

## Jabil PA 0600 Filament

### Printing & Drying Guide



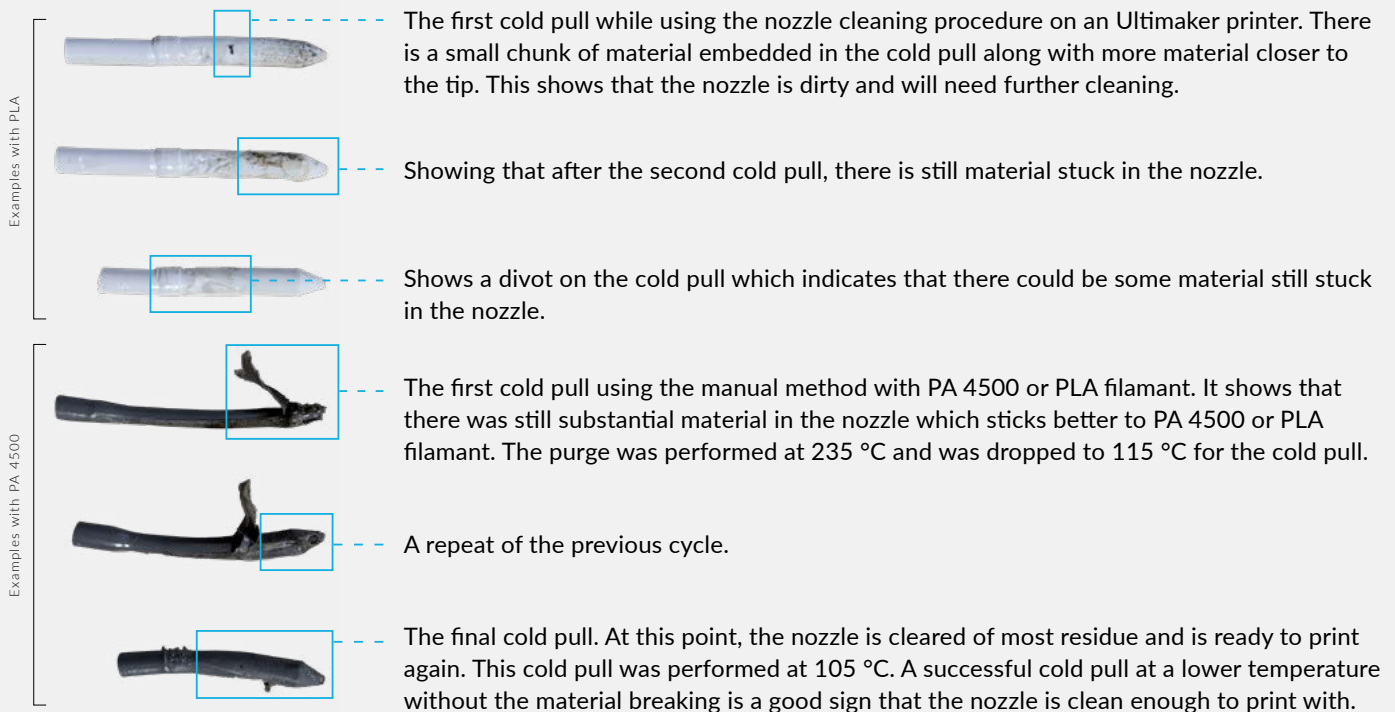
## Nozzle Cleaning

Note: this should be done after every several builds with PA 0600

- If available, run through the nozzle cleaning procedure for your machine. If unavailable, use the manual cleaning procedure below.
- Check the tip of the filament as it comes out of the nozzle and see if it is clean or if there are any black spots/divots on the tip.
- If there are black spots/divots on the material after running through the nozzle cleaning procedure (examples in image below), then run through the manual cleaning procedure while using PA 4500 (or other nylon).

### Manual Cleaning Procedure using Jabil PA 4500 or a PLA filament:

1. Set the nozzle temp to 235 °C
2. Push the filament through the nozzle until there is a steady flow of material
3. While continuing to push material through, decrease the nozzle temperature to 115 °C.
4. Keep pressure on the filament until the temperature drops below 160 °C.
5. Wait for the nozzle to reach 115 °C. Allow a few seconds for the filament to equilibrate to this temperature.
6. Using pliers, carefully pull the filament out of the print head.  
If the tip breaks in the print head during the cold pull, increase the cold pull temperature by 5 °C.



7. Examine the tip of the material. If it's dirty, repeat the process.

## Basic Printing Tips

- Do not print at a temperature above 240 °C, as this may lead to some material degradation and residue buildup in the nozzle, eventually leading to clogs.
  - If there is some under extrusion, a print core cleaning cycle may be required to remove any buildup of material in the hot end.
  - Larger print nozzles require less frequent cleaning.
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## Basic Drying Tips

- Dry at 70-75 °C. Long drying cycles (>6 hours) are ideal.
- Signs that the material needs to be dried:
  - Material will start to print with more stringing than normal
  - The surface finish will be rough
  - Mechanical properties are not as expected
  - In extreme cases, bubbling, hissing or generation of steam during printing

For more detailed drying advice, see **FFF Drying Tips** on the following page.

