

TECHNICAL DATA SHEET

Use	is a material for the FDM (FFF) 3D printing additive technology		
Material	Polyamide 12 with 17 % carbon fibers – 0,15 mm, petroleum product		
Diameter	1,75 mm		
Tolerance	± 0,1 mm		
Weight	0,5 kg netto ± 5 % / 0,7 kg brutto ± 5 %		
Packing	Spool in Vacuum ZIP bag, inserting to paper box, all in LDPE foil.		
Colours	See www.filament-pm.com		
Solvents	Formic acid (concentrated), Sulfuric acid (concentrated), fenol, benzyl alcohol		
Printing Properties			
Temperature HE	230 - 240 °C		
Temperature HB	110 - 120 °C		
Surface bed	Kapton printing bed, thicker Ultem, metal sheet or double-sided Powder-coated PA Nylon Sheet by Prusa		
Cooling print object	No		
Nozzle	Minimum 0.4 mm hardened for abrasive materials		
Printer space	Close		
Material Properties			
Thermal	Vicat softening temperature	ISO 306	170 °C
	Heat deflection temperature	ISO 75	165 °C
Mechanical	Impact strength	ISO 179	8,3 kJ/m ²
	Flexural modulus	ISO 178	1546 MPa
Physical	Density	ISO 1183/B	1,01 g/cm ³
	Melt Flow Index	ISO 1133	8 g/10 min