

CFsys™ FDM Printing Material

Technical Data Sheet

CFsys™ A PAHT-CF

15%短切碳纤维增强特种高温尼龙3D打印材料。

High temperature Polyamide based with 15% chopped carbon fiber reinforced FDM material.

产品介绍 Product Description

CFSYS™ A PET-CF专为FDM 3D打印工艺开发，基材选用高温尼龙，具有低吸湿，高强度，高耐磨性，耐化学性优异和高耐热性的特点。打印过程中尺寸稳定性好，无翘边无收缩现象，并且可以与CFSYS™S-PAHT易剥离支撑材料配合使用，解决复杂模型支撑面成型效果差的难题。

CFSYS™ A PAHT-CF is specially developed for FDM 3D printing process, and its substrate material is high temperature nylon, which has low density, low moisture absorption, high strength, high abrasion resistance, excellent chemical resistance and high heat resistance. It also has good dimensional stability, no warpage and no shrinkage during the printing process, and can be used with CFSYS™ S-PAHT Quick-Remove Support material to solve the problem of poor molding effect on the support surface of complex models.

产品亮点 Product Advantages

- **智能纤维增强技术**

CFsys®通过生产工艺控制增强纤维在材料基体内的分散与分布，使增强纤维在材料内形成网状骨架结构，并承担大部分由材料基体传递的载荷。CFsys®通过Smart Fiber Reinforced Technology大幅度提高了材料的机械性能和耐热性，并通过增强纤维网状结构释放了打印过程中的内应力，打印件尺寸稳定性好，无翘曲问题。

- **Smart Fiber Reinforced Technology**

CFSYS® controlling the dispersion and distribution of chopped carbon fibers within the material matrix during the extrusion process, the fibers form a mesh skeleton structure within the material and bear most of the load transferred by the material matrix. Smart Fiber Reinforced Technology greatly improves the mechanical properties and heat resistance of the material, and releases the internal stress during the printing process through the fiber mesh structure, resulting in good dimensional stability of the printed part and no warpage.

- **低吸湿性**

CFSYS™ A PAHT-CF基材使用高温尼龙，饱和吸湿率仅为普通PA6的十分之一，彻底解决尼龙材料吸湿前后机械性能与尺寸稳定性变化极大的缺陷。

- **Low Moisture Sensitivity**

CFSYS™ A PAHT-CF based on modified high temperature nylon, whose saturated moisture absorption rate is only one tenth of ordinary PA6, completely solving the defects of the mechanical properties and dimensional stability of nylon materials that change greatly after absorbed moisture.

- **超强耐磨性**

CFSYS™ A PAHT-CF摩擦系数低，具有自润滑性，耐磨性极佳。轻松实现各类高强度齿轮和耐磨要求工业应用。

- **Super Abrasive Resistance**

CFSYS™ A PAHT-CF has a low coefficient of friction, self-lubricating properties and excellent wear resistance, which can easily meet all kinds of high-strength gears or industrial applications with high wear requirements.

产品详情 Available

颜色 Color: 黑色 Black

线径 Diameter: 1.75mm

净重 Net Wet: 1kg

物性表 Material Properties

测试项目 Property	测试方法 Test Method	典型值 Typical value		
密度 Density	ISO 1183	1.20 g/cm ³		
饱和吸湿率 Water absorption	ISO 62: Method 1	1.37 %		
熔点 Melting Temperature	ISO 11357	237°C		
熔融指数 Melt index	300°C, 2.16kg	3.4 g/10min		
		未退火 Unannealed	退火后 Annealed	退火后 饱和吸湿处理 Saturation hygroscopic treatment after annealed
热变形温度 Determination of temperature	ISO 75: Method A (0.45 MPa)	84.8°C	190.7°C	194.5°C
	ISO 75: Method B (1.80 MPa)	82.0°C	117.5°C	101.5°C
拉伸强度 (X-Y) Tensile strength(X-Y)	ISO 527	93.15±1.64MPa	95.53±3.62 MPa	94.51±2.15 MPa
拉伸模量 (X-Y) Young's modulus (X-Y)		7492.51±329.13MPa	8114.10±539.02 MPa	7269.74±682.72 MPa
断裂伸长率 (X-Y) Elongation at break (X-Y)		1.92±0.10 %	1.52±0.11 %	2.33±0.20 %
弯曲强度 (X-Y) Bending strength (X-Y)	ISO 178	144.00±1.87MPa	141.82±4.34 MPa	157.53±5.78 MPa
弯曲模量 (X-Y) Bending modulus (X-Y)		6727.22±382.20MPa	7098.40±440.49 MPa	6983.35±474.51 MPa
缺口冲击强度 (X-Y) Charpy impact strength(X-Y)	ISO 179	10.37±0.27KJ/m ²	5.62±0.67 KJ/m ²	8.61±1.64 KJ/m ²
拉伸强度 (Z) Tensile strength (Z)	ISO 527	51.03±2.18MPa	/	/
拉伸模量 (Z) Young's modulus (Z)		3869.82±174.36MPa	/	/
断裂伸长率 (Z) Elongation at break (Z)		1.56±0.07%	/	/

