

# Technical data sheet – 3D Filament

## Nylon 66 – CF filled Filament

### The special filament for Automotive, Electrical and industrial applications

PA66 CF filled Its carbon fibre reinforced Polyamide 66 gives increased continuous temperature resistance, chemical resistance, Excellent mechanical strength and creep, compressive strength. PA66 CF offers excellent friction and wear performances. This is very special grade for automotive, electrical and industrial applications. These properties make the PA66 CF filament particularly suitable for usage in FDM and FFF 3D printers. The material has an excellent adhesion between layers which results in great improvement of the impact resistance, strength, durability and the printing process.

#### FILAMENT PROPERTIES

PROPERTIES	TEST METHODS	UNITS	Typical Values PA66 CF 20
Diameter	INS-6712	mm	1.75 ± 0.05
Specific gravity	ASTMD792	g/cm3	1.25
Moisture rate	ASTMD 570	%	< 1
Melt Volume Rate	ASTM D 1238	g/10min	8 -10
Melting temp Tm	ISO 11357	°C	260-280
TEST METHOD			PA66 CF 20
Tensile Strength	ASTMD 638	Mpa	193
Tensile Elongation	ASTMD 638	%	2-4
Flexural Strength	ASTMD 790	MPa	296
Flexural Modulus	ASTMD 790	MPa	550
Heat Distortion Temp. 1.80 Mpa	ASTMD 648	°C	240
Flammability Behaviour	UL	Rating	HB

PRINT RECOMMANDATION	PA66 CF 20
Nozzle Temp	275 °C
Print Speed	35 mm/sec
Bed Temp	125 °C
Nozzle	0.6 mm/
Infill	100 % +/- 45
Bed Adhesion	Glue stick

Disclaimer: The testing has been done in house so we extend no warranties what so ever, expressed or implied, including but not limited to, any implied fitness for any particular purpose. From the moment the product is shipped it is beyond our control. The information in this document is believed to be correct at the time of writing. However, handling, processing, settings, the type of 3D printer, slicing and other variables are completely up to the user. The method through which the product is used can be varied. It is up for the customer to determine how it is 3D printed and whether it is fit for purpose or suited to a particular application.



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