



TDS Rev 2.0

**Technical Data Sheet: iOn™ PA6-based Nylon Alloy 3D Printing Filament**

Physical Properties	Standard	Unit	Typical Value
Density	ISO 1183	g/cc	1.06

Mechanical Properties	Standard	Unit	Typical Value
Tensile Strength, Break	ISO 527	MPa	62
Tensile Modulus	ISO 527	MPa	2110
Tensile Elongation, Break	ISO 527	%	9
Flexural Strength	ISO 178	MPa	78
Flexural Modulus	ISO 178	MPa	2200

Thermal Properties	Standard	Unit	Typical Value
Glass Transition Temperature (Tg)	DSC	°C	105
Deflection Temperature at 0.45 MPa (66psi)	ISO 75	°C	97

Electrical Property	Standard	Unit	Typical Value
Surface Resistance	ASTM D257	Ohm/sq	>10 <sup>13</sup>

Printed Specimen Conditions
Printer: Gearbox™ HT2
Nozzle: 0.4mm
Layer Height: 0.25mm
Infill: 100%, +/- 45°
Extrusion Temp: 270°C
Bed Temp: 100°C
Specimen Orientation: XY Flat

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