

Product Texts

PA6/66 copolymer for 3D Printing Fused Deposition Modelling.

Suitable for parts requiring high dimensional stability and very reduced shrinkage. Transparent material, it offers good surface aspect and easy processability.

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2005 / -	MPa	ISO 527
^[C] Yield stress	55 / -	MPa	ISO 527
^[C] Yield strain	4.5 / -	%	ISO 527
^[C] Nominal strain at break	15 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	N / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	30 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	195 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	45 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	50 / *	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	10.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	3 / *	%	Sim. to ISO 62
^[C] Density	1100 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Additive Manufacturing

Features

Copolymer

Delivery form

Granules

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Special Characteristics

Transparent

Other text information

Injection molding

The material is available in granules or in filament – 1.75 mm and 2.85 mm diameter. In the case of granules, the material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.10%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. In the case of filaments, the material is originally sealed in vacuum bags with silica gel inside to keep environment in dry conditions. For best printing results, it is recommended to pre-dry the filament at 70-80°C for 2-4 h or more. Alternatively, Radilon® Adline filaments are compatible with Drywise system from Thought3D Ltd.

Recommended 3D-Print processing parameters:

Nozzle Temperature
250°-280°C

Bed Temperature
70-100°C

Adhesion promoter
Magigoo glue

Print Speed
30-40 mm/s

Please note: Parameters are dependent on printer used.
Radici tests were performed on a Ultimaker S5 printer