Durethan® B40SKW1 000000

PA6 Envalior

Product Texts

Injection Molding, Unreinforced

ISO 1043 PA6

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Tensile Modulus	**3200 / 900**	MPa	ISO 527
[C] Yield stress	**85 / 40**	MPa	ISO 527
[C] Yield strain	**4 / 25**	%	ISO 527
[C] Nominal strain at break	**20 / >50**	%	ISO 527

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Melting temperature, 10°C/min	**222 / ***	°C	ISO 11357-1/-3
[C] Temp. of deflection under load, 1.80 MPa	**55 / ***	°C	ISO 75-1/-2
[C] Temp. of deflection under load, 0.45 MPa	**180 / ***	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
[C] Water absorption	**10 / ***	%	Sim. to ISO 62
[C] Humidity absorption	**3 / ***	%	Sim. to ISO 62
[C] Density	**1140 / -**	kg/m³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
[C] Injection Molding, melt temperature	**270**	°C	ISO 294
Injection Molding, mold temperature	**80**	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**80**	°C	-
Pre-drying - Time	**2 - 6**	h	-
Processing humidity	**≤0.12**	%	-
Melt temperature	**260 - 80**	°C	-
Mold temperature	**80 - 100**	°C	-

Characteristics

Processing
Injection Molding

Special Characteristics
U.V. stabilized or stable to weather

Delivery form
Pellets

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

Other text information

Injection molding
PREPROCESSING
Residual moisture content: 0.03 - 0.12%
Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING
Melt temperature (Tmin - Tmax): 260 - 280 °C

Mold temperature: 80 - 100 °C