

PA-12 (Nylon)

Use the following configuration:

1. Clean brass 0.4 mm nozzle (ddd drop's standard);
2. Original spring for extruder;
3. Filamentreel of ddd drop PA12;
4. FFF profile PA12 (<https://www.ddd drop.com/ddd drop-support/>);
5. Magigoo PA (instruction of use is inside the Magigoo package). (<https://www.ddd drop.com/products/parts/>)
6. Set the PA12 filament as shown in picture "Set filament in Filament Management Module".



Important notes:

1. All kind of Nylon are sensitive to moisture. It has to be dried for good 3D print results. 6-8 hours on 70-90 degrees. Use the PrintDry filament dryer or an air-circulated oven.
2. The brim, which is enabled in the Simplify3D software, is necessary for a stable print process of PA. Don't disable the brim for any reason. This will cause bigger warping and delamination problems.
3. Keep the cover of the ddd drop 3D printer always closed while printing a product. Don't open the cover for any reason. This will cause bigger warping problems.
4. Tested with products with dimensions of 50 x 50 x 50 mm.
5. PA (Nylon) is a material which warp a lot. The amount of warping depends on the type of product you print. Massive products will warp more than thin products.

Tips:

1. After drying the filament, but not using it immediately, use a filament (vacuum) storage container to keep your filament dry for a longer time.
2. When printing large parts, use the Polybox filament container to put your filament in. While printing your filament is conditioned and free of moisture.



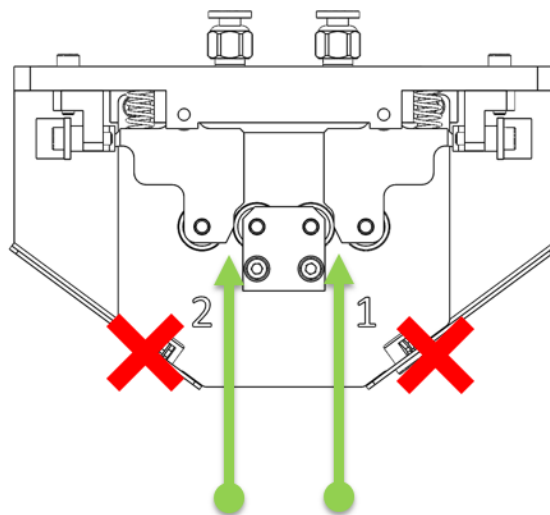
PrintDry



Filament storage container



Polybox



Set filament in Filament Management Module (FMM)

For any questions, don't hesitate to contact our Customer Service.
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