试样打印参数: 喷嘴温度320°C, 底板加热80°C, 打印速度45mm/s, 填充率100%, 填充角度±45°

退火条件: 100°C退火8小时

Specimens printed under the following conditions: Nozzle temp 320°C, Bed temp 80°C, Print speed 45mm/s, Infill 100%, Infill angle ±45°

Post-processing: 100°C Annealing 8 hours

建议打印参数 Recommended printing conditions

喷头温度 Nozzle Temperature	300-320°C
建议喷嘴大小 Recommended Nozzle Diameter	0.4-1.0 mm
建议底板材质 Recommended build surface treatment	PEI底板或者涂抹PVP固体胶 PEI or Coating with PVP glue
底板温度 Build plate temperature	70-90°C
Raft间距 Raft separation distance	0.12-0.16 mm
冷却风扇 Cooling fan speed	关闭 OFF
打印速度 Print speed	30-120 mm/s
回抽距离 Retraction distance	1-3 mm
回抽速度 Retraction speed	1800-3600 mm/min
建议支撑材料 Recommended support material	CFSYS™ S-PAHT Quick-Remove Support

Additional Suggestions:

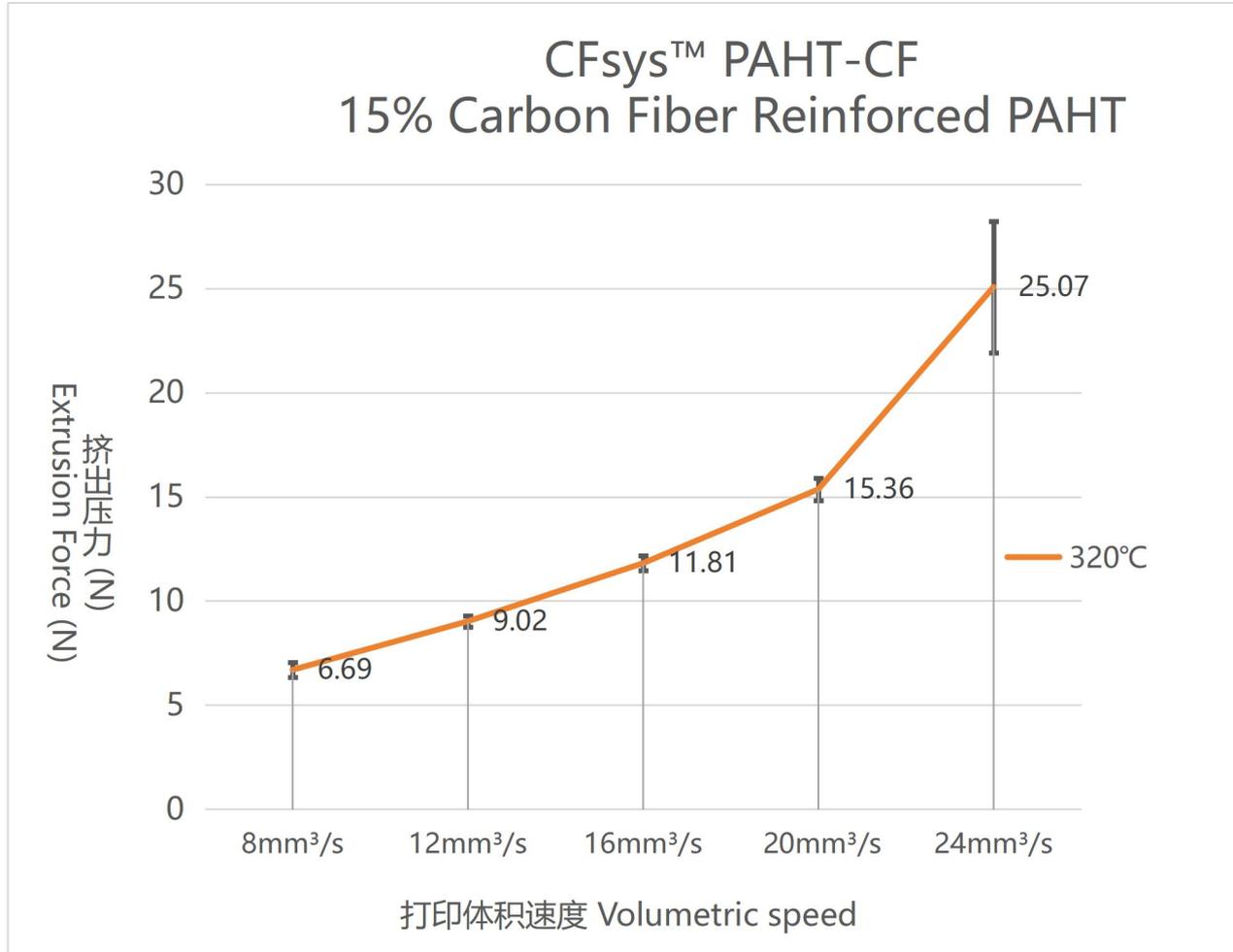
1. Nylon material is very easy to absorb moisture within the environment, and printing after absorbing moisture will result oozing, extruding with bubbles and rough surface appearance, thus reducing print quality. It is recommended that put the filament into a dry box (humidity below 15%) immediately after opening the CFSYS™ A PAHT-CF vacuum foil bag for printing. Please put the unused filament back into the original aluminum foil bag for sealed storage.
