

HP Inc
1501 PAGE MILL RD, PALO ALTO CA 94304-1126

HP 3D HR PA12(#)(R80)
Process Category: Powder Bed Fusion - Multi-Jet Fusion (MJF)
Polyamide 12 (PA12), furnished as powder for use with Multi Jet Fusion Technologies

Color	Min. Thk (mm)	Flame Class	HWI	HAI	RTI Elec	RTI Imp	RTI Str
BK	0.75	HB	-	-	65	65	65
	1.5	HB	-	-	65	65	65
	3.0	HB	-	-	65	65	65
Comparative Tracking Index (CTI): 0			Inclined Plane Tracking (IPT) kV: -				
Dielectric Strength (kV/mm): 2.8			Volume Resistivity (10 ^x ohm-cm): 14				
High-Voltage Arc Tracking Rate (HVTR): -			Surface Resistivity (10 ^x ohms/square): -				
Dimensional Change (%): -			High Volt, Low Current Arc Resis (D495): -				

Processing Parameters:Printing Process Designation Number: 1

Build Plane: HorizontalLaser Power (Watts): -

Layer Thickness (µm): -Scan Speed (m/s): -

Hatch Spacing (mm): -Scan Strategy: -

Post Processing Bead blasting: Glass beads, 70-150 µm or Ceramics beads, 150-250 µm with 3-5 bars Air Pressure. For 5-10 sec each Method: 100cm2 with 15 cm distance to part.

For use with HP Jet Fusion 3D 5200 Printer, HP Jet Fusion 3D 5210 Printer, HP Jet Fusion 3D 4200 Printer, HP Jet Fusion 3D 4210 printer: Printer. (HP Printing and Computing Solutions S L U - E165854) Printer Preset: Balanced

Limited properties and ratings assigned to samples produced by the Additive Manufacturing technique representing a specific set of printing parameters and build strategy. Other print parameters and build strategies may result in significantly different results.

- For use with Fusing and Detailing agents HP 3D600, HP 3D700 and HP 3D710

(R80) - Material is approved for use with Reclaimed powder of 80%

IEC/ISO small-scale test data does not pertain to building materials, furnishings and related contents. IEC/ISO small-scale test data is intended solely for determining the flammability of plastic materials used in the components and parts of end-product devices and appliances, where the acceptability of the combination is determined by UL.

Report Date: 2018-02-13

Last Revised: 2022-10-31

ALSO CERTIFIED TO IEC REQUIREMENTS

IEC and ISO Test Methods				
Test Name	Test Method	Units	Thk (mm)	Value
Flammability	IEC 60695-11-10	Class (color)	0.75	HB, HB75 (BK)
			1.5	HB, HB75 (BK)
			3.0	HB, HB40 (BK)
Glow-Wire Flammability (GWFI)	IEC 60695-2-12	°C	0.75	775
			1.5	700
			3.0	700
Glow-Wire Ignition (GWIT)	IEC 60695-2-13	°C	0.75	800
			1.5	725
			3.0	725
IEC Comparative Tracking Index	IEC 60112	Volts (Max)	-	-
IEC AC Dielectric Strength (AC DS)	IEC 60243-1	kV/mm	-	-
IEC DC Dielectric Strength (DC DS)	IEC 60243-2	kV/mm	-	-
IEC Volume Resistivity (VR)	IEC 62631-3-1	10 ^x ohm-m	-	-
IEC Surface Resistivity (SR)	IEC 62631-3-2	10 ^x ohms	-	-
IEC Inclined Plane Tracking (IPT)	IEC 60587	kV	-	-
IEC Ball Pressure	IEC 60695-10-2	°C	-	172
ISO Heat Deflection (1.80 MPa)	ISO 75-2	°C	-	-
ISO Tensile Strength	ISO 527-2	MPa	-	-
ISO Flexural Strength	ISO 178	MPa	-	-
ISO Tensile Impact	ISO 8256	kJ/m ²	-	-
ISO Izod Impact	ISO 180	kJ/m ²	-	-
ISO Charpy Impact	ISO 179-1	kJ/m ²	-	-