# **DuraForm® PA Plastic**



Durable polyamide (nylon) material for real-world physical testing and functional use.

# **General Properties**

MEASUREMENT	CONDITION	METRIC	U.S.
Specific Gravity	ASTM D792	1.00 g/cm <sup>3</sup>	1.00 g/cm <sup>3</sup>
Moisture Absorption - 24 hours	ASTM D570	0.07%	0.07%

## **Mechanical Properties**

MEASUREMENT	CONDITION	METRIC	U.S.
Tensile Strength Ultimate (MPa/PSI)	ASTM D 638	43	6237
Tensile Modulus (MPa/KSI)	ASTM D 638	1586	230
Elongation at Break (%)	ASTM D 638	14	14
Flexural Strength, Ultimate (MPa/PSI)	ASTM D 790	48	6962
Flexural Modulus (MPa/KSI)	ASTM D 790	1387	201
Hardness, Shore D	ASTM D2240	73	73
Impact Strength (notched Izod, 23°C)	ASTM D256	32 J/m	0.6 ft-lb/in
Impact Strength (unnotched Izod, 23°C)	ASTM D256	336 J/m	6.3 ft-lb/in
Gardner Impact	ASTM D5420	2.7 J	2.0 ft-lb

Data was generated by building parts under typical default parameters. DuraForm® PA Plastic was processed on a base-level HiQ<sup>TM</sup> SLS System at 13 watts laser power, 5 m/sec [200 inches/sec] scan speed, and a powder layer thickness of 0.1 mm [0.004 inches].

#### **Features**

- Excellent surface resolution and feature detail
- Easy-to-process
- Compliant with USP Class-VI testing
- Compatible with autoclave sterilization
- Good chemical resistance and low moisture absorption

#### **Benefits**

- Nicely balanced mechanical properties and processability
- Build prototypes that withstand functional testing
- Produce durable end-use parts without tooling
- Create accurate and repeatable parts as demanded by manufacturers
- Machinable and paintable for demonstration parts

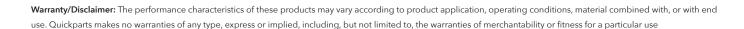
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#### contact@quickparts.com | www.quickparts.com

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North America +1 931 766 7290 **United Kingdom** +44 (0) 1494 479 690 **Germany** +49 (0) 6073 689 6000

France +33 (0) 2 43 51 20 30 **Italy** +39 0121 390310



# **DuraForm® PA Plastic**

# **Thermal Properties**

MEASUREMENT	CONDITION	METRIC	U.S.
Heat Deflection Temperature	ASTM D 648 @ 0.45 MPa @ 1.82 MPa	180 °C 95 °C	356 °F 203 °F
Coefficient of Thermal Expansion (µm/m-°C / µm/in-°F)	ASTM E 831 0-50 °C 85-145 °C	82.6 179.2	45.9 99.6
Specific Heat Capacity	ASTM E1269	1.64 J/g-°C	0.392 BTU/lb-°F
Thermal Conductivity	ASTM E1225	0.70 W/m-K	4.86 BTU-in/ hr-ft2-°F
Flammability	UL 94	НВ	НВ

### **Electrical Properties**

MEASUREMENT	CONDITION	METRIC	U.S.
Volume Resistivity	ASTM D257	5.9 X 10 <sup>13</sup> ohm-cm	5.9 X 10 <sup>13</sup> ohm-cm
Surface Resistivity	ASTM D257	7.0 X 10 <sup>12</sup> ohm	7.0 X 10 <sup>12</sup> ohm
Dissipation Factor, 1 KHz	ASTM D150	0.044	0.044
Dielectric Constant, 1 KHz	ASTM D150	2.73	2.73
Dielectric Strength	ASTM D149	17.3 kV/mm	439 kV/in

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# **Applications**

- Complex, thin-wall ductwork
- Functional prototypes that approach end-use performance properties
- Appropriate for low- to midvolume rapid manufacturing
- Medical applications requiring USP Class-VI compliance, or biocompatibility
- Motorsports
- Aerospace
- Housing and enclosures
- Impellers and connectors
- Consumer sporting goods
- Vehicle dashboards and grilles
- Snap-fit designs
- Parts requiring machining or joining with adhesives

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