

# PA 0600 FILAMENT

## RECOMMENDED PRINT SETTINGS

### BEST ADVICE FOR SUCCESSFUL PRINTING EXPERIENCE

- Make sure filament is dry prior to printing.
- Use in-line drying or dry in an oven at 70-75° C for several hours and repeat as necessary.
- Use a CC 0.6 core from Ultimaker.
- Do not print at a temperature above 240° C.
- Clean the print core after every long build or after several short builds.



#### PRINT TEMPERATURE

- 235° C



#### BED TEMPERATURE

- 50° C - 60° C



#### PRINTING SPEED

- Print Speed: 40 mm/s
- Infill Speed: 40 mm/s
- Wall Speed: 25-30 mm/s
- Top/Bottom Speed: 30m/s
- Initial Layer Speed: 20 mm/s



#### COOLING

- Regular Fan Speed: 20%
- Max Fan Speed: 100%



#### BED ADHESION

- Use a Skirt while printing
- Use PVA glue stick on glass
- The Magigoo HT solution provides great adhesion and down-surface quality



#### OTHER TIPS

- Turn the material flow rate for the top and bottom layer up to 103%.

If using Ultimaker Cura, enable the Lumas PA 0600 material profile available in the Marketplace or manually type in the settings from the information above.

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## PA 0600 FILAMENT

PA 0600 filament is a polyamide/polyketone alloy with high stiffness, good wear resistance, low friction and self-lubricating characteristics. The high stiffness and self-lubricating qualities make post-print machining, such as fly cuts, thread taps and heat stakes, simple and effective. Compared to other tribologically similar polymers such as POM and PVDF, which are commonly used for similar applications, PA 0600 releases no odors or toxic fumes during processing, exhibits low warp and has similar dynamic and static coefficient of friction.

### APPLICATIONS

Any application where high dimensional stability and lubricity is required

- Gears, bearings and rollers
- Parts requiring knurling
- Jigs, fixtures and tooling
- Work-holding devices, posts, nests etc.

### ADVANTAGES

- Excellent machinability
- High strength and stiffness
- Good wear and abrasion resistance
- Low coefficient of friction
- Excellent chemical resistance
- Low warp
- Good dimensional stability
- Non-marring

### BASIC DRYING TIPS

- Dry at 70-75 C. Long drying cycles (>6 hours) are ideal.
- Signs that the material needs to be dried:
  - Material will start to print with more stringing than normal
  - The surface finish will be rough
  - Mechanical properties are not as expected
  - In extreme cases, bubbling, hissing or generation of steam during printing



**QUESTIONS? VISIT [LUMASPOLYMERS.COM](https://lumaspolymers.com) FOR THE LATEST PRINT PROFILES.**