

LUMAS PA 4050 GB NATURAL PRINT SETTINGS

GETTING THE MOST OUT OF LUMAS ENGINEERED MATERIALS POWDER

PA 4050 GB has well-balanced material characteristics that are ideal for applications that require durable, high-quality parts. The detail resolution and excellent surface finish allow for solid-built parts. Multiple finishing possibilities make PA 4050 GB ideal for open-sourced laser sintering 3D printers.

LUMAS ENGINEERED MATERIALS RECOMMENDED PRINT SETTINGS

PRINT TEMPERATURE



Part Bed Temp 168°C
Piston Temp 155°C
Cylinder Temp 155°C
Feed Temp 150°C

LAYER THICKNESS



0.12 mm

FILL SETTINGS



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

COLORS

Natural White

APPLICATIONS

- Functional prototypes
- Complex geometries
- Low temperature duct work
- Caster housings
- Housings and enclosures

ADVANTAGES

- Higher stiffness than PA 4000
- Produces dense parts with an excellent surface finish
- Color stability
- Relatively isotropic performance

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