

Electrafil® PA6 1502 3DP

 Techmer Polymer Modifiers - *Polyamide 6*

General Information

Product Description

Electrafil® PA6 1502 3DP is a specially formulated, carbon fiber filled, and compounded thermoplastic material designed for general purpose additive manufacturing applications. This product has been optimized for maximum printability in additive manufacturing.

General

Material Status	• Commercial: Active
Availability	• North America
Filler / Reinforcement	• Carbon Fiber
Uses	• Additive Manufacturing (3D Printing)

 Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.30		ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	25000	psi	ASTM D638
Tensile Elongation (Break)	1.0	%	ASTM D638
Flexural Modulus	4.00E+6	psi	ASTM D790
Flexural Strength	35000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (0.125 in)	1.0	ft-lb/in	ASTM D256
Additional Information	Nominal Value	Unit	Test Method
Recommended Print Bed	Aluminum bed with cement glue or Kapton tape, glass epoxy laminate board, or polyamide sheet		
Recommended Print Bed Temperature	194 to 230	°F	

Processing Information

Extrusion	Nominal Value	Unit
Drying Temperature	180	°F
Drying Time	2.0 to 4.0	hr
Cylinder Zone 1 Temp.	440 to 480	°F
Cylinder Zone 2 Temp.	440 to 500	°F
Cylinder Zone 3 Temp.	480 to 550	°F
Cylinder Zone 4 Temp.	480 to 550	°F
Melt Temperature	490 to 550	°F
Die Temperature	500 to 550	°F

Extrusion Notes

If drying for longer than 6 hours, recommend reducing the temperature to 140°F in a desiccant dryer to avoid degradation of the material.

