TECHNICAL DATA SHEET PA-12

 PA-12 - combines mechanical strength, flexibility and chemical resistance (oils, greases, gasoline), great impact resistance, flexibility and dimensional stability. Finish of this filament is quite smooth which gives it low friction properties (large sliding).

| HARDNESS | | | | | \supset |
|------------------|--|------------|------------|--------------|------------|
| ELASTICITY | | \bigcirc | \bigcirc | \bigcirc (| \bigcirc |
| IMPACT STRENGTH | | | \bigcirc | \bigcirc (| \supset |
| TENSILE STRENGTH | | | | \bigcirc (| \bigcirc |

PHYSICAL PROPERTIES

| | VALUE | UNIT | TEST METHOD |
|------------------|-------|--------|-------------|
| Density | 1,02 | g/cm^3 | ISO 1183 |
| Water Absorption | 1,5 | % | ISO 62 |



MECHANICAL PROPERTIES

| | VALUE | UNIT | TEST METHOD |
|-----------------------------|-------|-------|-------------|
| Tensile strength | 45 | MPa | ISO 527-2 |
| Charpy impact strength 23°C | 7 | kJ/m2 | ISO 179-1eA |
| Charpy impact strength 40°C | 7 | kJ/m2 | ISO 179-1eA |

THERMAL PROPERTIES

| | VALUE | UNIT | TEST METHOD |
|--------------------------------------|-------|------|-------------|
| Heat Deflection Temperature 0,45 MPa | 110 | °C | ISO 75-2 |
| Heat Deflection Temperature 1,8 MPa | 50 | °C | ISO 75-2 |
| VICAT Softening Temperature | 138 | °C | ISO 306B |
| Flammability class | HB | - | UL 94 |

ELECTRICAL PROPERTIES

| | VALUE | UNIT | TEST METHOD |
|-------------|-------|-------|-------------|
| Resistivity | >1018 | Ω/cm2 | IEC 60093 |

RECOMMENDED PRINTING PARAMETERS









50°C



Print Speed 30-80mm/s



Nozzle temperature

240-260°C

Bed temperature

80-120°C

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