

RECOMMENDED 3D PRINT PARAMETERS

Nozzle Temperature:
220 - 250 °C / 428 - 482 °F

Closed Chamber:
Yes

Bed Temperature:
85 - 100 °C / 185 - 212 °F

Bed Material:
PP tape or PP adhesive

Nozzle Diameter:
≥ 0.4 mm

Print Speed:
20 -50 mm/s

Brim:
Yes, Min 5 mm

Cooling Fan:
Yes (Off for the first 2 layers)

- Optional Settings:**
- **Layer Height 0.3 mm**
Top Solid Layers: 3
Bottom Solid Layers: 2
 - **Layer Height 0.2 mm**
Top Solid Layers: 4
Bottom Solid Layers: 3

PHYSICAL PROPERTIES

Density	0.90 g/cm ³
Melting Point	136 °C / 276.8 °F
Color	Natural
Diameter	1.75 ± 0.05 mm
Net Weight	800 gr

CHARACTERISTICS

Pros

- Semi-flexible
- Low Density
- Good chemical resistance
- Good heat resistance
- Good Impact resistance
- Integral hinge property
- Good bonding between layers

Cons

- Poor UV resistance
- Shrinkage

STORAGE

Put in dry place and avoid direct sunlight

NOTICE

The information contained in this sheet are based on our knowledge and experience. Therefore, KREAFil is not responsible for the use of the information.

The given data provided may change without prior notice