

Fillamentum Nylon CF15 Carbon

(Polyamide 12 filled with 15 % of milled carbon fibers)

Printing temperature: 235 – 260 °C

Heated bed temperature: 80 – 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 > 10 mm / raft

Heated chamber / enclosure: recommended

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- Adhesion** - It is recommended to use large brim around the printed object. The best results were achieved with combination of glass bed and PVA glue. Magigoo PA also works fine. Nylons usually don't stick to PEI well, but it is possible to print small rounded parts 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/shrink.
- 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 build plate. It could increase the warping effect when printing nylon.
- Nozzle** - It is highly recommended to use wear-resistant nozzles (Dexdo nozzle, hardened steel, ruby etc.), because of carbon fibers.