

TECHNICAL DATA SHEET

VERSION 1.2
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PA HT

Innovatefil PA HT is a filament with great mechanical resistance and excellent performance at high temperatures.

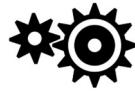
This filament is especially suitable for a professional user who requires a plus of quality in their prints and is mainly intended for rigid pieces that will have an end or direct use.



Thermal resistance



Impact resistance



High industrial capacity



	VALUES	UNIT OF MEASUREMENT	STANDARD		
PHYSICAL PROPERTIES					
Chemical name	Polyamide				
Density	1,2	g/cm ³	ISO 1183		
MECHANICAL PROPERTIES¹					
	XY PLANE	XZ PLANE			
Tensile strength	47,1	-	MPa		
Traction module	-	-	MPa		
Flexion strength	107,1	43,3	MPa		
Flexion module	2416,5	2980,7	MPa		
Elongation at maximum effort	1,8	-	%		
Stretch traction at break	3,9	-	%		
Elongation of flexion at break	15,3	2,7	%		
Charpy Impact Force (non-notched)	26,1	2,5	KJ/m ²		
Hardness	-		Shore D		
THERMAL PROPERTIES					
Glass transition temperature (Tg)	74	°C	ISO 11357		
VICAT B (50 N 50°C/h)	93	°C	ISO 306		
HDT B (0,45 MPa)	90	°C	ISO 75		
PRINTING PROPERTIES					
Printing temperature	250 – 270	°C			
Bed temperature	60 – 90	°C			
Print speed	30 – 50	mm/s			
Layer fan	40 – 60	%			
Material flow	90 – 95	%			
Layer height	≥ 0,2	mm			
Nozzle recommendations	≥ 0,4	mm			
SIZE					
SIZE	NET WEIGHT	GROSS WEIGHT	DIAMETER	COLOR	PACKAGING
M	750 g	900 g	1,75 mm/2,85 mm	Natural, black	Innovatefil box

NOTICE: The information provided in the data sheets is intended for reference only. It should not be used as design or quality control values. Actual values may differ significantly depending on printing conditions. The final performance of printed components not only depends on materials, design and printing conditions are also important.