



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	240°-270°	internal
plate temp	°C	50°-80°	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-10	internal
print speed	mm/l°	40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1,2	ISO 1183
Water absorption at equilibrium	%	<0,3	23°C / 24 h
Linear mould shrinkage	%	0,3-0,5	DIN 16901
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	85	ISO 527
Elongation	%	3,5	ISO 527
Modulus of elasticity	GPa	3	ISO 527
Thermal			
Heat distortion temp.	°C	90	ISO 75
Continuous service temp.	°C	120	UL 746B
Maximum (short term) use temp.	°C	160	-
Coefficient of thermal expansion	10 ⁻⁵ /K	0,5	DIN 52752
Thermal conductivity	W/mK	0,3	HOT-DISK
Electrical			
Insulation resistance	Ω	≤10 ¹²	DIN/IEC 60167
Surface resistance	Ω	<10 ¹²	DIN IEC 60093

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with PAHP Natural can be processed on conventional 3D printer using FDM / FFF technology.

PAHP Natural is a special polyamide developed for 3D printing and to obtain best results we recommend pre drying the filaments at 120° for 4-6 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

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