Nylon Flame

Property Data

Property	Test Method	Value
Density (g/cm^3)	ASTM D792	1.49
Water absorption/ %	ISO 62 (23°C/24hr)	<0.3
Flammability behavior	UL 94	(V-0)
Heat Distortion Temperature/ °C	ISO 75 (molded)	90
Service Temperature (during lifetame max 200 hr)/ °C	*	160
Continuous Service Temperature (20,000 hr)/ °C	IEC 60216	120
Tensile Strength/ kpsi	ISO 527	8
Tensile Elongation/ %	ISO 527	1.2
Modulus of elasticity/ kpsi	ISO 527	87
Insulation resistance strip electrode/ ohm	DIN IEC 60167	>10^9
Surface resistance	DIN IEC 60093	>10^9

Recommended Printer Settings

Parameter	Value
Nozzle temperature	265-290 °C
Heated bed temperature	50 °C
Speed	40-60 mm/s
Infill	As needed, up to 100 %
Layer thickness	0.2 mm or higher
Bed material	3D lac or similar, Magigoo PA or Buildtak or similar surfaces are recommended to improve 1st layer adhesion
Nozzles	Abrasion resistant
Drying	4 hr @ 70 °C; keep filament in dry, sealed bag/container for storage

These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters. Generally, slower speeds, larger nozzles and layers are beneficial. Being a Nylon-based filament, always be mindful of drying and storage.