

## 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.
- Do not print at a temperature above 240° C.
- Clean the print core after every long build or after several short builds.
- Use a CC 0.6 core from Ultimaker.



#### 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.

## 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 and 2.85mm



Questions? Visit [JabilAdditive@jabil.com](mailto:JabilAdditive@jabil.com), [jabil.com/filaments](http://jabil.com/filaments)

For the latest print profiles, search for Jabil Engineered Materials in the Cura Marketplace.

Learn More About PA  
4035 CF

