

Product Texts

Low fuel permeation PA6 suitable for use in injection molding/welding of small engine fuel tanks

ISO 1043 PA6-I

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	13 / *	cm ³ /10min	ISO 1133
Temperature	250 / *	°C	-
Load	2.16 / *	kg	-
^[C] Molding shrinkage, parallel	1.9 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	1.8 / *	%	ISO 294-4, 2577
^[C] Density of melt	869	kg/m ³	-
^[C] Thermal conductivity of melt	0.22	W/(m K)	-
^[C] Spec. heat capacity of melt	2740	J/(kg K)	-
^[C] Eff. thermal diffusivity	9.37E-8	m ² /s	-

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	1750 / 530	MPa	ISO 527
^[C] Yield stress	43 / -	MPa	ISO 527
^[C] Yield strain	4.2 / -	%	ISO 527
^[C] Nominal strain at break	>50 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	N / N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	N / N	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	80 / N	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	22 / 20	kJ/m ²	ISO 179/1eA
^[C] Puncture - maximum force, +23°C	3300 / -	N	ISO 6603-2
^[C] Puncture energy, +23°C	48 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	55 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	100 / *	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	130 / *	°C	ISO 306
^[C] Coeff. of linear therm. expansion, parallel	100 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	110 / *	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	7 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2.5 / *	%	Sim. to ISO 62
^[C] Density	1060 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

High impact or impact modified, U.V. stabilized or stable to weather

Features

Weldable

Regional Availability

North America, Europe, Asia Pacific

Other text information

Injection molding

[Injection Molding Recommendations](#)

[Steel recommendations for molds screws and barrels](#)

[Trouble shooting guideline for injection molding](#)