Nylon Hydrophobic

Property Data

Property	Test Method	Value
Density (g/cm^3)	ASTM D792	1.14
Water absorption/ %	ISO 62 (23 °C/24hr)	<0.3
Melt Flow Rate (MVR)/ g/10 min	ISO 1133 (250 °C)	5.1
Heat Distortion Temperature/ °C	ISO 75 (molded)	90
Continuous Service Temperature/ °C	IEC 60216	120
Service Temperature (during lifetime max 200 hr)/ °C	*	160
Tensile Strength/ kpsi	ISO 527	11.6
Tensile Elongation/ %	ISO 527	4
Modulus of elasticity/ kpsi	ISO 527	478
Charpy Impact Strength/ kJ/m^2	ISO 179	135
Insulation resistance strip electrode/ ohm	DIN IEC 60167	>10^{12}
Surface resistance	DIN IEC 60093	>10^{12}

Recommended Printer Settings

Parameter	Value
Nozzle temperature	265 - 290 °C
Heated bed temperature	>50 °C
Speed	40-60 mm/s
Infill	As needed, up to 100 %
Layer thickness	0.2 mm or higher
Bed material	PEI, glass with glue stick; other typical materials used for nylons should work as well
Drying	120 °C; keep filament in dry, sealed bag/container for storage

These processing conditions are general guidelines only. Each printer will likely have a unique set of printing parameters. Generally, slower speeds, larger nozzles and layers are beneficial. While Nylon Hydrophobic has a measurably lower moisture uptake, and moisture has less of an effect on the printing and performance, Nylon is moisture sensitive, take care to dry and maintain filament and store in a sealed container.