

**Product Texts**

PA6/66 copolymer 10% carbon fibre reinforced for 3D Printing Fused Deposition Modelling.

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

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	<b>3850 / -</b>	MPa	ISO 527
<sup>[C]</sup> Yield stress	<b>65 / -</b>	MPa	ISO 527
<sup>[C]</sup> Yield strain	<b>3.5 / -</b>	%	ISO 527
<sup>[C]</sup> Nominal strain at break	<b>18 / -</b>	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	<b>60 / -</b>	kJ/m <sup>2</sup>	ISO 179/1eU

[C]: CAMPUS

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	<b>195 / *</b>	°C	ISO 11357-1/-3

[C]: CAMPUS

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<sup>[C]</sup> Water absorption	<b>9 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	<b>2.6 / *</b>	%	Sim. to ISO 62
<sup>[C]</sup> Density	<b>1160 / -</b>	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics**

**Processing**

Injection Molding, Additive Manufacturing

**Features**

Copolymer

**Delivery form**

Granules, Black

**Regional Availability**

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

**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*