



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	°C	230-250	internal
plate temp	°C	85-105	internal
min. nozzle diameter	mm.	0.4	internal
fan	%	0-30	internal
print speed	mm/l°	40-50	internal
PROPERTY			
Physical			
Specific gravity	g/cm ³	1	ISO 1183
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	1440	ISO 527
Charpy impact strength (23°C)	kJ/m ²	no break	ISO 179
Charpy impact strength (-30°C)	kJ/m ²	no break	ISO 179
Hardness	sh/D	75	ISO 868
Yield stress	MPa	43	ISO 527-2
Thermal			
Melting point	°C	180	ISO 11357

Disclaimer

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ADDITIONAL INFORMATIONS

In general filaments made with Longchain PA can be processed on conventional 3D printer using FDM / FFF technology.

Longchain PA is a polyamide 12 uva resistance 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 .

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