

Recommended FDM Print Settings

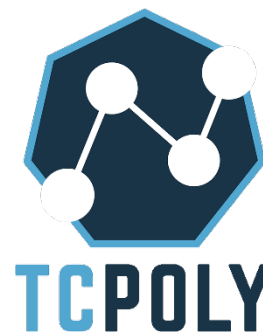
Ice9™ NYLON

Thermally conductive, electrically non-insulating plastic

Filament product code: TC-PA-175-1000

Pellet product code: TC-PA-000-1000

Properties based on 3D printed samples



GENERAL PROPERTIES		VALUE	
Base Material		Polyamide	
Color		Dark gray	
Filament diameter		1.75 ± 0.1 mm	
TEMPERATURE SETTINGS		VALUE	UNITS
Extruder temperature		265-310	°C
Bed temperature		70-100	°C
Chamber temperature		60-70	°C
Cooling fan		Bridging only, 60	%
SLICING SETTINGS		VALUE	UNITS
Print speed		60-150	mm/s
Layer height		0.2-0.7	mm
Retraction distance		4	mm
Extra restart distance		0.5	mm
Infill for best thermal performance		95-100	%
ADDITIONAL GUIDELINES			
Nozzle diameter		0.4-1.0 mm	
Extruder type		Direct drive or Bowden	
Print bed preparation		Glue stick on PEI or glass	
Storage instructions		Sealed bag	
Drying instructions		4 hour @ 70°C	

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