

PA 4500 Filament

Recommended Print Settings



Print Temperature

The optimal printing range is 240 – 260°C



Bed Temperature

A bed temperature of 50° C will provide the best adhesion during printing.



Printing Speed

Base printing speed of 70 mm/s
 Infill speed of 70 mm/s
 Wall speed of 30 mm/s
 Initial layer speed of 20 mm/s



Cooling

Fan Speed: 20%

Note: Increasing fan speed will reduce any curling tendencies.



Bed Adhesion

PVA Glue Stick



Other Tips

Store filament dry and keep dry during printing.

If using Ultimaker Cura, enable the Jabil PA 4500 material profile available in the Marketplace or manually type in the settings from the information above.

Disclaimer: Due to the large variety of printers and part geometries, the given process parameters are a guideline.

PA 4500 Filament

JABIL

PA 4500 Filament is a low warp, neat Nylon copolymer that has good lay flat/low warp properties, excellent appearance, strength in both XY and XZ directions, toughness, and can be used at lower processing temps (240-260° C). Along with better printability, PA 4500 filament also delivers better appearance, over 100% elongation at break and better overall strength compared to other commercial PA's and products like PETG and PLA.

Applications

Component production of less than 20,000 per year with complex geometries that require good wear properties and appearance are required but also strength and durability

Examples include:

- Slides
- Screen printing pallets
- Automation sleds
- Adaptors for fluid and materials handling
- End of arm tooling (EOAT)
- Masking covers
- Die cast models and patterns
- Clips
- Covers
- Housings
- Gears

Advantages

- Greater Z strength
- Over 100% elongation at break

Prints on open platforms including Ultimaker S5, UM 3, Raise3D, Method X and Taz® Pro Platforms

Diameters

1.75mm and 2.85mm



jabil.com/filaments

Questions? Contact us:
JabilAdditive@jabil.com



Learn More About
PA 4500

For the latest print profiles, search for Jabil Engineered Materials in the Cura Marketplace.