

# PC (polycarbonate)

for FORTUS 3D Production Systems

**FORTUS**  
3D PRODUCTION SYSTEMS

A true industrial thermoplastic, PC (polycarbonate) is widely used in automotive, aerospace, medical and many other applications. PC offers accuracy, durability and stability, creating strong parts that withstand functional testing. A PC part manufactured on a Fortus 3D Production System is 5-60 percent stronger than a part made on previous FDM systems. It also has superior mechanical properties to ABS and a number of other thermoplastics. When combined with a Fortus system, PC gives you Real Parts™ for conceptual modeling, functional prototyping, manufacturing tools, and end-use-parts.



Mechanical Properties <sup>1</sup>	Test Method	English	Metric
Tensile Strength (Type 1, 0.125", 0.2"/min)	ASTM D638	9,800 psi	68 MPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	330,000 psi	2,280 MPa
Tensile Elongation (Type 1, 0.125", 0.2"/min)	ASTM D638	4.8%	4.8%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	15,100 psi	104 MPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	324,000 psi	2,234 MPa
IZOD Impact, notched (Method A, 23°C)	ASTM D256	1 ft-lb/in	53 J/m
IZOD Impact, un-notched (Method A, 23°C)	ASTM D256	6 ft-lb/in	320 J/m

Thermal Properties <sup>3</sup>	Test Method	English	Metric
Heat Deflection (HDT) @ 66 psi	ASTM D648	280°F	138°C
Heat Deflection (HDT) @ 264 psi	ASTM D648	261°F	127°C
Vicat Softening	ASTM D1525	282°F	139°C
Glass Transition (Tg)	DMA (SSYS)	322°F	161°C
Melt Point	-----	Not Applicable <sup>2</sup>	Not Applicable <sup>2</sup>

Other <sup>3</sup>	Test Method	Value
Specific Gravity	ASTM D792	1.2
Flame Classification	UL94	V2 (0.043", 1.1 mm)
Coefficient of Thermal Expansion	ASTM E831	3.8E-05 in/in/°F
Rockwell Hardness	ASTM D785	R115
Dielectric Strength	IEC 60112	15.0 kV/mm
Dielectric Constant @ 60 Hz	IEC 60250	3.17
Dielectric Constant @ 1 Mhz	IEC 60250	2.96

► See reverse for color options and system availability.

The information presented are typical values intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. End-use material performance can be impacted (+/-) by, but not limited to, part design, end-use conditions, test conditions, etc. Actual values will vary with build conditions. Tested parts were built on Fortus 400mc @ 0.010" (0.254 mm) slice. Product specifications are subject to change without notice.

<sup>1</sup> Build orientation is on side long edge. <sup>2</sup> Due to amorphous nature, material does not display a melting point. <sup>3</sup> Literature value unless otherwise noted.



System Availability	Layer Thickness Capability	Support Structure	Available Colors
Fortus 360mc Fortus 400mc Fortus 900mc	0.013 inch (0.330 mm) 0.010 inch (0.254 mm) 0.007 inch (0.178 mm)	BASS	□ White

**At the core:**  
Advanced FDM technology

Fortus systems are based on patented Stratasys FDM — Fused Deposition Modeling — technology. FDM is the industry's leading additive fabrication technology, and the only one that uses production grade thermoplastics, enabling the most durable parts.

Fortus systems use a wide range of thermoplastics with advanced mechanical properties so your parts can endure high heat, caustic chemicals, sterilization, and high impact applications.

**No special facilities needed**

You can install a Fortus 3D Production System just about anywhere. No special venting is required because Fortus systems don't produce noxious fumes, chemicals, or waste.

**No special skills needed**

Fortus 3D Production Systems are easy to operate and maintain compared to other additive fabrication systems because there are no messy powders or resins to handle and contain. They're so simple, an operator can be trained to operate a Fortus system in less than 30 minutes.

**Get your benchmark on the future of manufacturing**

Fine details. Smooth surface finishes. Accuracy. Strength. The best way to see the advantages of a Fortus 3D Production System is to have your own part built on a Fortus system. Get your free part at: [www.fortus.com/benchmark](http://www.fortus.com/benchmark).

For more information about Fortus systems, materials and applications, call 650-369-5335 x-11 or visit [www.protopulsion.com](http://www.protopulsion.com)

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