

3D Printing Guidelines

Novamid® ID 1070

PA

GRADE CODING

Novamid® ID 1070 is a strong and ductile 3D printing grade based on PA6/Nylon.

Storage: In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged. For the same reason, partial used bags should be sealed before re-storage.

Allow the material that has been stored to adapt to the temperature in the processing room while keeping the bag closed.

Packaging: Novamid® ID 1070 grades are supplied in airtight, moisture-proof packaging with a moisture level <0.05 w%.

Conditioning before printing: To prevent moisture condensing on filaments, bring filaments up to ambient temperature in the print shop while keeping the packaging closed.

Drying: In case the filament has become wet, it should be dried. Using a hot air oven at 80°C for at least 4h is recommended. When storing the filament after printing, it is advised to seal the bag and add silica gel to the bag to keep the filament as dry as possible.

MACHINERY SETTINGS

Nozzle diameter: 0.4 mm

Filament diameter: 2.85 mm, 1.75 mm

Print Speed: 50 -100 mm/s (obeying the maximal throughput of the extruder).

Extrusion width: 0.4 mm (or at least equal to nozzle diameter).

Layer Height: Layer: 0.1-0.2 mm / First layer: 100-150% of first layer.

Extrusion temperatures: Extruder: 250-270°C / 446-518°F.

Novamid® ID 1070 can be used with a range of nozzle temperature (250-285 °C / 446-545°F). Preferred temperature to print your object is 260°C / 500°F. To generate a homogeneous melt, the melt temperature should always be above 250°C / 446°F. Optimal mechanical properties will be achieved at melt temperature between (260-280°C / 500-536°F).

Build plate Temperature:

Build plate temperature setting: 100-120°C / 212-248°F.

Note: prior to removing the printed part from the bed, the bed temperature should be lowered to ambient to avoid severe deformation of the part.

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GENERAL PROCESSING SETTINGS

Build plate adhesion: For the best adhesion with Novamid® ID 1070 it is advised to use an adhesive promotor, e.g. Dimafix®. PEI (polyether imide) build plate has shown to establish good adhesion, but to prevent warpage it should be of sufficient thickness. Adding a (large) brim to the print will help in establishing bed adhesion during the print as well.

Prior to applying an adhesive promotor, any surface must be free from dirt and grease. Therefore cleaning with ethanol or acetone is recommended.

Note: prior to removing the printed part, the build plate temperature should be lowered to ambient temperature to facilitate separation and thus avoiding severe deformation of the printed part.

SAFETY

For the safety properties of the material, please refer to our SDS which can be ordered at our sales offices. During practical operation wear personal safety protections for hand/eye/body.

STARTUP/SHUT DOWN

Production has to be start with a clean machine. Starting the machine, extrude at least 50 mm of new filament through the nozzle. After printing with Novamid® ID 1070, purge the printer with PLA or PETG. Remove the filament from the machine before shutting down the printer.

PRODUCTION BREAKS

At restart after production interruptions exceeding a few minutes, purge the nozzle adequately.

TROUBLESHOOTING

Most common defects:

- **Warping:** Corners of the print lift and detach from the platform. Advice is to lower the build plate temperature. Wait long enough to allow the heat to dissipate to the top of the surface of the substrate.
- **First layer not sticking / parts coming loose:** the first layer of your print does not seem to want to stick or your parts come loose partway through the print. Remedies: check bed levelling and first layer thickness, increase size of brim, raise bed temperature, add appropriate adhesion promotor e.g. Dimafix® the build plate or change to PEI bed substrate.
- **Filament grinding:** The feeder wheels have ground a groove into the filament. Remove the damaged filament and start again, reduce printing speed, reduce retraction speed and length.
- **Stringing:** Unwanted strands of plastic span across the print. Lower nozzle temperature, enable retraction, or increase the retraction length.

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