric, 20%

Alcohols	
C	Ethanol
C	Isopropanol
B	Methanol

Alkali	
B	Sodium Hydroxide, 20%
A	Soap, 1%
B	Potassium Hydroxide
C	Ammonia, >10%

Miscellaneous	
B	Clorox, 5%
A	Calcium Solution Saturated
C	Freon 113
C	Freon 11B
A	Freon 12
A	Hydrogen Disulfide, 5%
A	Mr. Clean
A	Sodium Chloride Saturated
A	Synthetic Perspiration
B	Tide Detergent
A	Water

Organics	
C	Acetone
A	ASTM Fuel A
B	ASTM Fuel B
B	ASTM Fuel C
A	ASTM Oil #1
A	ASTM Oil #2
A	ASTM Oil #3
B	Benzene
B	Brake Fluid, Type A
--	Brake Fluid, (HD)
A	Butane
B	Carbon tetrachloride
C	Cyclohexanone
C	Dimethyl formamid
C	Dimethyl sulfoxide
C	1,4-dioxane
B	Diocyl Phthalate
C	Ethylene dichloride
--	Ethyl ether
A	Ethylene glycol (Antifreeze)
A	Gasolene, 100 octane
--	Hexane
A	Kerosene
C	Methylene chloride
B	Methyl ethyl ketone
C	n-Methyl-2-pyrrolidene
--	Oil, Texas Crude
--	Oil, Detergent 20W
--	Oil, Nondetergent 20W
--	Oil, Skydrol Type B
--	Oil, Skydrol Type 500A
--	Oil, Skydrol Type 500B
A	Oil, Transmission Type A
B	Perchloroethylene
C	Pyridine
C	Tetrahydrofuran
B	Toluene
C	Trichloroethylene
A	Turpentine