

Public printing recommendation

Bedrock 3D Standard Black PC/ABS FR Black

MaterialID MAT0245

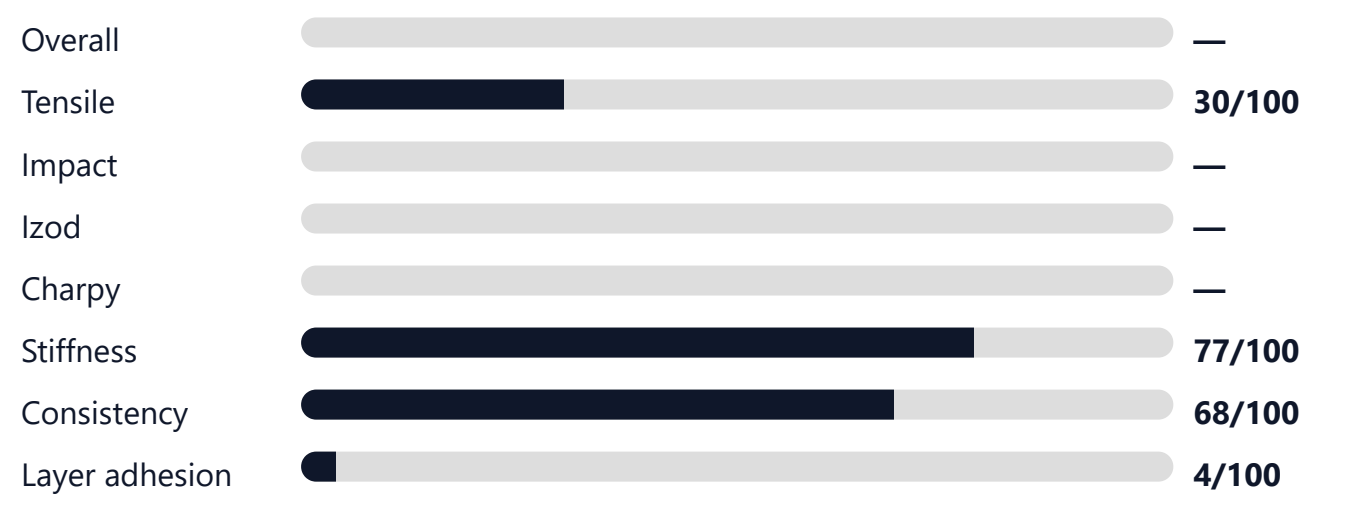


3DPiceland Labs
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DIRECT-IMPACT-METHODOLOGY - Izod and Charpy
Methodology
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Guidance boundary: values below are shared base-material guidance resolved only through the canonical BaseMaterialId link. They are not manufacturer-, spool- or printer-specific validated settings. Missing fields remain Not recorded.

Overall —	Engineering axes 5/8	Public rank —	MSRP USD/kg 72.96
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Engineering profile



Recommended applications

- Rigid brackets, fixtures and shape-stable prototypes
- Cosmetic parts, concept models or low-load prototypes
- Avoid high tensile load applications

Measured strengths

- Consistency: 68/100. Repeatability is one of the stronger signals in this material profile.
- Tensile: 30/100. Tensile behavior is competitive against the material-family context.

- Stiffness: 77/100. Stiffness is a relative advantage in this comparison group.

Limitations

- Tensile: 30/100. Avoid using this as the primary choice for tensile-loaded parts.
- Layer adhesion: 4/100. Z-axis performance should be treated with caution.

Engineering trade-offs

- Good repeatability does not compensate for low tensile capability in load-bearing designs.

Base-material printing guidance

Guidance	Minimum	Recommended	Maximum	Unit
Nozzle temperature	275	275	280	°C
Bed temperature	110	110	115	°C
Print speed	55	130	130	mm/s
Cooling	15	20	25	%
Guidance		Value	Unit	
Cooling guidance		Low		
Drying temperature		80	°C	
Drying time		8	hours	
Enclosure		Required		
Printer / G-code reference		PrusaCoreOneL		
Slicer profile reference		Prusament PC Blend		

Print workflow checks

- Confirm nozzle temperature, bed temperature, speed, cooling and drying requirements from the manufacturer profile or spool label.
- Print a small validation part before committing to a long, costly or safety-relevant print.
- Orient the part so the governing load does not rely on an unverified or weak engineering axis.

- Engineering/high-temperature family: confirm enclosure, ventilation, warping control and material-specific drying requirements.
- Layer-adhesion evidence is weak; avoid critical Z-axis loading without additional validation.

Decision guidance

- Overall suitability is unavailable until the required measurements and method references are complete.
- Do not choose it as a tensile-strength benchmark material.

Stronger same-family alternatives

MaterialID	Material	Manufacturer	Overall	Tensile	Impact	Izod	Charpy
Confirm exact settings against the manufacturer profile, spool label and actual printer/material combination. Results do not replace application-specific validation.							

[Testing methodology](#) · [Download PDF](#)

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Score policy engineering-score-v70-1: Overall requires tensile, stiffness, consistency, layer adhesion and the Izod/Charpy impact family, each with equal weight. Both impact methods and configured versioned references are required. Missing results and unconfigured scores remain n/a. Legacy Impact is historical only; thermal remains separate. Engineering-axis counts describe displayed evidence, not Overall completeness.