



PA6

Unreinforced,
lubricated and nucleated

Mechanical Properties	Typical data (dry)	Unit	Test method
Stress at break	85	MPa	ISO 527
Strain at break	4,5	%	ISO 527
Tensile Modulus	3600	MPa	ISO 527
Flexural strength	105	MPa	ISO 178
Flexural modulus	3200	MPa	ISO 178
Charpy Impact strength (+23°C)	NB	kJ/m ²	ISO 179
Charpy notched Impact strength (+23°C)	10	kJ/m ²	ISO 179
Charpy impact strength (- 30°C)	NB	kJ/m ²	ISO 179
Charpy notched Impact strength (-30°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)	75	°C	ISO 75
Temp. of deflection under load (0.45 MPa)	160	°C	ISO 75
CTE, linear, Parallel to Flow	0.9	E-4/°C	ISO 11359-1,-2
CTE, linear, Transverse to Flow	1.0	E-4/°C	ISO 11359-1,-2

Electrical Properties	Typical data	Unit	Test method
CTI Tracking index	600 (cond)	-	IEC 60112
Surface resistivity	10 ¹⁴ (cond)	Ohm	IEC 60093
Volume resistivity	10 ¹⁴	Ohm*m	IEC 60093

Physical Properties	Typical data	Unit	Test method
Density	1130	kg/m ³	ISO 1183
Moisture absorption at Equilibrium	2.5	%	ISO 62
Water absorption at Saturation	8.5	%	ISO 62
Linear mold shrinkage, Flow	1.15	%	ISO 294-4
Linear mold shrinkage, Transverse	1.20	%	ISO 294-4

Flammability	Typical data	Unit	Test method
Burning Behav. at 1.5 mm nom. thickn.	V-2	class	IEC 60695-11-10
Oxygen Index LOI	26	%	ISO 4589-1/-2
Glow Wire Flammability Index	960	°C	IEC 60695-2-12

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.

Volgamid[®] B3D



KuibyshevAzot
PUBLIC JOINT-STOCK COMPANY

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Processing Properties

Injection molding temperature	245-275	°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

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