



PA6

Unreinforced,
lubricated and nucleated

| Mechanical properties | Typical data (dry) | Unit | Test method |
|--|--------------------|-------------------|-------------|
| Stress at break | 82 | MPa | ISO 527 |
| Strain at break | 4,0 | % | ISO 527 |
| Flexural strength | 100 | MPa | ISO 178 |
| Flexural modulus | 2400 | MPa | ISO 178 |
| Charpy Impact strength (+23°C) | NB | kJ/m ² | ISO 179 |
| Charpy notched Impact strength (+23°C) | 8 | kJ/m ² | ISO 179 |

| Thermal properties | Typical data | Unit | Test method |
|---|--------------|------|-------------|
| Melting temperature, 10°C/min | 220 | °C | ISO 11357 |
| Temp. of deflection under load (1.80 MPa) | 65 | °C | ISO 75 |
| Temp. of deflection under load (0.45 MPa) | 180 | °C | ISO 75 |

| Other | Typical data | Unit | Test method |
|---------------------|------------------|--------------------|-------------|
| Humidity absorption | 2.5 | % | ISO 62 |
| Surface resistivity | 10 ¹³ | Ω | IEC 60093 |
| Mold shrinkage | 0.9/0.9 | % | ISO 294-4 |
| Density | 1130 | kg/cm ³ | ISO 1183 |

Recommendations for Injection molding

| | | |
|------------------------------------|---------|----|
| Injection molding temperature | 230-270 | °C |
| Mold temperature | 50-80 | °C |
| Drying temperature | 80 | °C |
| Drying time | 4-8 | H |
| Moisture content before processing | <0,15 | % |

Characteristics

Designed for the production of injection molding of various products and parts in the automotive, machinery, household appliances and other industries

Disclaimer: Unless specified to the contrary, the value given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum value. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions and the coloring.