

# LUMAFUSE PA 4535 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

- 250 – 270° C



#### BED TEMPERATURE

- 60° C



#### PRINTING SPEED

- Print Speed: 60 mm/s
- Wall Speed: 40 mm/s
- Infill Speed: 60 mm/s
- Initial Layer Speed: 20 mm/s



#### COOLING

- Fan Speed: 10%



#### BED ADHESION

- PVA glue stick



#### OTHER TIPS

- Filament is very stiff and can create feeding issues, these can be mitigated if a small amount of moisture is absorbed from the atmosphere without sacrificing print quality.
- Hardened steel or ruby tipped nozzles are required.

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

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# LUMAFUSE PA 4535 CF FILAMENT

LumaFuse PA 4535 CF is among the strongest PA co-polymer carbon fiber filaments available on the market, delivering increased strength and stiffness. LumaFuse PA 4535 CF has the highest carbon fiber loading available in the industry, providing 40% improvement in tensile strength, impact strength, Z strength and elongation at break, with the added benefit of being ESD safe.

## APPLICATIONS

Great for parts requiring increased stiffness and strength.

Examples include:

- Aluminum replacement parts
- Housings requiring tight printing dimensional tolerances
- Jigs, fixtures and tooling
- Clips
- Brackets
- Retainers
- Covers
- Housings

## ADVANTAGES

- 40% increase in stiffness and tensile strength over lower carbon fiber-loaded products
- No reduction in impact strength
- Improved Z layer properties
- Electrostatic dissipative (ESD)
- Almost no shrinkage or curl
- Prints on open platforms including Ultimaker S5, Raise3D, Method X and Taz® Pro Platforms

## DIAMETERS

- 1.75mm
- 2.85mm



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