FDM Nylon 12

PRODUCTION-GRADE THERMOPLASTIC FOR FORTUS 3D PRINTERS

FDM Nylon 12™ is the first material in Stratasys' family of nylon offerings, complementing the current portfolio of FDM® materials and enabling new applications requiring: repetitive snap fits, high fatigue resistance, strong chemical resistance and press (friction) fit inserts. FDM Nylon 12 is primarily used in aerospace, automotive and consumer goods industries to take on everything from tooling, jigs and fixtures to covers, panels and vibration resistant components. For use with Fortus 380mc™, 450mc™ and 900mc™ 3D Printers, FDM Nylon 12 offers unparalleled toughness and a simple, clean process – free of powders.

CONDITIONED*

MECHANICAL PROPERTIES[1]	TEST METHOD	ENGLISH		METRIC	
		XZ AXIS	ZX AXIS	XZ AXIS	ZX AXIS
Tensile Strenth, Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	4,600 psi	4,100 psi	32 MPa	28 MPa
Tensile Strength, Ultimate (Type 1, 0.125", 0.2"/min)	ASTM D638	6,650 psi	5,600 psi	46 MPa	38.5 MPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	186,000 psi	165,000 psi	1,282 MPa	1,138 MPa
Elongation at Break (Type 1, 0.125", 0.2"/min)	ASTM D638	30%	5.4%	30%	5.4%
Elongation at Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	2.4%	2.7%	2.4%	2.7%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	9,700 psi	8,800 psi	67 MPa	61 MPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	185,000 psi	171,000 psi	1,276 MPa	1,180 MPa
Flexural Strain at Break	ASTM D790	No Break	>10%	No Break	>10%
IZOD impact - notched (Method A, 23 °C)	ASTM D256	2.5 ft-lb/in	1 ft-lb/in	135 J/m	53 J/m
IZOD impact - unnotched (Method A, 23 °C)	ASTM D256	31 ft-lb/in	3.7 ft-lb/in	1,656 J/m	200 J/m
Compressive Strength, Yield (Method 1, 0.05"/min)	ASTM D695	7,400 psi	7,900 psi	51 MPa	55 MPa
Compressive Strength, Ultimate (Method 1, 0.05"/min)	ASTM D695	24,200 psi	800 psi	167 MPa	6 MPa
Compressive Modulus (Method 1, 0.05"/min)	ASTM D695	730,000 psi	155,000 psi	5,033 MPa	1,069 MPa

UNCONDITIONED (DRY)**

MECHANICAL PROPERTIES	TEST METHOD	ENGLISH		METRIC	
		XZ AXIS	ZX AXIS	XZ AXIS	ZX AXIS
Tensile Strength, Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	7,700 psi	6,900 psi	53 MPa	48 MPa
Tensile Modulus (Type 1, 0.125", 0.2"/min)	ASTM D638	190,000 psi	180,000 psi	1,310 MPa	1,241 MPa
Elongation at Break (Type 1, 0.125", 0.2"/min)	ASTM D638	9.5%	5%	9.5%	5%
Elongation at Yield (Type 1, 0.125", 0.2"/min)	ASTM D638	6.5%	5%	6.5%	5%
Flexural Strength (Method 1, 0.05"/min)	ASTM D790	10,000 psi	8,600 psi	69 MPa	60 MPa
Flexural Modulus (Method 1, 0.05"/min)	ASTM D790	190,000 psi	180,000 psi	1,300 MPa	1,250 MPa
Flexural Strain at Break	ASTM D790	No Break	>10%	No Break	>10%
IZOD impact - notched (Method A, 23 °C)	ASTM D256	2.8 ft-lb/in	0.9 ft-lb/in	150 J/m	50 J/m
IZOD impact - unnotched (Method A, 23 °C)	ASTM D256	>37.4 ft-lb/in	5.1 ft-lb/in	>2,000 J/m	275 J/m

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At the core: Advanced FDM Technology

FDM (fused deposition modeling) technology works with engineering-grade thermoplastics to build strong, long-lasting and dimensionally stable parts with the best accuracy and repeatability of any 3D printing technology. These parts are tough enough to be used as advanced conceptual models, functional prototypes, manufacturing tools and production parts.

Meet production demands

FDM systems are as versatile and durable as the parts they produce. Advanced FDM 3D Printers boast the largest build envelopes and material capacities in their class, delivering longer, uninterrupted build times, bigger parts and higher quantities than other additive manufacturing systems, delivering high throughput, duty cycles and utilization rates.

Opening the way for new possibilities

FDM 3D Printers streamline processes from design through manufacturing, reducing costs and eliminating traditional barriers along the way. Industries can cut lead times and costs, products turn out better and get to market faster.

No special facilities needed

FDM 3D Printers are easy to operate and maintain compared to other additive fabrication systems because there are no messy powders or resins to handle and contain, and no special venting is required because FDM systems don't produce noxious fumes, chemicals or waste.

THERMAL PROPERTIES[1]	TEST METHOD	ENGLISH	METRIC
Heat Deflection (HDT) @ 66 psi annealed	ASTM D648	207 °F	97 °C
Heat Deflection (HDT) @ 66 psi unannealed	ASTM D648	167 °F	75 °C
Heat Deflection (HDT) @ 264 psi annealed	ASTM D648	180 °F	82 °C
Heat Deflection (HDT) @ 264 psi unannealed	ASTM D648	131 °F	55 °C
Melting Point	----------	352 °F	178 °C

OTHER	TEST METHOD	VALUE
Specific Gravity	ASTM D792	1.00

SYSTEM AVAILABILITY	LAYER THICKNESS CAPABILITY	SUPPORT MATERIAL	COLOR
Fortus 380mc	0.013 inch (0.330 mm)	SR-110	■ Black
Fortus 450mc	0.010 inch (0.254 mm)		
Fortus 900mc	0.007 inch (0.178 mm)		

**Conditioned = 20 °C and 50% RH for 72 hours*
***Unconditioned (Dry) = Direct from FDM system*
— Annealed = 2 hours @ 140 °C
— Unannealed = direct from FDM system

The information presented are typical values intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. End-use material performance can be impacted (+/-) by, but not limited to, part design, end-use conditions, test conditions, etc. Actual values will vary with build conditions. Tested parts were built on Fortus 400mc™ @ 0.010" (0.254 mm) slice. Product specifications are subject to change without notice.

The performance characteristics of these materials may vary according to application, operating conditions, or end use. Each user is responsible for determining that the Stratasys material is safe, lawful, and technically suitable for the intended application, as well as for identifying the proper disposal (or recycling) method consistent with applicable environmental laws and regulations. Stratasys makes no warranties of any kind, express or implied, including, but not limited to, the warranties of merchantability, fitness for a particular use, or warranty against patent infringement.

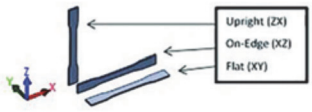
[1]Literature value unless otherwise noted.

Orientation: See Stratasys Testing white paper for more detailed description of build orien tations.

XZ = X or "on edge"

XY = Y or "flat"

ZX = or "upright"



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dim3D
we add. you succeed.

dim3d-Druck GmbH
Im Kressgraben 19 – 21
74257 Untereisesheim
Tel.: +49 7132 899 91-80
info@dim3d.de
www.dim3d.de

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