

THE FILAMENT ASA CF

MATERIAL PROPERTIES

General Properties

| | | |
|------------------|---------------|----------|
| Specific Gravity | 1.12 g/cm3 | ISO 1183 |
| MFI, 220°C, 10kg | 7,6 g/10 min. | ISO 1133 |

Mechanical Properties

| | | |
|---------------------------------|-----------|---------|
| Tensile Strength at Yield | 66 MPa | ISO 527 |
| Tensile Strength at Break | 59 MPa | ISO 527 |
| Tensile Elongation at Break | 2% | ISO 527 |
| Impact strength - charpy method | 5,7 kJ/m2 | ISO 179 |

Thermal Properties

| | | |
|-----------------------------|------|--------|
| Heat Deflection Temperature | 88°C | D 648 |
| VICAT | 96°C | D 1525 |

GUIDELINE FOR PRINT SETTINGS*

| | |
|-------------------------------------|--|
| Nozzle temperature | 230-270°C |
| Nozzle temperature (High Speed) | |
| Bed temperature | 75-100°C |
| Closed chamber for printing | recommended for larger prints |
| Dry box recommended | No |
| Ruby or hardened nozzle recommended | Yes |
| Adhesive | not necessary (if you need increased adhesion or prevent warping: glue stick, Dimafix, 3DLac, Magigoo) |
| Cooling | 0-20% |
| Surface finish | matte, carbon appearance |
| Features | 3% CF for durability and flexibility; optimized formula; UV resistant |

* settings are based on a 0,4 mm nozzle.
** depending on the geometrical complexity

STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.

SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at support@spectrumfilaments.com

Disclaimer
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