



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

<b>Material</b>	<b>Polyamide 6/6.6 copolymer</b>
<b>Filament Net Weight:</b>	<b>3.0, 4.5, 8.0 kg</b>
<b>Diameter</b>	<b>2.85 mm</b>
<b>Density</b> (ISO 1183)	<b>1.12 g/cm<sup>3</sup></b>
<b>Melting temperature</b> (DSC)	<b>190 °C</b>
<b>Vicat Softening Temperature</b> (ISO 306)	<b>180 °C</b>

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

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

## Mechanical Properties (Dry State)

<b>Young's Modulus</b> (ISO 527)	<b>2325 MPa</b>
<b>Tensile Strength</b> (ISO 527)	<b>67 MPa</b>
<b>Elongation at break</b> (ISO 527)	<b>10,0 %</b>
<b>Bending Modulus</b> (ISO 178)	<b>1725 MPa</b>
<b>Bending Strength</b> (ISO 178)	<b>98 MPa</b>
<b>Charpy Impact strength</b> (ISO 179)	<b>10 kJ/m<sup>2</sup></b>

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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