

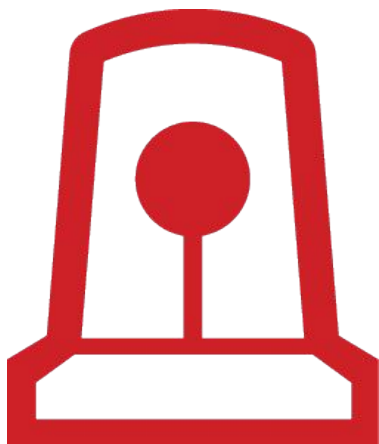
RED STOP

PA 11

RED STOP is a fine composite powder based on polyamide 11 (thermoplastic) especially formulated to function on powder bed systems by laser sintering (SLS, LS). It enables to obtain productions of models and functional parts for the food industry with long cycle of life and excellent chemical resistance.

RED STOP

PA 11



Typical features :

RED color in mass
Safety parts
signage

Applications examples :

- ➔ security parts
- ➔ Safety equipments
- ➔ warning parts
- ➔ PA 11 based parts

Refresh rate :

50%

limited to 8-10 cycles

Standard process ability of the powder on your systems
* measured on non-finish surface
** Depending on the laser sintering level and cycles.

Key Points :

100%

Color

in mass



MADE IN



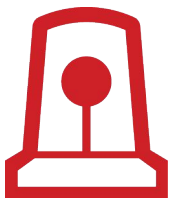
General Properties :

Chemical Nature of the Preparation :	POLYAMIDE 11 formulation . Presence of additives grade = RED STOP	
Physical State (20°C) and Color :	Solid (powder) : Red coloration in mass.	
Average Particle Size : Grain Size : Grain Size : Grain Size :	Diffraction laser : D10 D50 D90	45 < _ < 65 µm 35 µm 50 µm 80 µm
Powder packed Density 23 ° C : Part Density : 23°C Moisture absorption 24 hrs :	Method FABULOUS : Method FABULOUS : ASTM D570	0,55 +/- 0,05 g/cm ³ (estimate) 1,02 +/- 0,05 g/cm ³ (estimate) 1,12 +/- 0,05 % (estimate)

Mechanical Properties :

Young Modulus*	ISO 527	> 1600 MPa (estimate)
Flexural Modulus*	ISO 178	> 1500 MPa (estimate)
Tensile strength (Average XY)*	ISO 527	53 +/- 4 MPa (estimate)
Tensile strength (Average Z)*	ISO 527	45 +/- 3 MPa (estimate)
Elongation at break (Average XY)*	ISO 527	20 +/- 2 % (estimate)
Elongation at break (Average Z)*	ISO 527	5 +/- 2 % (estimate)
Charpy – Impact strength*	ISO 179 (20°C)	N/C
*statistics after several cycles		

The mechanical properties can vary according to the positioning of the tensile bars, operating conditions and exposure parameters of the systems used. These data rest on the current state of our knowledge. They do not give the exact characteristics of material and does not represent a guarantee.



RED STOP PA 11

Thermal Properties :

T°f Melting Point :	DSC	183 <_ < 202 °C
T° Process : According to machine Reading :	Glazing Method	- 12 +/- 2 °C (ex : 186 °C +/-2)
Flammability – Fire Classification UL-94 following ASTM D618(ISO 921) with a barrel 125 x 13 x 13 mm	UL94 vertical & Horizontal test	Red Stop : HC Out Classification

Electrical Properties :

According to the value reach in CEI 93 the material is considered as : **ISOLANT**

Volume resistivity	CEI 93	1 E+13 Ohms/m (estimate)
Horizontal surface Voluminal resistivity	CEI 93	1 E+15 Ohms (estimate)
Vertical surface Voluminal resistivity	CEI 93	1 E+15 Ohms (estimate)

Surface Finish :

Natural Coloration :	Visual	RED in mass
Shore D Hardness :	ISO 868 (20°C)	78 Shore D
Surface Ra/ Upper Facing processed & blasting :	ISO 4287	12 +/- 4 µm
Surface Ra/ Upper Facing after Finishing :	ISO 4287	6 +/- 2 µm

Chemical Properties :

Matrix in Polyamide 11 with a good chemical resistance to alkaline, hydrocarbons, oils, gasoline's, gas oil and solvents.
Attack by the acids. Sealing of wall starting from 2 mm thickness.

SOLUBILITY : WATER :	Insoluble in Water on the basis of its structure at 20 °C < 1 mg/m3 (estimated) Soluble in :Mineral acids, Phenols
Solvents :	Insoluble in most organic solvents Insoluble in : Chlorinated solvents, Alkaline conditions
Odor :	None
pH:	NA
Melting Point / Range : Decomposition Temperature : Explosive Properties :	> 180 °C Polymer: > 350 °C Dust may form explosive mixture in air (30 - 60 g/m3) Test of dust behavior in explosions : Kst = 200 - 250 m.bar/s CARE / 301 m.bar/s Explosibility class : St2 CARE Standard : ISO 6184/1 - ASTM E 1226
Explosive Limits :	Lower : in air 30 - 60 g/m3 Higher : In air Approximately 200 g/m3 (estimated)

Data Sheet_RED STOP PA11_ Oct 2021.