

Radilon® ADLINE CS

Radici Group High Performance Polymers - *Polyamide 66/6 Copolymer*

General Information

Product Description

PA6/66 copolymer for 3D printing Fused deposition Modeling.

Suitable for parts requiring high dimensional stability and reduced shrinkage. Transparent material, it offers good surface aspect and easy processability.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Features	• Copolymer • Good Clarity	• Good Processability • Good Surface Finish	• High Dimensional Stability • Low Shrinkage
Agency Ratings	• EU 2011/65/EC		
RoHS Compliance	• RoHS Compliant		
Appearance	• Clear/Transparent		
Processing Method	• 3D Printing, Fused Deposition Modeling (FDM)		
Resin ID (ISO 1043)	• PA6/66		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.10	g/cm ³	ISO 1183
Water Absorption (Saturation, 73°F, 0.0787 in)	10	%	ISO 62
Water Absorption (Equilibrium, 73°F, 0.0787 in, 50% RH)	3.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	291000	psi	ISO 527-1/1A/1
Tensile Stress (Yield)	7980	psi	ISO 527-2/1A/50
Tensile Strain (Yield)	4.5	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	15	%	ISO 527-2/1A/50
Flexural Modulus ²	276000	psi	ISO 178
Flexural Stress ²	10200	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (73°F)	14	ft-lb/in ²	ISO 179/1eA
Charpy Unnotched Impact Strength (73°F)	No Break		ISO 179/1eU
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (66 psi, Unannealed)	122	°F	ISO 75-2/Bf
Deflection Temperature Under Load (264 psi, Unannealed)	113	°F	ISO 75-2/Af
Melting Temperature ³	383	°F	ISO 11357-3

Additional Information

Nozzle Temperature: 250-280°C
 Bed Temperature: 70-100°C
 Adhesion promoter: Magigoo glue
 Print Speed: 30-40 mm/s

Notes

¹ Typical properties: these are not to be construed as specifications.

² 0.079 in/min

³ 10°C/min

