

# Restricted

## Product Information

# INFINAM® PA 6004 P

## POLYAMIDE-12 POWDER FOR ADDITIVE FABRICATION PROCESSES

**INFINAM® PA 6004 P** is a natural colored fine powder especially for the use in additive fabrication. Our product is suitable for manufacturing of functional prototypes, manufacturing of individual units as well as serial parts. INFINAM® PA 6004 P is especially suitable for powder bed fusion technologies.

### Features

- Powder for flame retardant 3D print parts
- Exploitable on common systems for powder-based additive fabrication
- Easy-to-process
- High process stability
- Excellent powder flow properties
- Excellent mechanical properties
- Excellent surface resolution and feature detail
- Nice surface finish
- Good resistance against numerous chemicals

The features and properties presented are to be understood as typical and are intended for reference and comparison purposes only. Due to layer-wise construction and by variation of processing conditions the actual properties of components from additive processes will vary. Due to process-related deviations the user is responsible to ensure the characteristic values required for the respective use and to carry out additional application-related tests if necessary.

FOR FURTHER INFORMATION PLEASE CONTACT US AT [EVONIK-HP@EVONIK.COM](mailto:EVONIK-HP@EVONIK.COM)  
OR VISIT OUR PRODUCT AT [WWW.3D-PRINTING.COM](http://WWW.3D-PRINTING.COM)

Powder properties	dry / cond	Unit	Test Standard
Bulk density, powder	<b>520</b>	g/l	EN ISO 60
Particle size, D(50)	<b>55</b>	µm	ISO 13320, DIN ISO 8130-13
Rel. solution viscosity	<b>1,60 / *</b>	-	ISO 307
Melting temp., DSC 1st heating, powder	<b>185 / *</b>	°C	ISO 11357

Properties of 3D printed parts acc. ISO	dry / cond	Unit	Test Standard
Tensile modulus flat X	<b>2500 / -</b>	MPa	ISO 527

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Tensile modulus on-edge Y	<b>2500 / -</b>	MPa	ISO 527
Tensile modulus upright Z	<b>2300 / -</b>	MPa	ISO 527
Tensile strength flat X	<b>47 / -</b>	MPa	ISO 527
Tensile strength on-edge Y	<b>47 / -</b>	MPa	ISO 527
Tensile strength upright Z	<b>42 / -</b>	MPa	ISO 527
Nominal strain at break flat X, εB	<b>4 / -</b>	%	ISO 527
Nominal strain at break on-edge Y, εB	<b>4 / -</b>	%	ISO 527
Nominal strain at break upright Z, εB	<b>4 / -</b>	%	ISO 527
Burnin behav. at thickness h	<b>V-0 / *</b>	class	IEC 60695-11-10
Thickness tested	<b>3,0 / *</b>	mm	-

## Characteristics

### Key Features, Industrial Sector

Industry and Engineering, 3D Printing

### Key Features, Processing

3D Printing

### Key Features, Delivery form

Powder

### Key Features, Additives

Flame retardant

### Processing

Additive manufacturing, Powder bed fusion

### Special Characteristics

Halogen-free, Semi-crystalline

### Color

White

### Additives

Flame retardant

### Delivery form

Fine powder (FP)

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