

## Technical Data Sheet

# PolyMide™ CoPA

[www.polymaker.com](http://www.polymaker.com)

V5.0



**PolyMide™**  
**CoPA**

PolyMide™ CoPA is based on a copolymer of Nylon 6 and Nylon 6,6. The filament combines excellent strength, toughness, and heat resistance of up to 180°C.

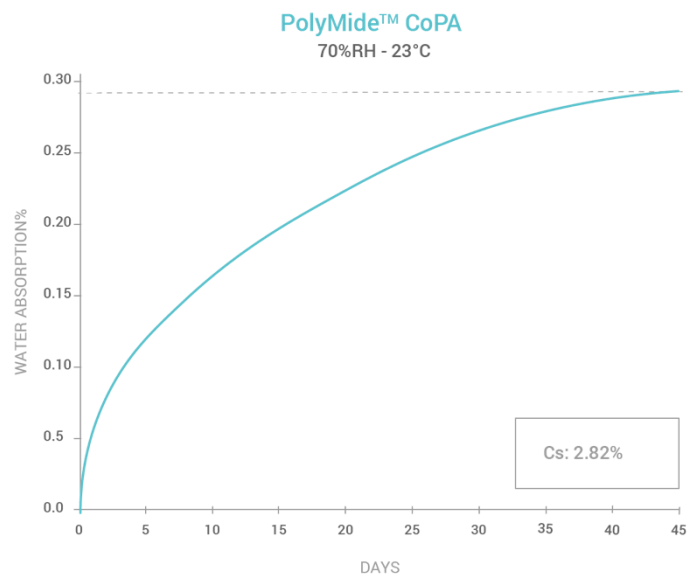
## PHYSICAL PROPERTIES

Property	Testing Method	Typical Value
Density	ISO1183, GB/T1033	1.12 g/cm <sup>3</sup> at 21°C
Melt Index	260°C, 1.2 kg	12 g/10min
Light Transmission	N/A	N/A
Flame retardancy V2	UL94	V2

## CHEMICAL RESISTANT DATA

Property	Testing Method
Effect of weak acids	Not Resistant
Effect of strong acids	Not Resistant
Effect of weak alkalis	Slight Resistant
Effect of strong alkalis	Not Resistant
Effect of organic solvent	Not Resistant
Effect of oils and grease	Resistance
Effect of Sunlight	No data available

