

# LUVOCOM® 3F PAHT 9936 BK

An unreinforced polyamide-based formulation designed for industrial applications. 3F PAHT 9936 BK has excellent tensile and impact strength and allows continued operation up to 100°C – 120°C while retaining 50% of its mechanical properties and short-term 160°C. Low warping and increased layer adhesion increase the printability of this material.

## Material features:

- Unreinforced PAHT
- Optimized surface appearance
- Designed for industrial applications
- PA6 based material
- Low warping and increased layer adhesion



## Filament specs.

Size	Ø tolerance	Roundness
1,75mm	± 0,05mm	≥ 95%
2,85mm	± 0,10mm	≥ 95%

## Material properties

Description	Testmethod	Typical value
Specific gravity	ISO 1183	1,25 g/cc
MFI 250°C/2,16kg	ISO 1133	6 g/10 min
Tensile strength at yield	ISO 527	78 MPa
Elongation strain at yield	ISO 527	4,4%
Tensile (E) modulus	ISO 527	3400 MPa
Flexural modulus	ISO 178	6000 MPa
Flexural strength	ISO 178	78 MPa
Vicat softening temp. A	ISO 306	80°C
Heat deflection temp. A (1,8MPa)	ISO 75	90°C
Mold shrinkage	DIN 16742	0,3-0,5%
Water absorption 23°C	ISO 62	<0,3%
Printing temp.	Internal method	265±10°C

## Additional info:

Recommended temperature for heated bed is 60-70°C. Adhesion is possible on different surfaces. LUVOCOM® 3F PAHT 9936 BK can be used on all common desktop FDM technology or FFF 3D printers. Dry the spool before printing: 12 hours at 70°C or 4 hours at 100°C.

Storage: Cool and dry (15-25°C) and away from UV light. This enhances the shelf life significantly.