



DuraForm[®] ProX[®] FR1200

A flame-retardant PA12 material with high accuracy and excellent surface finish. Ideally suited for direct production of aerospace, transportation and consumer goods application where reliable fire retardancy and reduced smoke and toxicity are required.

General Properties

MEASUREMENT	CONDITION	METRIC	U.S.
Sintered Part Density (g/cm ³ lb/in ³)	ASTM D792	1.03	.037
Water Absorption (%)	ASTM D570	0.1	0.1

Features

- FAR 25.853 compliant
- Passes AITM smoke density and toxicity requirements
- High accuracy and repeatability needed for manufacturing
- Non-halogenated formulation
- Excellent surface quality

Mechanical Properties

MEASUREMENT	CONDITION	METRIC	U.S.
Tensile Strength Ultimate (MPa psi)	ASTM D 638	45	6510
Tensile Modulus (MPa ksi)	ASTM D 638	2010	291
Elongation at Break (%)	ASTM D 638	8	8
Flexural Strength, Ultimate (MPa psi)	ASTM D 790	61	8900
Flexural Modulus (MPa ksi)	ASTM D 790	1720	249
Hardness, Shore D	ASTM D2240	77	77
Impact Strength @ 0.12" (J/m ft-lb/in) Notched Izod, 23°C Unnotched Izod, 23°C	ASTM D256	24 278	0.5 5.2

Benefits

- Reduce fuel costs with weight optimized design enabled by additive manufacturing
- Accelerate changes in cabin designs for in service aircraft
- Eliminate tooling and minimize spare part stocking costs
- Excellent flame retardancy at 12 and 60 second exposures

Applications

- Direct 3D production of aircraft interior parts
- Parts requiring flame retardancy
- Automotive and transportation related parts where fire safety may be needed
- Consumer electronics and other goods

Thermal Properties

MEASUREMENT	CONDITION	METRIC	U.S.
Heat Deflection Temperature @ 0.45 MPa @ 1.82 MPa	ASTM D638	180 °C 94 °C	356 °F 201 °F
Coefficient of Thermal Expansion (0-145°C) (µm/m-°C µin/in-°F)	ASTM E831	137	76
Specific Heat Capacity (J/g-°C BTU/lb-°F)	ASTM E1269 @ 23°C @ 50°C @ 100°C @ 150°C	1.63 1.98 2.35 2.85	0.39 0.47 0.56 0.68
Thermal Conductivity (W/m-K BTU-in/hr-ft²-°F)	ASTM E1530	0.25	1.73

The parts used to generate the above data were generated by building parts using 100% virgin powder using default parameters on a ProX[®] SLS 500 printer.



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Electrical Properties

MEASUREMENT	CONDITION	METRIC	U.S.
Volume Resistivity (ohm-cm ohm-in)	ASTM D257	3.61×10^{14}	1.42×10^{14}
Surface Resistivity (ohm)	ASTM D257	1.11×10^{13}	1.11×10^{13}
Dissipation Factor, 1 KHz	ASTM D150	0.032	0.032
Dielectric Constant, 1 KHz	ASTM D150	3.0	3.0
Dielectric Strength (kV/mm kV/in)	ASTM D149	17.4	442

Flammability Properties

MEASUREMENT	CONDITION	METRIC	U.S.
FAR 25.853 (a) And Appendix F Part I (b)(4) (mm in)	60 sec	3.0	0.12
FAR 25.853 (a) And Appendix F Part I (a)(1)(ii) (mm in)	12 sec	1.8	0.07
AITM 2.0007B Smoke Density, Flaming Mode Non Flaming Mode	12 sec 3 sec	pass pass	pass pass
AITM 3.0005 Combustion Toxicity Flaming Non Flaming Mode		pass pass	pass pass
AITM 2.0006 (kW/m ² BTU/s ft ²) Maximum Heat Release Rate (HRR) Total Heat Release (HR)	- 2 min	141.3 105.2	12.44 9.26
Flammability (UL File #E494541) V2 @ 5.0 mm (0.2") HB @ 1.5 mm (0.06")	UL 94 V	pass pass	pass pass



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