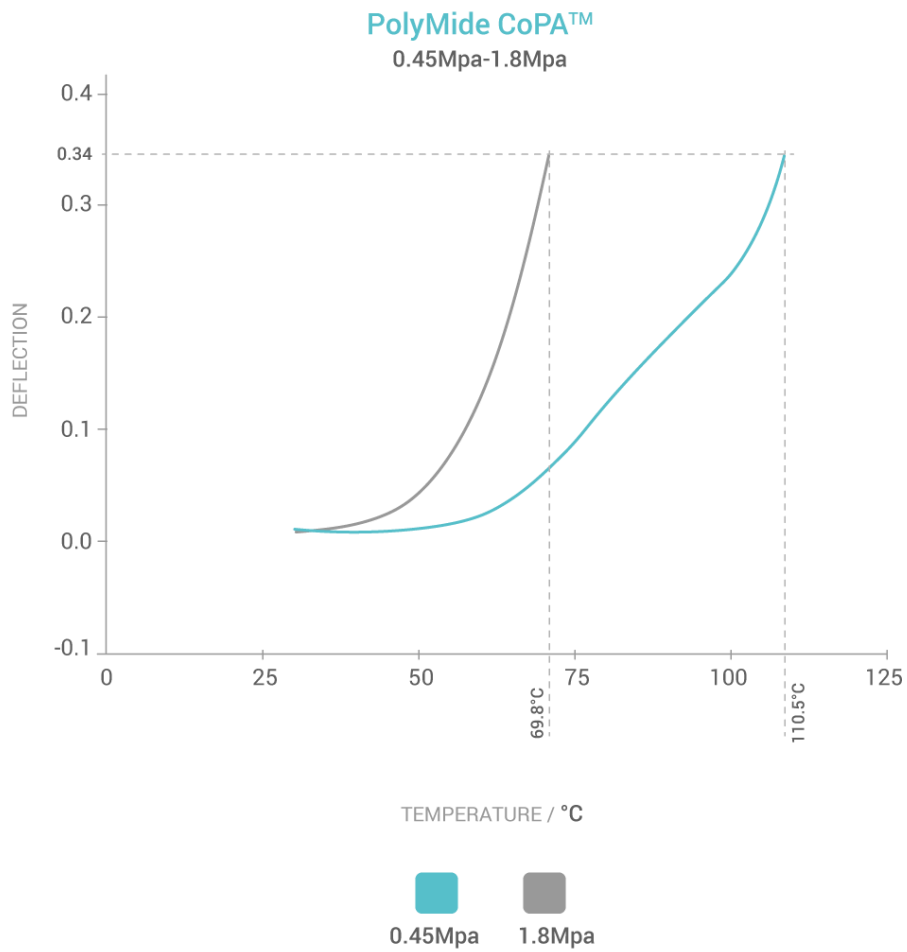
## MOISTURE ABSORPTION CURVE



## THERMAL PROPERTIES

Property	Testing Method	Typical Value
Glass transition	DSC, 10°C/min	67 °C
Melting temperature	DSC, 10°C/min	190 °C
Crystallization temperature	DSC, 10°C/min	128 °C
Decomposition temperature	TGA, 20°C/min	370 °C
Vicat softening temperature	ISO 306 GB/T 1633	180 °C
Heat deflection temperature	ISO 75 1.8MPa	69 °C
Heat deflection temperature	ISO 75 0.45MPa	110 °C
Thermal conductivity	N/A	N/A
Heat shrinkage rate	N/A	N/A

## HDT CURVE



## MECHANICAL PROPERTIES (Dry state)

Property	Testing Method	Typical Value
Young's modulus (X-Y)	ISO 527, GB/T 1040	2223 ± 199 MPa
Young's modulus (Z)		2564 ± 97 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	66.2 ± 0.9 MPa
Tensile strength (Z)		43.3 ± 9.1 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	9.9 ± 1.5 %
Elongation at break (Z)		1.8 ± 0.4 %
Bending modulus (X-Y)	ISO 178, GB/T 9341	1667 ± 118 MPa
Bending modulus (Z)		N/A
Bending strength (X-Y)	ISO 178, GB/T 9341	97 ± 1.1 MPa
Bending strength (Z)		N/A
Charpy impact strength (X-Y)	ISO 179, GB/T 9343	9.6 ± 1.4 kJ/m <sup>2</sup>
Charpy impact strength (Z)		N/A
Low temperature impact strength (X-Y)	ISO 179-1/1eA:2010, -30°C	4.5 ± 1.5 kJ/m <sup>2</sup>

### Note:

All specimens were annealed at 80°C for 30min and dried for 48h prior to testing

## MECHANICAL PROPERTIES (Moisture Conditioned)

Property	Testing Method	Typical Value
Young's modulus (X-Y)	ISO 527, GB/T 1040	1053 ± 235 MPa
Young's modulus (Z)		702 ± 16 MPa
Tensile strength (X-Y)	ISO 527, GB/T 1040	36.4 ± 0.9 MPa
Tensile strength (Z)		31.4 ± 1.5 MPa
Elongation at break (X-Y)	ISO 527, GB/T 1040	216.5 ± 12.1 %
Elongation at break (Z)		4.6 ± 0.2 %
Bending modulus (X-Y)	ISO 178, GB/T 9341	862.8 ± 133.3 MPa
Bending modulus (Z)		N/A
Bending strength (X-Y)	ISO 178, GB/T 9341	41.6 ± 11.6 MPa
Bending strength (Z)		N/A
Charpy impact strength (X-Y)	ISO 179, GB/T 9343	17.2 ± 1.4 kJ/m <sup>2</sup>
Charpy impact strength (Z)		N/A

### Note:

All specimens were annealed at 80 °C for 30 min, and conditioned at 50% relative humidity and ambient temperature for 15 days prior to testing

