

3D printing guide

Fillamentum Nylon AF 80

(Polyamide 12 with Aramid fibers)

Printing temperature: 235-255 °C

Heated bed temperature: 90-110 °C

Speed: 30-50 mm/s

Part cooling fan: 0%

Heated bed surface: PEI, mirror/glass

Adhesive: Magigoo PA, PVA glue

Raft/skirt/brim: Brim >10mm, raft

Heated chamber/enclosure: recommended

Adhesion – Recommend to use large brim around the printed object. The best results we achieved with glass bed and PVA glue. Also Magigoo PA works fine. Nylons usually doesn't stick to PEI good, but small rounded parts are possible to print on PEI.

Cooling – It's necessary to turn off the part cooling fan. Too high part cooling fan speed or too fast cooling of the printed object can lead to warp/shrinkage.

Storing - Airtight bag with desiccant.

In case of moist material, re-dry it in appropriate device. The conditions to achieve optimal level of moisture are 80 °C for 3 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, stringing, oozing etc.

Printed parts – If it's possible at construction, avoid sharp corners touching the buildplate, can increase the warping effect when printing nylon.

Nozzle - **We recommend to use wear resistant nozzles (hardened steel, ruby, Dexdo nozzle etc), because of Aramid fibers.**