

**Product Texts**

PA6 injection moulding grade. Toughened. Natural colour.

Suitable for parts requiring good impact strength.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	1.4 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	1.3 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	1950 / 650	MPa	ISO 527
<sup>[C]</sup> Yield stress	52 / 25	MPa	ISO 527
<sup>[C]</sup> Yield strain	4.4 / 35	%	ISO 527
<sup>[C]</sup> Nominal strain at break	>50 / -	%	ISO 527
<sup>[C]</sup> Charpy notched impact strength, +23°C	65 / 110	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	15 / -	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	50 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	155 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Vicat softening temperature, B	170 / *	°C	ISO 306
<sup>[C]</sup> Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Volume resistivity	1E13 / 1E11	Ohm*m	IEC 62631-3-1
<sup>[C]</sup> Surface resistivity	* / 1E10	Ohm	IEC 62631-3-2
<sup>[C]</sup> Comparative tracking index	600 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	9 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	2.6 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1070 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.15	%	-
Melt temperature	250 - 280	°C	-
Mold temperature	70 - 80	°C	-

**Characteristics**
**Processing**

Injection Molding

**Special Characteristics**

High impact or impact modified

**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

250 - 280°C

Mold Temperature

70 - 80°C

Injection Speed

medium