

MATERIAL SPECIFICATIONS

PA 606-FR

HIGHLIGHTS

- Fire Retardant Nylon 12
- Easy to process across most laser sintering platforms
- Passes the FAR 25.853 60-second burn requirement
- Produces accurate, repeatable parts for prototyping and manufacturing applications

APPLICATIONS

- Aerospace and automotive ducts
- Snap fit components and multi-sectional bonding requirements
- Prototypes requiring durability, accuracy and end-use functionality
- Ideal for high feature detail applications requiring FAR 25.853 fire retardant compliancy

TYPICAL PHYSICAL PROPERTIES

PROPERTY	TEST METHOD	U.S. STANDARD	METRIC
Colour/Appearance	Visual	White	White
Bulk Density	ASTM D1895	0.266 oz/in ³	0.46 g/cm ³
Average Particle Size (D50)	Laser Diffraction	0.002 inches	55 microns
Particle Size Range (D10-D90)	Laser Diffraction	0.001 - 0.004 inches	30 - 100 microns
Sintered Part Density	ASTM D792	0.590 oz/in ³	1.02 g/cm ³
Heat Deflection Temperature	ASTM D648	203°F @ 264 psi	95°C @ 1.82 MPa
Heat Deflection Temperature	ASTM D648	356°F @ 66 psi	180°C @ 0.45 MPa
Ultimate Tensile Strength (XY)	ASTM D638	6,962 psi	48 MPa
Tensile Modulus (XY)	ASTM D638	247,000 psi	1,700 MPa
Flexural Modulus (XY)	ASTM D790	217,000 psi	1,500 MPa
Elongation at Break (XY)	ASTM D638	24%	24%
Izod Impact Strength - Notched (XY)	ASTM D256	0.6 ft-lb/in	32 J/m
Izod Impact Strength - Un-notched (XY)	ASTM D256	6.3 ft-lb/in	336 J/m
Flammability 60 Second Burn	FAR 25.853	Pass	Pass
Hardness (Shore D)	ASTM D2240	73	73

For reference use only. Actual properties may vary significantly from those listed above based on processing parameters, operating conditions and end use applications. The above properties were based on virgin ALM PA 606-FR using normal processing parameters on a 2500+ platform as outlined in the ALM Material Processing Guide. Advanced Laser Materials, LLC makes no warranties of materials for any application, nor does it make a warranty of any type, expressed or implied, but not limited to, the warranties of merchantability for a particular purpose.



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