

PA 815-GS

High Performance Natural Coloured Nylon 11

Technical Data Sheet

POWDER PROPERTIES	TEST METHOD	PA 815-GS
Density, Bulk	ASTM D 1895	0.48 g/cc
Average Particle Size (D50)	Laser Diffraction	50 µm
Particle Size Range (D10-D90)	Laser Diffraction	38-78 µm
Sintered Part Density	ASTM D 792	1.30 g/cc

THERMAL PROPERTIES	TEST METHOD	PA 815-GS
Melting Point	ASTM D 3418	200 °C
Melt Flow Rate (3 min., 5.0 kg, 235 °C)	ASTM D 1238	13 g/10 min

MECHANICAL PROPERTIES	TEST METHOD	PA 815-GS
Heat Deflection Temp. @ 0.45 MPa	ASTM D 648	Waiting for Test Results
Heat Deflection Temp. @ 1.82 MPa	ASTM D 648	Waiting for Test Results
Ultimate Tensile Strength (XY)	ASTM D 638	36 MPa / 5,276 psi
Tensile Modulus (XY)	ASTM D 638	2,661 MPa / 386 kpsi
Flexural Modulus (XY)	ASTM D 790	1,724 MPa / 250 kpsi

Elongation at Break (XY)	ASTM D 638	10.44%
Volume Resistivity	ASTM D 257	1.3 x 10 ¹³ ohm-cm
Surface Resistivity	ASTM D 257	4.9 x 10 ¹² ohm-cm
Shore D Hardness	ASTM D 2240	76

Actual part properties may vary slightly from those listed above based on processing parameters, operating conditions, and material usage. The above properties were based on virgin ALM PA 815-GS using nominal operating parameters on a 2500+ platform. Advanced Laser Materials, LLC makes no warranties of materials for any particular application, nor does it make a warranty of any type, expressed or implied, including, but not limited to, the warranties of merchantability for a particular purpose.



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