2. After the material is damp, there will be more printing oozing, bubbles extruded and rough printing surface. Please dry the filament in an oven at 80-100°C for 4-6h to restore the printing quality of CFSYS™ A PAHT-CF.
3. It is recommended that the thickness of the heating block should no less than 12mm. It is recommended to use hardened steel and above grade nozzles made by CFSys, which can effectively improve the print quality. Besides, it is recommended that the thickness of the heating block is longer 12mm.
4. After the printing is completed, the CFSYS™ A PAHT-CF printed part can be annealed to further improve the strength of print part. Annealing conditions: leave printing part in an oven at 80-100°C for 4 to 8 hours and cool to room temperature naturally.

其他建议:

1. 尼龙材料非常容易吸收环境内的水分，吸湿后打印会出现拉丝，挤出有气泡等现象，降低打印质量。建议您打开CFSYS™ A PAHT-CF真空铝箔袋包装后立即将线材放入干燥盒内（湿度控制在15%以下）进行打印。不用的线材请放回原包装铝箔袋内密封保存。
2. 材料受潮后会出现打印拉丝增多，挤出有气泡，打印表面质量粗糙等现象。请将线材放入80-100°C烘箱内干燥4-6h，即可恢复CFSYS™ A PAHT-CF的打印质量。
3. 建议选用硬化钢及以上等级喷嘴，可以有效提高打印质量，建议加热块厚度不小于12mm。
4. 打印完成后可以对打印件进行退火处理，可以进一步提高CFSYS™ A PAHT-CF打印件的强度，退火条件：80-100°C温度下放置4-8小时后取出即可。

挤出压力与打印流量速度测试

Extrusion Force vs Print Volumetric Speed Test



测试参数: 12mm长度铜制加热块, BMG挤出机, CFsys硬化钢喷头, 喷嘴大小0.4mm, 层高0.2mm。

Test parameters: 12mm length brass heat block, BMG extruder, CFsys Hardened Steel Nozzle, Nozzle size 0.4mm, Layer Height 0.2mm.