TECHNICAL DATA SHEET

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COEXNylex™ PA6-CF 3D Printing Filament

Carbon fiber nylon · Product code CX23 · 1.75 mm

Base resin: Carbon-fiber-reinforced nylon 6 copolymer

Typical values for the base resin. Printed parts vary with print settings, orientation and moisture content.

Physical properties

Property	Standard	Unit	Typical value
Specific gravity / density	ISO 1183	g/cm³	1.18
Melting temperature, 10 °C/min	ISO 11357-1/-3	°C	195

Mechanical properties

Property	Standard	Unit	Typical value
Tensile strength	ASTM D638	MPa (psi)	76 (11,000)
Tensile modulus	ASTM D638	MPa (psi)	3,034 (440,000)
Strain at yield	ASTM D638	%	4.0
Impact strength, unnotched	ASTM D4812		No break

Filament specifications

Diameter	Nominal	Minimum	Maximum	Tolerance
1.75 mm	1.75 mm (0.0689 in)	1.72 mm (0.0677 in)	1.78 mm (0.0701 in)	±0.03 mm (±0.0012 i

Recommended print settings

Nozzle temperature	265–290 °C
Bed temperature	80–100 °C
Enclosure	Required
Part cooling fan	40–80%, off for the first layer
Nozzle	Abrasive material: use a hardened steel, ruby-tipped or other wear-resistant nozzle
Drying	80 °C (176 °F) for 8–12 hours before printing an opened spool
Storage	Keep sealed and dry; nylon absorbs moisture from the air

Advantages

Heat resistant, chemical resistant, strong, durable. Lightweight and incredibly strong material to make durable, functional parts.

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