

PA6 GK10

MATERIAL PROPERTIES

Specific gravity	1.01 g/cm ³	ISO 1183-3
Water absorption, 23°C/24h	<0.3%	ISO 62
Melt flow rate (MFR), 250°C / 2,16kg	2.2 g/10 min	ISO 1133
Linear mould shrinkage	0.3-0.5%	DIN 16742

Mechanical Properties at 23°C / 50% rh

Tensile strength (dry, at 50 mm/min)	87 MPa	ISO 527
Elongation at max. force (dry, at 50 mm/min)	2.7%	ISO 527
Modulus of elasticity (dry, at 1 mm/min)	4.2 GPa	ISO 527
Charpy impact strength (dry, 80x10x4mm)	26 kJ/m ²	ISO 179 1eU

Thermal Properties

Heat distortion temperature (HDT A)	90°C	ISO 75
Continuous service temperature (20.000h)	120°C	IEC 60216
Service temperature (max. 200h)	160°C	

Electrical Properties

Insulation resistance (strip electrode R25)	> 10 ¹² Ω	DIN IEC 60167
Surface resistance (ROB)	> 10 ¹² Ω	DIN IEC 60093

GUIDELINE FOR PRINT SETTINGS*

Nozzle temperature	260-290°C
Bed temperature	< 80°C
Active cooling fan	0 - 10%
Layer height**	≥ 0.15mm
Shell thickness**	0.40 - 2.70 mm
Print speed**	30-80 mm/s
Closed chamber	recommended
Dry box	recommended
Ruby or hardened nozzle	recommended

* settings are based on a 0,4 mm nozzle.

** depending on the geometrical complexity

Disclaimer

The product- and technical data provided in this datasheet is correct to the best of Spectrum Group Sp. z o.o. knowledge and are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary according to printing conditions, model complexity, environmental conditions, etc. The user assumes all responsibility for the use of all information provided and shall verify quality and other properties or any consequence from the use of all such information. Typical values are indicative only and are not to be construed as being binding specifications. Spectrum Group Sp. z o.o. shall not be made liable for any damage, injury or loss induced from the use of Spectrum Group Sp. z o.o. materials in any particular application.

DESCRIPTION

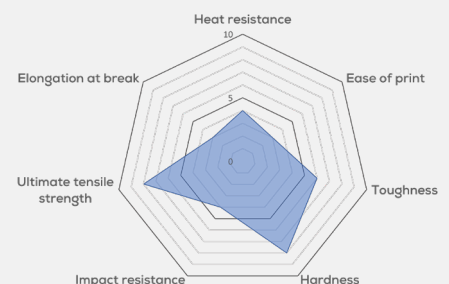
Filament Spectrum PA6 GK10 is a new, high-temperature PA6-based construction material in natural colour. Filled with hollow glass spheres, it is stiffer and lighter than the polyamide the material is based on. Its specific property is a low impact of moisture, high temperature resistance and good electrical insulation properties as compared to unmodified PA6 or PA66.

FEAUTURES

- high creep resistance
- high hardness and rigidity of the printed items
- chemical resistance to lubricants and oils
- a wide range of applications
- very robust interlayer lamination
- high impact resistance
- a relatively high resistance to thermal ageing

STORAGE AND SHELF LIFE

Filament should be stored in a dry room at room temperature. Recommended storage temperature is ca. 18-25°C (64.4 -77.0°F). Keep out of moisture, sunlight and direct heat. When stored properly, product has a shelf life of 24 months.



SUPPORT

If you have any questions or experience any issues, please do not hesitate to contact us at support@spectrumfilaments.com