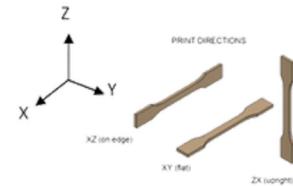


## KRATIR MII PA6 CF

Material class: Polyamide 6 / Carbon Fiber

### Excellent in combination with continuous fiber systems

- Easy printing, increased stiffness
- Highest surface finish



Property	Method	Units	Value XZ** (on edge)	Value ZX** (upright)
<b>Mechanical properties</b>				
Tensile Modulus	ISO 527 Type 1BA	MPa	5800	2000
Tensile Strength at yield	ISO 527 Type 1BA	MPa	112	45
Tensile Strength at break	ISO 527 Type 1BA	MPa	-	-
Elongation at yield	ISO 527 Type 1BA	%	3.9	4.9
Elongation at break	ISO 527 Type 1BA	%	7.1	5.0
Flexural Modulus	ISO 178	Mpa	2570	2290
Flexural Stress at break	ISO 178	Mpa	101	43
Flexural Strain at break	ISO 178	%	5.7	1.9
Impact Strength	ISO 180	J/m		
Impact Strength	ISO 180	kJ/m <sup>2</sup>		

\*\* XZ/ZX Bars cut out of 3D printed plates on edge and in Z direction printed according to guidelines

Property	Method	Units	Value
<b>Thermal properties</b>			
Glass transition temperature (Tg)	ISO 11357-1	°C	60
Melting temperature	ISO 11357-3	°C	220
Vicat softening temperature	ISO 306/B50	°C	
Temp. of deflection under load (1.80 Mpa)*	ISO 75-1/-2	°C	180
Temp of deflection under load ( 0.45 Mpa)*	ISO 75-1/-2	°C	
<b>Physical properties</b>			
Filament diameter (+/- 0.05 mm)		mm	1.73
Density	ISO 1183-1	g/cm3	1.18
Humidity absorption (70 °C, 62% r.H.)*	ISO1110	%	
Water absorption (23 °C saturated)*	ISO 62	%	

\* Injection moulding data



## Recommended processing conditions

Nozzle temperature	Recommended 280 °C (280 °C - 310 °C)
Bed temperature	Recommended 110 °C (80 °C - 120 °C)
Chamber temperature	Recommended 90 °C (23 °C - 90 °C)
Bed material	(Textured) PEI Sheet, Glass, Carbon Fiber Plate
Adhesion promoter	Magigoo PA or Magigoo HT
Nozzle diameter	≥ 0.4mm, hardened steel nozzle
Print speed	Recommended: 30 mm/s (30-50 mm/s)
Drying instructions filament	100 °C for 4-6 hours

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