technical datasheet

F3 PA-CF Pro

Dezember 2024

www.fiberthree.com

General information

Properties

- *PA 6 blend*
- *15 weight.-% carbon fiber*
- *very high tensile strength*
- *low warping effect*
- *excellent adhesion to epoxy based fiber plates*
- *chemical resistant to many oils, carburant and chemicals*
- *good hydrolysis resistance*
- *matte black surface finish*

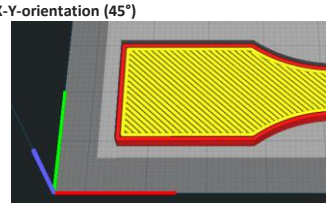
Mechanical properties	Test method	Unit	Typical value	Quality grade acc. VDI 3405 Part 7
Density	DIN EN ISO 1183	g/ cm³	1,25	
Modulus of Elasticity printed specimen x-y (0°) *	DIN EN ISO 527-2 Typ 1A *	MPa (N/mm²)	10500	10
Modulus of Elasticity printed specimen x-y (90°) *	DIN EN ISO 527-2 Typ 1A *	MPa (N/mm²)	4700	7
Tensile strength printed specimen x-y (0°) *	DIN EN ISO 527-2 Typ 1A *	MPa (N/mm²)	110	10
Tensile strength printed specimen x-y (+ 45°/-45°) *	DIN EN ISO 527-2 Typ 1A *	MPa (N/mm²)	85	8
Tensile strength printed specimen x-y (90°) *	DIN EN ISO 527-2 Typ 1A *	MPa (N/mm²)	70	7
Tensile stress printed specimen x-y (0°)	DIN EN ISO 527-2 Typ 1A*	MPa (N/mm²)	112,73	
Elongation printed specimen (0°)	DIN EN ISO 527-2 Typ 1A*	%	0,98	--
Flexural modulus E_f printed specimen (+ 45°/-45°)	DIN EN ISO 14125 (Method B)	GPa (kN/mm²)	4,78	
Impact strength printed specimen	DIN EN ISO 179eU	kJ/m²	47	
Impact strength printed specimen (notched)	DIN EN ISO 179eB	kJ/m²	5,46	

* Test specimen printed: 1.75mm filament; v=50 mm/s; Orientation layers in 0°/ 90°/ +-45°; conditioned 24h at 50% RF and 23° C
Test specimen polyamide lite: Raise3D Pro2, nozzle 0.6mm, temp. nozzle 305°C, temp print bed 70°C; layer height 0.15mm

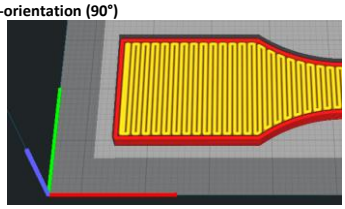
Tensile test PA with 1mm/min. These are target values for optimal print quality. Values might vary greatly with the same settings, depending on the system Nozzle - Printer - Gcode.

Orientation of printed specimen

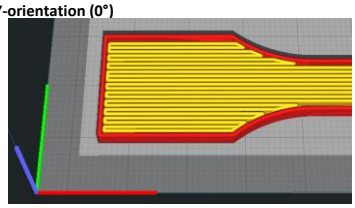
X-Y-orientation (45°)



X-Y-orientation (90°)



X-Y-orientation (0°)



Thermal properties	Test method	Unit	Typical value
Glass transition temp.	DIN ISO 11357	°C	68
Heat distortion temp. (HDT A@1,8 MPa)	DIN ISO 75	°C	120 °C
Electrical properties	**Test method**	**Units**	**Typical value**
Insulation resistance	IEC 60167	Ohm*m	$>10^{10}$
Surface resistance	IEC 60093	Ohm*m	$>10^{10}$
Other properties	**Test method**	**Units**	**Typical value**
Water absorption (after 24h)	DIN ISO 62	%	>0,3
Recommendations	**Test method**	**Units**	**Typical value**
Temperature nozzle	Fiberthree GmbH	°C	270 - 285
Temperature build plate	Fiberthree GmbH	°C	Max. 80
Nozzle diameter	Fiberthree GmbH	mm	> 0,25
Fan cooling	Fiberthree GmbH	%	not recommended
Layer height	Fiberthree GmbH	mm	≥ 0,10
Printing speed	Fiberthree GmbH	mm/s	50
Infill	Fiberthree GmbH	%	0 - 100
Retraction (direct drive/ bowden system)	Fiberthree GmbH	mm (@ 50mm/sec)	direct drive min. 2mm / bowden system min. 6mm
Material build plate	Fiberthree GmbH		carbon fiber, glass fiber or phenolic resins, glass, PEI
Recommended nozzle	Fiberthree GmbH		wear resistant nozzles: hardened steel, tungsten, nozzles with industrial sapphire or ruby or ceramic
Recommended parts	Fiberthree GmbH		high strength lightweight parts, parts with low electrical conductivity

EU & REACH conformity			
SVHC > 0,1 % (List dated December 2023)	given	no substances included	
Regulated substances acc. 2015/863/EU (RoHS 3)	given	no substances included	

Legal disclaimer

Technical properties or values are related to the thermoplastic base material for filament production if not mentioned differently.
Any recommendation made for use of seller's materials are made to the best knowledge and are based upon prior tests and experience of the seller. Seller does not guarantee the results to be obtained and all such recommendations are non-binding and do not constitute any representation and do not affect in any way buyer's obligation to examine and test the seller's goods with regard to their suitability for buyer's foreseen purposes.
No information given by the seller is to be construed in any way as a guarantee regarding charactaristics or duration of use, unless such information has been explicitly given as a guarantee.