

PC 1500 FR Filament

Recommended Print Settings



Print Temperature

The optimal printing range is 285 – 305°C



Bed Temperature

Up to 105°C with ABS slurry, or up to 140°C using a PVP-based glue stick.



Printing Speed

Base printing speed of 40 mm/s
 Infill speed of 40 mm/s
 Wall speed of 32 mm/s
 Initial layer speed of 20 mm/s



Cooling

For best results, do not use a cooling fan. Enabling bridging settings will help improve overhang quality.



Bed Adhesion

Suitable adhesion can be obtained by using a slurry of ABS in acetone, or with a PEI sheet with a PVP-based glue stick. A brim should be used to help with bed adhesion.



Other Tips

If possible, print in an enclosed area that can maintain a temperature of 50-55°C to help minimize warping or cracking.

If using Ultimaker Cura, enable the Jabil PC 1500 FR material profile available in the Marketplace or manually type in the settings from the information above.

Disclaimer: Due to the large variety of printers and part geometries, the given process parameters are a guideline.

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PC 1500 FR is a flame-retardant, easy printing polycarbonate manufactured with FR UL V-0 material. The material is perfect for parts that require strength, stiffness and impact resistance along with flame retardancy.

Applications

- Automotive, aerospace, general manufacturing
- Housings (including battery housings)
- Welding fixtures
- Brackets
- Motor mounts
- Parts for aerospace or automotive applications

Advantages

- Made from UL V-0 yellow-card-certified raw materials
- Stiff with excellent impact strength and ductility
- Very good flame retardancy and self-extinguishing properties
- High impact resistance
- Testing performed in a qualified lab demonstrates V-0 burn properties on a printed part down to 2mm thickness when printed with the correct design and print parameters*

Prints on open platforms including Ultimaker S5, UM 3, Raise3D, Method X and Taz® Pro Platforms

Diameters

1.75mm and 2.85mm



* Jabil is not responsible for UL certification of parts printed by any third-party. Finished part testing and certification is the responsibility of the user/fabricator.

jabil.com/filaments

Questions? Contact us:
JabilAdditive@jabil.com



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PC 1500 FR

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