

## Polypropylene-copolymer

## Powder, white

Physical properties		Test method	Specimen	Units	Typical value
Specific gravity		ISO 1183-3		g/cm <sup>3</sup>	0,91
Water absorption	23°C / 24h	ISO 62	MPTS ISO 3167 A	%	< 0,2
<b>Mechanical properties</b> at 23°C / 50% rh					
Tensile strength	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	MPa	23
Elongation at maximum force	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	11,7
Elongation at break	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	269
Modulus of elasticity	dry, @1 mm/min	ISO 527	MPTS ISO 3167 A	GPa	0,8
Charpy impact strength	dry	ISO 179 1eU	80x10x4mm	kJ/m <sup>2</sup>	4,7
<b>Thermal properties</b>					
Melting temperature	DSC	ISO 11357	molded sample	°C	149
Vicat softening temp	VSTA	DIN ISO 306	MPTS ISO 3167 A	°C	118
<b>Electrical properties</b>					
Surface resistance	ROB	DIN IEC 60093	Ronde 60x4mm	Ω	>10 <sup>11</sup>
<b>Other properties</b>					
Powder d10		Laser diff.	powder	µm	25
Powder d50		Laser diff.	powder	µm	65
Powder d90		Laser diff.	powder	µm	115

## Main features



REGULATORY

Powder for laser sintering (additive manufacturing). 3D-printing of light-weight parts with high toughness for automotive, robotics and many more applications. Suitable for parts in contact with food.

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## Recommended processing parameters

## General

Due to the large variety of machines and part geometries given process parameters can only be seen as an orientation. Please use material data based on PA12, but part bed and cylinder temperature must be decreased.

Part bed temperature: 129 °C

Cylinder temperature: 105 °C

Scan speed: 3000 mm/s

Hatch distance: 0.30 mm

Layer thickness: 0.15 mm

Laser power: 31 W

x-/y-Scaling 3.1

Z-scaling 2.1

## Predrying

No predrying necessary. The powder should be de-agglomerated by using a screening process (250 microns sieve opening) before processing.

## Processing

In general LUVOSINT PP can be processed on standard lasersinter machines while observing the usual technical guidelines. Part bed powder can be re-used. Strictly avoid PA contaminations.

## Delivery form &amp; storage

Material will be delivered as 20 kg boxes on pallets.

Preferably storage should be effected in dry and normally temperatured rooms.

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