LUMAS POLYMERS

LUMAS PA 4000 NATURAL PRINT SETTINGS

GETTING THE MOST OUT OF LUMAS ENGINEERED MATERIALS POWDER

A very durable nylon powder, PA 4000 has well-balanced material characteristics that are ideal for a wide variety of applications. The detail resolution, excellent surface finish, and 34% elongation at break ensures this bright white material meets your product requirements. The chemical resistance and various finishing possibilities make PA 4000 ideal for open-sourced laser sintering 3D printers.

LUMAS ENGINEERED MATERIALS RECOMMENDED PRINT SETTINGS

PRINT TEMPERATURE

Part Bed Temp 168°C
Piston Temp 140°C
Cylinder Temp 140°C
Feed Temp 140°C

LAYER THICKNESS

0.12 mm

FILL SETTINGS

Fill Laser Power 70W
Fill Scan Spacing 0.3
Fill Scan Count 1

COLORS

- Natural

APPLICATIONS

- Functional prototypes
- Complex geometries
- Low temperature duct work
- Caster housings
- Housings and enclosures
- Parts with snap-fit features

ADVANTAGES

- Excellent tensile elongation and impact strength
- Exceptional powder flowability and melt wet-out
- Produces dense parts with an excellent surface finish
- Material has potential for high recyclability
- Color stability

QUESTIONS? CONTACT US: CUSTOMER_SERVICE@LUMASPOLYMERS.COM

Due to the large variety of printers and part geometries, the given process parameters are a guideline.

For additional information, visit lumaspolymers.com