

HP 3D High Reusability PA11(#)(R70) - Plastics for Additive Manufacturing - Component

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File Number: E497657

Blue Card® 

Printing Process Designation Number 1 ▾

COMPANY

HP Inc
1501 Page Mill Rd
Palo Alto, CA 94304-1126 United States

MODEL INFO

HP 3D High Reusability PA11(#)(R70)

Polyamide 11 (PA11), furnished as powder for use with Multi Jet Fusion Technologies
(R70) – Material is approved for use with Reclaimed powder of 70%.
– For use with Fusing and Detailing agents HP 3D600, HP 3D700 and HP 3D710

FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		ANSI/UL 94
0.75 mm, Color: BK	HB	
1.5 mm, Color: BK	HB	
3.0 mm, Color: BK	HB	
ISO/IEC FLAMMABILITY PROPERTIES	VALUE	TEST METHOD
Flammability		IEC 60695-11-10
0.75 mm, Color: BK	HB75	
1.5 mm, Color: BK	HB75	
3.0 mm, Color: BK	HB40	
Glow Wire Ignition Temperature (GWIT)		IEC 60695-2-13
0.75 mm	675 °C	
1.5 mm	675 °C	
3.0 mm	675 °C	
Glow Wire Flammability Index (GWFI)		IEC 60695-2-12
0.75 mm	675 °C	
1.5 mm	675 °C	
3.0 mm	675 °C	
ELECTRICAL PROPERTIES	VALUE	TEST METHOD
Dielectric Strength	3.0 kV/mm	ASTM D149
Volume Resistivity	1.0E+12 ohms-cm	ASTM D257/IEC 60093
Comparative Tracking Index (CTI) (Material Group: I)	CTI600 V	IEC 60112
THERMAL PROPERTIES	VALUE	TEST METHOD
Relative Thermal Index - Electrical Strength		UL 746B
0.75 mm	65 °C	
1.5 mm	65 °C	
3.0 mm	65 °C	
Relative Thermal Index - Mechanical Impact		UL 746B
0.75 mm	65 °C	
1.5 mm	65 °C	
3.0 mm	65 °C	
Relative Thermal Index - Mechanical Strength		UL 746B
0.75 mm	65 °C	
1.5 mm	65 °C	
3.0 mm	65 °C	
Ball Pressure Temperature	170 °C	
PROCESSING PARAMETER	VALUE	TEST METHOD
Process Category	Powder Bed Fusion - Multi-Jet Fusion (MJF)	
Build Plane	Horizontal	
Post Process Method	Bead blasting: Glass beads, 70-150 µm or Ceramics beads, 150-250 µm with 3-5 bars Air Pressure. For 5-10 sec each 100cm2 with 15 cm distance to part.	
Printer	HP Jet Fusion 3D 5200 Printer, HP Jet Fusion 3D 5210 Printer, HP Jet Fusion 3D 4200 Printer, HP Jet Fusion 3D 4210 Printer. (HP Printing and Computing Solutions S L U - E165854)	
Printer Preset	Balanced	

Report Date: 2020-03-31
Revision Date: 2021-06-25

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