

Technical Data Sheet

ADSINT® PA12 HT

AdSint® PA12HT is a composite material, filled with glassbeads and aluminium. Compared to other reinforced grades **AdSint® PA12HT** offers higher temperature resistance. It can be used in an environment which requires very high heat distortion temperatures (117°C). It exhibits an excellent surface with a metallic appearance, post processing allows drilling. **AdSint® PA12HT** has been tested and approved on most common SLS printers. The refresh rate is between 30% and 40%, depending on the application.

General properties

Measurement	Method & Conditions	Metric Value
Mean Diameter	ISO 13320	40 µm
Particle Size Distribution		
Fine Particles < 22 µm	ISO 13320	10 max. %
Coarse Particles > 60 µm		10 max. %
Powder packed density 23°C	ISO 1068-1975	± 0,05g/cm ³
Part Density 23°C	ISO 61	1.29 ± 0,05g/cm ³
Part Water absorption at 23°C, 50% RH at equilibrium	ISO 62/1	0.3 to 0.5%

Thermal properties

Measurement	Method & Conditions	Metric Value
Melting point T ^m	ISO 11357-3	181 ± 2°C
Glass transition Temperature T ^g	ISO 11357-3	* ± 2°C
Heat Deflection Temperature at 0.45 MPa	ISO 75f	* ± 5°C
Heat Deflection Temperature at 1.82 MPa	ISO 75f	117 ± 2°C

Mechanical properties

Measurement	Method & Conditions	Metric Value
Tensile strength	ISO 527-2:93-1B	38 ± 1 MPa
Tensile modulus	ISO 527-2:93-1B	3100 ± 100 MPa
Elongation at break	ISO 527-2:93-1B	2 ± 1 %
Flexural modulus	ISO 178 (23°C)	2800 ± 25 MPa
Charpy – Impact strength (Unnotched)	ISO 179 1eU (23°C)	12 ± 2 kJ/m ²
Hardness (Shore D – instantaneous)	ISO 868 (20°C)	77 ± 1

Chemical resistances

ADSint® PA 12 HT features outstanding resistance to oils, hydraulic fluids and fuels, as well as excellent resistance to acids, bases and salts.

Handling – storage

Store the product in original packaging away from moisture and heat. Under these conditions, the material will maintain its technical properties for 3 years. Once the material passes the 3 year limit, it will be necessary to perform testing of the specified data to restart the shelf life period.

Delivery Form

The material will be delivered in 2kg bottles or 20kg drums (2x10kg powder bags).

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