

DOMAMID 6I4 575

PA6

DOMO Engineering Plastics

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	1.5 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	1.8 / *	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	1950 / 800	MPa	ISO 527
Yield stress	50 / 30	MPa	ISO 527
Strain at break	>50 / >50	%	ISO 527
Flexural modulus, 23°C	1650 / 750	MPa	ISO 178
Charpy impact strength, +23°C	N / N	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	N / N	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	65 / -	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	N / N	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	60 / -	kJ/m ²	ISO 180/1A
Rockwell hardness	R 100	-	ISO 2039-2
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	50 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	135 / *	°C	ISO 75-1/-2
Vicat softening temperature, B	170 / *	°C	ISO 306
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-
Electrical properties			
ISO Data			
Volume resistivity	1E13 / -	Ohm*m	IEC 62631-3-1
Surface resistivity	* / 1E13	Ohm	IEC 62631-3-2
Other properties			
Density	1070 / -	kg/m ³	ISO 1183
Material specific properties			
ISO Data			
Viscosity number	145 / *	cm ³ /g	ISO 307, 1157, 1628
Processing Recommendation Injection Molding			
Pre-drying - Temperature	75 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	240 - 260	°C	-
Mold temperature	60 - 90	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Special Characteristics

High impact or impact modified