

# 3D Printer Filament NYLON

Made by Filkemp

**RAW MATERIAL**  
NYLON

**TECHNICAL DATASHEET**

**APPLICATION**  
3D Printing

## Material Specifications

DIAMETER & DIMENSIONAL TOLERANCE	Ø TOLERANCE	ROUNDNESS DEVIATION
1.65 – 1.75 mm	±0,10mm	max 3%

## Material Properties

DESCRIPTION	TEST METHOD	TYPICAL VALUE
Density	DIN 1183	1.25g/cm <sup>3</sup> at 20°C
Melting point	DIN EN ISO 11357	185– 195°C
Tenacity	DIN EN ISO 2062 L=500mm, V=500mm/min	Min. 35.0 cN/tex
Tensile Strength	DIN EN ISO 2062 L=500mm, V=500mm/min	Min. 100 daN
Elongation	DIN EN ISO 2062 L=500mm, V=500mm/min	Max. 35.0 ± 5.0%

### RECOMMENDATIONS

Suggested print temperature (guideline) 225-235°C  
Suggested print speed 30-40 mm/s  
Suggested bed temperature not needed  
Advised Fan air 0% (off)

### STORAGE INSTRUCTIONS



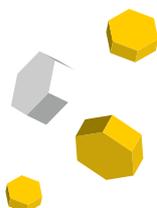
OPTIMAL STORAGE  
TEMPERATURE

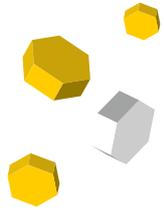


UNUSED  
EXPIRATION DATE



COOL, DRY PLACE  
AWAY FROM SUNLIGHT





## 3D Printer Filament

# NYLON

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## RECOMMENDATIONS

### HOW DOES MOISTURE SENSITIVITY IMPACT NYLON?

NYLON is very hygroscopic material. This means that it attracts moisture from the air which can have a negative impact on the printing performance. After printing, it is strongly recommended to place the spool into a vacuum bag (without any silica\*) for storage.

*\* More often than not silica gel sachets contain a higher ppm moisture content than the filament itself which would have a reversed effect.*

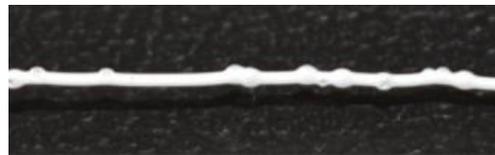
### WHEN IS NYLON TOO WET TO PRINT?

If the NYLON is too wet, this can be evaluated visually:

- 1 - Heat the nozzle to the preferred temperature for your printer.
- 2 - Extrude or push the filament through the nozzle.

Tiny bubbles appearing when the filament is coming out of the nozzle indicates expanding moisture and can cause unwanted printing effects.

When a clear filament is not perfectly clear after extruding, and has milky white streaks through it, it is also too wet to print.



*Example of a very wet filament with moisture bubbles after extrusion*

### WHAT TO DO WHEN NYLON IS TOO WET TO PRINT?

NYLON attracts moisture. After every print it is recommended to dry the filament before the next print.

The formula for drying NYLON is easy:

- After a 24 hour print put it into a standard heated air oven or filament dryer at 65°C for 24 hours.
- After a 8 hour print, put the filament into the oven for 8 hours.
- After a 2 hour print, put the filament into the oven for 2 hours.

This will be enough to dry the NYLON to moisture levels in order to have the best printing results.

