



3D Printing Filament

TECHNICAL DATA SHEET – NYLFORCE³

Commercial name: Fiber Force NYLFORCE³
Raw material: Polyammide
Designation: 3D printing applications
Manufacturer: Fiber Force Italy srl – Vicolo Dotti 4 – 31100 Treviso – Italy

Material specifications

Property	Value	Test Method - ISO
Density	1,10 g/cm ³	1183
Melting point	180°C	11357
Tensile Modulus	1100 MPa	527
Tensile Strength	50 MPa	527
Impact strength	no break kJ/m ²	179/2-1eU
Shore hardness	70	868
Heat deflection temp. HDT/B	125°C	75
Thermal expansion coefficient	1,2 10 ⁻⁴ /K	11359
Max usage Temp. long term	100°C	2578
Max usage Temp. short term	150°C	2578D
Dielectric strength	32 kV/mm	IEC 60243
Specific volume resistivity	10 ¹¹ Ωm	IEC 60243
Flammability	HB	1210
Linear mould shrinkage	0,80	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)	240°C-250°C
Suggested print speed	30-50 mm/s
Suggested bed temperature	70°C (not necessary)