

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	ISO 527	
Traction module	-	-	MPa	ISO 527	
Flexion strength	107,1	43,3	MPa	ISO 178	
Flexion module	2416,5	2980,7	MPa	ISO 178	
Elongation at maximum effort	1,8	-	%	ISO 527	
Stretch traction at break	3,9	-	%	ISO 527	
Elongation of flexion at break	15,3	2,7	%	ISO 178	
Charpy Impact Force (non-notched)	26,1	2,5	kJ/m ²	ISO 179	
Hardness	-	-	Shore D	ISO 7619-1	
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		
PACKAGING					
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.