

PA 4535 CF Filament

Recommended Print Settings



Print Temperature

The optimal printing range is 250 - 270°C



Cooling

Fan Speed: 10%



Bed Temperature

A bed temperature of 60° C will provide the best adhesion during printing.



Bed Adhesion

PVA Glue Stick



Printing Speed

Base printing speed of 60 mm/s
 Infill speed of 60 mm/s
 Wall speed of 40 mm/s
 Initial layer speed of 20 mm/s



Other Tips

- Filament is very stiff and can create feeding issues, these can be mitigated if a small amount of moisture is absorbed from the atmosphere without sacrificing print quality.
- Hardened steel or ruby tipped nozzles are required.

If using Ultimaker Cura, enable the Jabil PA 4535 material profile available in the Marketplace or manually type in the settings from the information above.

Disclaimer: Due to the large variety of printers and part geometries, the given process parameters are a guideline.

PA 4535 CF Filament

JABIL

PA 4535 CF is among the strongest PA co-polymer carbon fiber filaments available on the market, delivering increased strength and stiffness. PA 4535 CF has the highest carbon fiber loading available in the industry, providing 40% improvement in tensile strength, impact strength, Z strength and elongation at break, with the added benefit of being ESD safe.

Applications

Great for parts requiring increased stiffness and strength

Examples include:

- Aluminum replacement parts
- Housings requiring tight printing dimensional tolerances
- Jigs, fixtures and tooling
- Clips
- Brackets
- Retainers
- Covers
- Housings

Advantages

- 40% increase in stiffness and tensile strength over lower carbon fiber-loaded products
- No reduction in impact strength
- Improved Z layer properties
- Electrostatic dissipative (ESD)
- Almost no shrinkage or curl

Prints on open platforms including Ultimaker S5, Raise3D, Method X and Taz® Pro Platforms

Diameters

1.75mm and 2.85mm



jabil.com/filaments

Questions? Contact us:
JabilAdditive@jabil.com



Learn More About
PA 4535 CF

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