

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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