

SAKATA 3D PA-CF15 (Nylon) filament consists of a 15% carbon fiber reinforced and heat stabilized copolyamide with improved mechanical properties, abrasion resistance. Its main characteristics are improved stiffness, high mechanical properties and abrasion resistance whilst maintaining excellent polyamide chemical properties. It also shows a good adherence between layers and low shrinkage when printing. Ideal for engineering and industrial applications. Made in Spain by POLIMERSIA GLOBAL S.L.

FILAMENT SPECIFICATIONS	Unit	Value
Diameter	mm	1.75 ± 0.03
Max. roundness deviation	mm	0.03
Net weight	g	850

PHYSICAL PROPERTIES	Standard	Unit	Value
Density	ISO 1183	g/cm ³	1.18
Moisture absorption	ISO 62	%	2.5
Water absorption	ISO 62	%	8.0
MECHANICAL PROPERTIES	Standard	Unit	Value (dry/cond.)*
Tensile modulus	ISO 527	MPa	9,000 / -
Tensile strength	ISO 527	MPa	120 / -
Elongation at break	ISO 527	%	4 / -
Flexural modulus	ISO 178	MPa	8,000 / -
Flexural strength	ISO 178	MPa	180 / -
Charpy unnotched impact strength	ISO 179	KJ/m ²	60 / -
Charpy notched impact strength	ISO 179	KJ/m ²	4 / -
THERMAL PROPERTIES	Standard	Unit	Value
HDT (0.45 MPa)	ISO 75	°C	180

* dry = dry as moulded / cond.= conditioned according to ISO 1110

PRINT SETTINGS	Unit	Value
Type of printer	-	Enclosed
Nozzle temp.	°C	235 - 260
Type of nozzle	-	Hardened steel
Bed temp.	°C	> 65
Type of bed	-	Glass or PEI
Adhesive	-	Yes
Fan speed	%	0
Layer height	mm	0.02
Print speed	mm/s	30 - 100
Dry specification	Before printing	> 8 hours at 70 °C (drybox)
	During printing	70 °C (drybox)

Certifications / Approvals

SAKATA 3D PA-CF15 filament is not certified for food contact either medical applications.

Safety Considerations

Good general ventilation of the workplace is recommended.

Disclaimer

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