

# Fillamentum Nylon AF80 Aramid

(Polyamide 12 with 8 % of 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 >10 mm, raft

**Heated chamber / enclosure:** recommended

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- Adhesion** - It is recommended to use a large brim around the printed object. The best results were achieved with a glass bed and PVA glue. Also, Magigoo PA works fine. Although Nylons usually don't stick well to PEI, small rounded parts are possible to print on PEI.
- Cooling** - It is 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 warping and shrinking.
- Storing** - Airtight bag with desiccant.  
In case of moist material, re-dry it in appropriate drying device. The conditions to achieve an optimal level of moisture are 80 °C for 3 hours. Processing of moist filament may cause degradation of polymer chains, brittleness, poor layer adhesion, change of colour, stringing, oozing, etc.
- Printed parts** - If it is possible at construction, avoid sharp corners touching the build plate. It can increase the warping effect when printing nylon.
- Nozzle** - It is recommended to use wear-resistant nozzles (hardened steel, ruby, Dexdo nozzle etc.) due to the content of aramid fibers.