

Product Texts

PA6/ABS blend, injection moulding grade. Natural colour.

Suitable for parts requiring good dimensional stability and low warpage. Good compromise between stiffness, toughness and good property retention after moisture absorption.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.7 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	2400 / -	MPa	ISO 527
^[C] Yield stress	53 / -	MPa	ISO 527
^[C] Yield strain	3.5 / -	%	ISO 527
^[C] Nominal strain at break	>50 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	N / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	12 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1080 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Features

Low Warpage

Delivery form

Granules, Natural Color

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Additives

Release agent

Other text information

Injection molding

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 ° C, dew point -20 ° C or below, time 2-4 h or more. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

Injection Molding Processing Parameters

Melt Temperature	Mold Temperature	Injection Speed
240 - 260°C	40 - 60°C	medium