LUMAS POLYMERS

PA 1500 FR FILAMENT

RECOMMENDED PRINT SETTINGS

PRINT TEMPERATURE

- The optimal printing range is 285 – 305°C

BED TEMPERATURE

- Up to 105°C with ABS slurry, or up to 140°C using a PVP-based glue stick.

PRINTING SPEED

- Base printing speed of 40 mm/s
- Infill speed of 40 mm/s
- Wall speed of 32 mm/s
- Initial layer speed of 20 mm/s

COOLING

- For best results, do not use a cooling fan. Enabling bridging settings will help improve overhang quality.

BED ADHESION

- Suitable adhesion can be obtained by using a slurry of ABS in acetone, or with a PEI sheet with a PVP-based glue stick. A brim should be used to help with bed adhesion.

OTHER TIPS

- If possible, print in an enclosed area that can maintain a temperature of 50-55°C to help minimize warping or cracking.

If using Ultimaker Cura, enable the Lumas PA 1500 FR material profile available in the Marketplace or manually type in the settings from the information above.

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APPLICATIONS

- Automotive, aerospace, general manufacturing
- Housings (including battery housings)
- Welding fixtures
- Brackets
- Motor mounts
- Parts for aerospace or automotive applications

ADVANTAGES

- Made from UL V-0 yellow-card-certified raw materials
- Stiff with excellent impact strength and ductility
- Very good flame retardancy and self-extinguishing properties
- High impact resistance
- Testing performed in a qualified lab demonstrates V-0 burn properties on a printed part down to 2mm thickness when printed with the correct design and print parameters
- Prints on open platforms including Ultimaker S5, UM 3, Raise3D, Method X and Taz® Pro Platforms

DIAMETERS

- 1.75mm
- 2.85mm

QUESTIONS? VISIT LUMASPOLYMERS.COM FOR THE LATEST PRINT PROFILES.