

# TECHNICAL DATA SHEET

## Filaticum PA

3D printing filament for FDM/FFF printer

### Product Description

Filaticum PA

### Specification

	Filaticum PA
Diameter	1,75 mm
Tolerance	+/-0,05 mm, +/-0,1 mm
Colours	black
Weight	1 kg

### Printing Settings

Nozzle temperature	250-280 °C
Nozzle size	≥ 0,5 mm
Bed temperature	max. 80°C
Cooling fan	up to 30%
Layer height	≥ 0,15 mm
Print speed	30-60 mm/s
Dry (if wet)	recommended (at least 12h at 80 using a hot dry air oven)

This printer setting recommended for the starting, can be modified according to the printer, printed objects and required mechanical parameters.

### Raw Material Properties

Physical properties *	Method	PA6
Heat Deflection Temp., °C	ISO 75	65
Tensile Strength, MPa	ISO 527	120
Tensile Elongation, %	ISO 527	4
Flexural Modulus, MPa	ISO 178	9000
Notched Izod Impact, kJ/m <sup>2</sup>	ISO 179	4

PA filament should be stored in a dry room at room temperature. Recommended storage temperature is 18-25°C. Keep out of moisture, sunlight and direct heat. In case of proper storage, product has a shelf life of 12 months.

### Producer

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