



# Technical Data Sheet

## Nylon PA6 Low Warp Filament

The material offered by Spectrum Group Sp. z o.o. has been developed and adapted to general modeling. Tests performed by Spectrum Group have showed that it is feasible to use the offered product in most 3D printers operating in FDM/FFF technology available on the market. Before the first use, it is advisable to print out a hard proof to check if the filament is compatible with your 3D printer.

Physical properties	Typical value	Test Method
Material density	1.05 g/cm <sup>3</sup>	ISO 1183/B
Melt Flow Rate (220°C, 10kg)	6.6 g/10min	ISO 1133
Molding Shrinkage	0.7%	ISO 1133
Dimensional tolerance	± 0.05mm	

Dry			
Mechanical properties	Test condition	Typical value	Test Method
Elongation at break	50mm/min	4%	ISO 527-1,-2
Bending tension	2mm/min	80 MPa	ISO 178
Flexural Modulus	2mm/min	2300 MPa	ISO 178
Young's Modulus	1mm/min	2500 MPa	ISO 527-1,-2
Yield point	50mm/min	80	ISO 527-1,-2
Brinell scale indentation hardness	358N	155 MPa	ISO 2039-1

Conditioned			
Mechanical properties	Test condition	Typical value	Test Method
Elongation at break	50mm/min	250%	ISO 527-1,-2
Bending tension	2mm/min	40 MPa	ISO 178
Flexural Modulus	2mm/min	1300 MPa	ISO 178
Young's Modulus	1mm/min	1500 MPa	ISO 527-1,-2
Yield point	50mm/min	45 MPa	ISO 527-1,-2
Brinell scale indentation hardness	358N	95 MPa	ISO 2039-1

Technical data is provided according to the data of the base material and it is for information only.

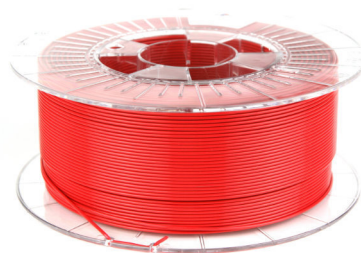
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Thermal properties	Test condition	Typical value	Test Method
Vicat Softening Temperature	50N	120°C	ISO 306
Melt temperature	10°C/min	221°C	ISO 11357-1-3

Flammability	Typical value	Test Method
3.2mm	class HB	UL 94

Printing properties	Typical value	Test Method
Printing temperature	250-270°C	
Bed temperature	85-100°C	
Recommendation	has to be dried before printing	



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