



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	230-250	internal
plate temp	C°	90-110	internal
min. nozzle diameter (2)	mm.	0.5	internal
fan	%	0-40	internal
print speed	mm/l°	40-50	internal
PROPERTY			
Physical			
Specific gravity	g/cm ³	1.07	ISO 1183
Water absorption	%	1.1	23°C / 24 h
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	8000	ISO 178
Flexural modulud	MPa	6800	ISO 178
Volume resistivity	ohm/cm	1.00 e+11	IEC 60093
Stress at break	MPa	110	ISO 527-2
Thermal			
Melting point DSC	°C	178	ISO 3146

Disclaimer

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ADDITIONAL INFORMATIONS

In General filaments made with CARBONIUM (nylon + carbon fiber) can be processed on conventional 3D printer using FDM / FFF technology.

CARBONIUM (nylon + carbon fiber) is a special polyamide carbon fiber reinforced developed for 3D printing and to obtain best results we recommend pre drying the filaments at 70° for 2 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 .

(2) 0.5 mm is the minimum diameter of the nozzle with carbon fibers reinforced. Carbon fibers are abrasive, we suggest to use a nozzle in hardened or tempered metal, like Widia, or wear resistance internal surface, like ceramics or other.
NO tefloned surface!

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