



## 3D Printing Filament

### TECHNICAL DATA SHEET – NYLFORCE Glass Fiber

Commercial name: Fiber Force NYLFORCE GF  
Raw material: Glass fiber reinforced polyamide  
Designation: 3D printing applications  
Manufacturer: Fiber Force Italy srl – Vicolo Dotti 4 – 31100 Treviso – Italy

#### Material specifications

Property	Value	Test Method - ISO
Density	1,00 g/cm <sup>3</sup>	1183
Melting point	180°C	11357
Tensile Modulus	4000 MPa	527
Tensile Strength	95 MPa	527
Impact strength	80 kJ/m <sup>2</sup>	179/2-1eU
Shore hardness	77 MPa	2039-1
Heat deflection temp. HDT/A	160°C	75
Thermal expansion coefficient	0,1 10 <sup>-4</sup> /K	11359
Max usage Temp. long term	90-120°C	2578
Max usage Temp. short term	150°C	2578D
Dielectric strength	-	IEC 60243
Specific volume resistivity	10 <sup>11</sup> Ωm	IEC 60243
Flammability	HB	1210
Linear mould shrinkage	0,5	294

#### Filament specifications

Property	Value and Tolerances
Diameter 1.75mm	1.75 ± 0.05 mm
Diameter 2.85mm	2.85 ± 0.05 mm
Roundness deviation	max 2%
Suggested print temperature (guideline)	Between 250°C and 265°C
Suggested print speed	40 mm/s
Suggested bed temperature	60°C/70°C