Most polymer filaments used in 3D printing can absorb moisture from the atmosphere. This decreases visual quality and mechanical properties and can lead to print failures. Materials will begin to absorb moisture as soon as they are exposed to humidity and the effects can be observed in as little as an hour for some materials.

There are two main concerns related to filaments and moisture:

1. How to dry filament that has absorbed moisture, and;
2. How to keep filament dry while printing.

While many of the advanced hobbyist or light industrial level printers incorporate some means of mitigating moisture uptake during printing, there is still a significant lack of effective off-the-shelf drying options. There are many approaches which range in cost and effectiveness. Unfortunately, there is no one-size-fits-all solution. This guide is intended to help you understand the factors that affect moisture uptake as well as some of the most effective means to dry and maintain dryness of filaments.

## Moisture Uptake

The table below describes some of the more common filament base materials, their rate of moisture absorption, the general impact of moisture absorption and typical drying conditions.

Polymer Family	Absorption Rate	Impact of Moisture Absorption	Typical Drying Time/Temperature <sup>1,2</sup>
PLA	Slow	Moderate	4 hr / 80 °C
ABS / ASA	Moderate	Severe	4 hr / 80 °C
TPU	Moderate	Severe	3 hr / 80 °C
PETG	Moderate	Moderate	6 hr / 70 °C
Polycarbonate	Moderate	Severe	4 hr / 80 °C
Nylon 12	High	Moderate	6+ hr / 80 °C
Nylon 6	Very high	Moderate	6+ hr / 80 °C

*Note 1: Typically, manufacturers will recommend drying conditions for their filaments.*

*Note 2: Many filament materials may tolerate higher drying temperatures, however, the spool may warp or the filament may degrade when exposed to higher temperatures for extended periods of time.*

For those fortunate enough to have a moisture balance, Karl Fischer Titrator, or other apparatus which can determine moisture content, a weight percentage of 0.10 or less is ideal for most filaments.

## Drying Tips

The filament drying rate is a function of temperature, ambient humidity and the tendency of a given material to hold onto water that it has absorbed. The rate of drying increases with temperature and decreases with higher ambient humidity. However, too much heat and the filament may tack together or the spool may warp.

There are several different methods for drying filament. Below is a list from most to least effective.

MOST EFFECTIVE  
-----  
LEAST EFFECTIVE

<b>Desiccating Oven</b>	A desiccating oven is a closed-loop system that actively removes moisture from the air, heats, and circulates. Set the oven to the manufacturer's recommended drying temperature. Let the material sit in the oven for several hours and re-test moisture content. Repeat until material is dry.
<b>Normal Oven</b>	Normal ovens reduce the humidity of the air simply by heating it up, making them less effective than desiccating ovens because they don't actively remove moisture from the air. The same procedure as a desiccating oven applies. Convection will improve drying rate.
<b>Dehydration</b> (PrintDry, food dehydrator)	Set device to recommended temperature for material and allow to dry for several hours or even days. Follow instructions of chosen device for temperature and drying times.
<b>Desiccant</b> (in sealed bag)	Placing a spool of filament in a sealed moisture-barrier bag with a suitable amount of dry desiccant will slowly dry out the filament, but can take as much as a week or more depending on the weight of filament and desiccant, the moisture content of the filament and the ambient temperature. Placing the sealed bag in a warm environment will improve the drying rate.

## Drying Methods to Avoid

The following methods **do not** provide effective drying and may ruin your filament or potentially even be dangerous.

- ⊘ Microwave
- ⊘ Toaster Oven
- ⊘ 3D Printer Build Plate
- ⊘ Heat Lamp

## Storage Tips

When the filament has been effectively dried, it must be stored in a dry environment during printing or until ready to print. Below are some options listed from most to least effective.

LEAST EFFECTIVE ----- MOST EFFECTIVE

### Enclosed Box with Dry Gas Purge

If you're fortunate enough to have access to a dry gas source (e.g., a nitrogen generator or desiccant-dried pressurized air), plumbing a line and running a trickle purge will keep material dry indefinitely. **Make sure to have an oxygen sensor in the room if using nitrogen.**

### Desiccant Dry Box

Fill a mesh bag with color changing desiccant and place it in an airtight tote with your filament and close the lid completely. This method works best if the tote is not going to be opened often.

### Sealed Bag with Desiccant

As noted in the Drying section above, storing filament in a sealed moisture-barrier bag with dry desiccant will typically keep filament dry, if not provide a slow rate of drying.

### Reduced Humidity Storage Box (e.g., StatPro)

Plug in and allow chamber humidity to drop. Once chamber is dry, place dry material inside and close door completely.