

PA 4035 CF 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

- 240 – 260° C



BED TEMPERATURE

- 70° C



PRINTING SPEED

- Print Speed: 45 mm/s
- Infill Speed: 45 mm/s
- Wall Speed: 30 mm/s
- Top/Bottom Speed: 25m/s
- Initial Layer Speed: 20 mm/s



COOLING

- 100%



BED ADHESION

- Use a Skirt with a thick layer of PVA glue stick on glass.



OTHER TIPS

- Make sure to use plenty of glue on glass. If any warping occurs, use more glue.
- Works well with support material. PVA support works better than HIPS.

If using Ultimaker Cura, enable the Lumas PA 4035 CF material profile available in the Marketplace or manually type in the settings from the information above.

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PA 4035 CF FILAMENT

PA 4035 CF is an ESD-safe (electrostatic dissipative), carbon-fiber-reinforced PA12 copolymer providing greater stiffness, strength and toughness over similar materials on the market. This is a great material for printing items that require extra strength and toughness.

APPLICATIONS

- Automotive, aerospace, general manufacturing, medical
- Ducting for automotive and aerospace
- Casting patterns
- Composite tooling
- Prosthetics
- Aluminum replacement

ADVANTAGES

- High strength, stiffness and toughness
- High-impact strength
- Superior printed part surface finish quality
- Surface resistivity of $\leq E9$ for ESD sensitive applications
- Mechanical properties can be tailored by adjusting fill orientation
- 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](https://lumaspolymers.com) FOR THE LATEST PRINT PROFILES.