

PA 4535 CF Filament

Recommended Print Settings

BEST ADVICE Use in-line drying or dry in an oven at 70-75°C for several hours and repeat as necessary. • Clean the print core after every long build or after several short builds.

• Use a CC 0.6 core from Ultimaker.



PRINT TEMPERATURE

250°C - 270°C



BED TEMPERATURE

60°C



PRINTING SPEED

- Print Speed: 60 mm/s
- Wall Speed: 40 mm/s
- Infill Speed: 60 mm/s
- Initial Layer Speed: 20 mm/s



COOLING

Fan Speed: 10%



BED ADHESION

PVA glue stick

OTHER TIPS

- Filament is very stiff and can create feeding issues, these can be mitigated if a small amount of moisture is absorbed from the atmosphere without sacrificing print quality.
- Hardened steel or ruby tipped nozzles are required.

PA 4535 CF Filament

PA 4535 CF is among the strongest PA co-polymer carbon fiber filaments available on the market, delivering increased strength and stiffness. PA 4535 CF has the highest carbon fiber loading available in the industry, providing 40% improvement in tensile strength, impact strength, Z strength and elongation at break, with the added benefit of being ESD safe.

APPLICATIONS

Great for parts requiring increased stiffness and strength.

Examples include:

- Aluminum replacement parts
- Housings requiring tight printing dimensional tolerances
- Jigs, fixtures and tooling
- Clips
- Brackets
- Retainers
- Covers
- Housings

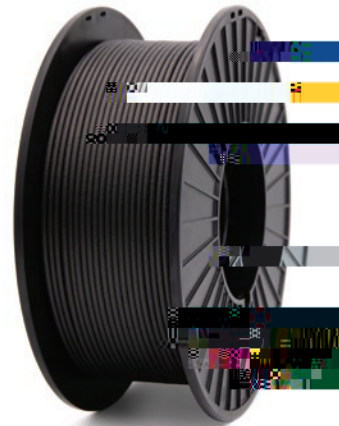
ADVANTAGES

- 40% increase in stiffness and tensile strength over lower carbon fiber-loaded products
- No reduction in impact strength
- Improved Z layer properties
- Electrostatic dissipative (ESD)
- Almost no shrinkage or curl

Prints on open platforms including Ultimaker S5, Raise3D, Method X and Taz[®] Pro Platforms

DIAMETERS

1.75mm and 2.85mm



Questions? Visit JabilAdditive@jabil.com, jabil.com/filaments

For the latest print profiles, search for Jabil Engineered Materials in the Cura Marketplace.

Learn More About PA
4535 CF

