

PA 4500 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

- 50° C



PRINTING SPEED

- Print Speed: 70 mm/s
- Wall Speed: 30 mm/s
- Infill Speed: 70 mm/s
- Initial Layer Speed: 20 mm/s



COOLING

- Regular Fan Speed: 20%



BED ADHESION

- PVA glue stick



OTHER TIPS

- Store filament dry and keep dry during printing

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 4500 FILAMENT

PA 4500 Filament is a low warp, neat Nylon copolymer that has good lay flat/low warp properties, excellent appearance, strength in both XY and XZ directions, toughness, and can be used at lower processing temps (240-260° C). Along with better printability, PA 4500 filament also delivers better appearance, over 100% elongation at break and better overall strength compared to other commercial PAs and products like PETG and PLA.

APPLICATIONS

Component production of less than 20,000 per year with complex geometries that require good wear properties and appearance are required but also strength and durability.

Examples Include:

- Slides
- Screen printing pallets
- Automation sleds
- Adaptors for fluid and materials handling
- End of arm tooling (EOAT)
- Masking covers
- Die cast models and patterns
- Clips
- Covers
- Housings
- Gears

ADVANTAGES

- Greater Z strength
- Over 100% elongation at break
- 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.