

NexaForge

Technical Data Sheet (TDS)

General technical data for NexaForge 3D printer filament product families.

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Brand	NexaForge	Status	Customer Issue
Product Scope	3D Printer Filament Product Families	Contact	wangdancqu@gmail.com

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Document Use: This document is issued for customer communication, distributor review and product evaluation. For buyer-specific regulatory filing, customs submission or certification audit, product-specific test reports and country-specific documentation may be requested.

1. Product Identification

Item	Description
Product Name	NexaForge 3D Printer Filament
Product Families	PLA, PLA+, PETG, Silk PLA, Matte PLA, Matte PETG, TPU, PEBA, ABS, ASA, HIPS, Nylon/PA, PA-CF, PC, PC+ABS, POM, PVA, PVB and specialty filaments
Typical Diameter	1.75 mm; other diameters subject to order confirmation
Application	FDM / FFF 3D printing for resellers, print farms, schools, makers, engineering prototyping and OEM/private-label buyers
Country of Origin	China

2. Standard Product Parameters

Parameter	Standard Specification
Diameter tolerance	+/-0.02 mm, based on standard production control and product series
Net weight	1.0 kg per spool unless otherwise specified
Gross weight	Approx. 1.32 kg per spool depending on material and packaging
Spool type	Plastic spool; AMS-compatible spool available for selected product lines
Spool reference size	Approx. 198 mm outer diameter; approx. 62 mm width for AMS-compatible spool design
Packaging	Vacuum-sealed bag with desiccant, label and outer carton as agreed
Color supply	Standard color card, visual effects and custom color matching subject to MOQ
Wholesale MOQ	From 50 rolls
OEM customization MOQ	From 1000 rolls for private label / custom packaging / color program, subject to project confirmation
Samples	Paid samples available before bulk order or OEM project confirmation

3. Material Series and Recommended Printing Settings

Material Series	Nozzle Temp.	Bed Temp.	Speed	Recommended Notes
PLA / PLA+	190-220 °C	50-65 °C	40-100 mm/s	General printing; suitable for models, education and daily use
Silk PLA / Dual / Tri-color	195-220 °C	50-65 °C	35-70 mm/s	Use lower speed for smoother gloss and color-transition effect
Matte PLA / Matte PETG	PLA: 190-220 °C; PETG: 220-250 °C	50-90 °C	35-80 mm/s	Low-gloss surface; tune temperature by material base
PETG / 110 °C EPTG	220-250 °C	70-90 °C	40-80 mm/s	Good toughness; keep cooling moderate to improve layer bonding
TPU / PEBA	210-240 °C	40-60 °C	20-40 mm/s	Flexible material; reduce speed and use direct drive if possible
ABS	230-260 °C	90-110 °C	30-70 mm/s	Enclosure recommended; avoid drafts
ASA	240-270 °C	90-110 °C	30-70 mm/s	UV/weather-resistant engineering applications; enclosure recommended

Material Series	Nozzle Temp.	Bed Temp.	Speed	Recommended Notes
HIPS	230-250 °C	90-110 °C	30-60 mm/s	Support or model material; enclosure recommended
Nylon / PA	250-280 °C	70-100 °C	30-60 mm/s	Dry before printing; keep dry during printing
PA-CF / Carbon Fiber Nylon	260-290 °C	70-110 °C	30-60 mm/s	Hardened steel or ruby nozzle recommended; dry before printing
PC / PC+ABS / POM	250-300 °C	90-120 °C	25-60 mm/s	Engineering materials; enclosure and dry storage recommended
PVA / PVB	190-220 °C	50-70 °C	20-40 mm/s	Keep dry; PVA is water-soluble; PVB can be post-processed
Wood / Marble / Metal Effect	190-230 °C	50-70 °C	30-70 mm/s	Use abrasion-resistant nozzle for filled materials when needed
Glow / Fluorescent / Specialty	190-230 °C	50-70 °C	30-70 mm/s	Settings vary by material base and effect additive

Note: Printing parameters are recommended starting points. Final settings depend on printer model, nozzle size, part geometry, drying condition, chamber environment and slicing profile.

4. Quality Control and Production Control

Control Item	Standard Control Method
Diameter consistency	In-line diameter monitoring and production sampling
Winding quality	Neat winding inspection to reduce tangling and feeding interruption
Moisture protection	Vacuum packaging with desiccant; dry storage recommended after opening
Visual inspection	Color, surface, label and spool inspection before shipment
Batch traceability	Batch/lot identification can be provided according to order requirement
Monthly capacity	200+ tons production capacity subject to production plan and confirmed order schedule

5. Storage, Handling and Shelf Life

Item	Requirement
Storage	Store in a cool, dry, well-ventilated indoor area. Avoid direct sunlight, rain, high temperature and high humidity.
After opening	Seal unused filament in a dry bag or dry box. For moisture-sensitive materials, dry before printing.
Drying recommendation	PLA/PETG: mild drying if moisture is observed; Nylon/PA/PA-CF/PVA: drying is strongly recommended before use.
Shelf life	12 months recommended under unopened, dry storage conditions; performance depends on storage environment and material type.

6. Packaging, Labeling and OEM Support

Service	Description
Standard brand supply	NexaForge brand label and standard carton packing
Custom sticker	Available under OEM/private-label project; MOQ from 1000 rolls unless otherwise agreed
Custom box	Available under OEM/private-label project; MOQ from 1000 rolls unless otherwise agreed

Service	Description
Color matching	Available under OEM/private-label project; MOQ and lead time depend on material and color system
Documentation	TDS, SDS/MSDS, test report, packing list, invoice and label file support available by order requirement

7. Compliance and Documentation Support

NexaForge can provide product information documents and compliance support for customer evaluation. RoHS, REACH, quality report, test report or other customer-specific documents should be confirmed by exact product series, batch, destination market and buyer requirement.

Document Type	Availability
TDS	Available for customer evaluation and distributor onboarding
SDS / MSDS	Available in 16-section format for customer safety and handling reference
RoHS / REACH	Available upon request for applicable product series and confirmed batches
COA / QC Report	Available upon request based on order and batch requirement
OEM artwork / packaging file	Available for confirmed private-label projects

8. Disclaimer

The information contained in this TDS is based on NexaForge standard product knowledge and typical operating conditions. It is provided in good faith for customer evaluation and does not replace customer testing under actual printing, regulatory or end-use conditions. Product specifications may vary by material series, color, additive, batch and agreed order requirement.

Revision History

Revision	Date	Description
1.0	2026-06-15	Initial customer-issue technical data sheet for NexaForge filament product families