



THE **LARGE-SCALE** FFF 3D-PRINTER
FOR **PROFESSIONAL** AND **INDUSTRIAL** USE.

TECHNICAL DATA SHEET
BigRep PA6/66

PA6/66 is a polyamide grade 3D printing filament combining excellent heat and chemical resistance, mechanical properties and printability.

Physical Properties

Material	Polyamide 6/6.6 copolymer
Filament Net Weight:	3.0, 4.5, 8.0 kg
Diameter	2.85 mm
Density (ISO 1183)	1.12 g/cm³
Melting temperature (DSC)	190 °C
Vicat Softening Temperature (ISO 306)	180 °C

Recommended Printing Conditions (Original BigRep factory files for the material are available from BigRep Global Support)

Nozzle temperature	250 - 270 °C
Heating bed temperature	0 - 75 °C
Environmental temperature	40 - 60 °C
Printing speed	>40 mm/s
Additional Comments	Material is sensitive to moisture and should be stored under dry conditions at all times

Mechanical Properties (Dry State)

Young's Modulus (ISO 527)	2325 MPa
Tensile Strength (ISO 527)	67 MPa
Elongation at break (ISO 527)	10,0 %
Bending Modulus (ISO 178)	1725 MPa
Bending Strength (ISO 178)	98 MPa
Charpy Impact strength (ISO 179)	10 kJ/m²

Keep sealed in an air tight container, away from humidity.
Store at around room temperature and protect from direct heat or sunlight.

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