## HOW TO MAKE SPECIMENS

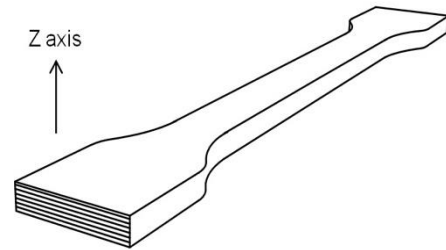
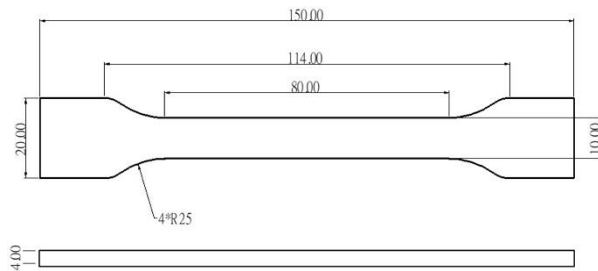
Printing temperature	265 °C
Bed temperature	50 °C
Shell	2
Top & bottom layer	4
Infill	100%
Environmental temperature	40 – 60 (recommended) (°C)
Cooling fan	OFF

### Note:

- Abrasion of the brass nozzle happens quite often when printing PolyMide™ CoPA. A wear-resistant nozzle, such as hardened steel and ruby nozzle, is highly recommended to be used with PolyMide™ CoPA.
- PolyMide™ CoPA is sensitive to moisture and should always be stored and used under dry conditions (relative humidity below 20%).
- If PolyMide™ CoPA is used as the support material for itself, please remove the support structure before excessive moisture absorption. Otherwise the support structure can be permanently bonded to the model.
- After the printing process, it is recommended to anneal the model in the oven at 70°C for 2 hours.
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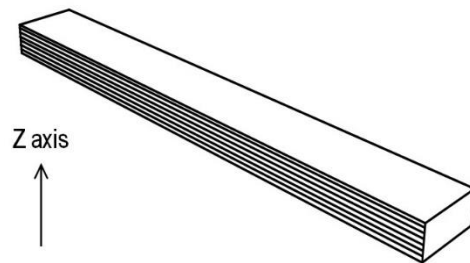
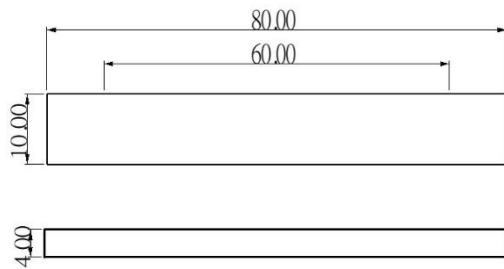
## TENSILE TESTING SPECIMEN

ASTM D638 (ISO 527, GB/T 1040)



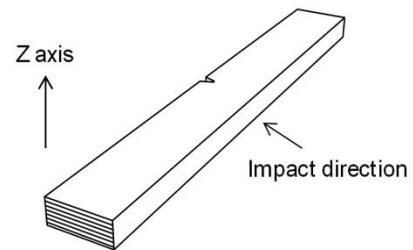
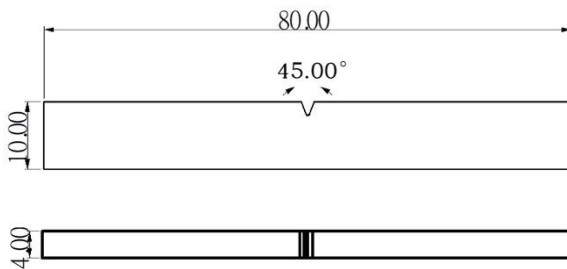
## FLEXURAL TESTING SPECIMEN

ASTM D638 (ISO 527, GB/T 1040)



## IMPACT TESTING SPECIMEN

ASTM D638 (ISO 179, GB/T 1043)



### DISCLAIMER:

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. End- use performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, etc. Product specifications are subject to change without notice.

Each user is responsible for determining the safety, lawfulness, technical suitability, and disposal/ recycling practices of Polymaker materials for the intended application. Polymaker makes no warranty of any kind, unless announced separately, to the fitness for any use or application. Polymaker shall not be made liable for any damage, injury or loss induced from the use of Polymaker materials in any application.