



SUGGESTED PRINT SETS (1)			
Suggested print sets	unit	value	test method
extruder temp	C°	240-270	internal
plate temp	C°	80-90	internal
min. nozzle diameter	mm.	0,2	internal
fan	%	0-10	internal
print speed	mm/l°	40	internal
PROPERTY			
Physical			
Specific gravity	g/cm3	1.49	ISO 1183
Mechanical at 23°C / 50% rh			
Tensile strength	MPa	55	ISO 527
Elongation at max. force	%	1,2	ISO 527
Modulus of elasticity	GPa	6	ISO 527
Thermal			
HDT A	°C	90	ISO 75
Continuos service temp 20.000h	°C	120	IEC 3167 A
Service temperature max 200h lifetime	°C	160	ISO 3167 A
Flamabilty			
th. 0.4 mm	V	0	UL 94V
th. 0.8 mm	V	0	UL 94V
th. 1.6 mm	V	0	UL 94V

Disclaimer

The above information is provide in good fact .Treedfilaments is not responsible for any processing which may occur to product finished articles , packaging materials and other .

Further Treedfilaments makes no warranty or representation of any kind regarding the information given or the product described and expressly disclaims all implied warranties , representations and conditions , including without limitation all warranties and conditions of quality , merchantability and suitability or fitness for particular



Railway conformity

The statement of conformity is made considering the decision rule according to DIN EN 45545-2 (02-2016). A material is considered to fulfill the requirements of The DIN EN 45545-2, if the determinate value complies with the limit given in the table 2

Table 2

Requirement set.	Test method.	Parameter (unit).	Max. Or Min.	HL1	HL2	HL3
R22 R23 R24.	T01.	OI %.	Minimum.	28.	28.	32.

ADDITIONAL INFORMATIONS

In General filaments made with PAKK can be processed on conventional 3D printer using FDM / FFF technology.

PAKK is a special Polyamide developed for 3D printing and to obtain best results we recommend pre drying the filaments at 90° for 4 h. Increase drying time for spools up 1 kg.

Don't leave the filament stopped inside the nozzle more than 20 min. If that down the temperature under 210°, better stop the thermal control.

(1) Suggested print set merely represent a recommendation for general use . Every printer necessity a specific set , nozzle temp, bed temp, etc .

Disclaimer

The above information is provide in good fact .Treedfilaments is not responsible for any processing which may occur to product finished articles , packaging materials and other .

Further Treedfilaments makes no warranty or representation of any kind regarding the information given or the product described and expressly disclaims all implied warranties , representations and conditions , including without limitation all warranties and conditions of quality , merchantability and suitability or fitness for particular purpose .