ECONAMID ORO 6

PA6 DOMO Engineering Plastics

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	**1.0**	%	ISO 294-4, 2577
Molding shrinkage, normal	**1.1**	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	**3050**	MPa	ISO 527
Yield stress	**80**	MPa	ISO 527
Strain at break	**40**	%	ISO 527
Flexural modulus, 23°C	**2600**	MPa	ISO 178
Charpy impact strength, +23°C	**N**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**4**	kJ/m²	ISO 179/1eA
Izod impact strength, +23°C	**N**	kJ/m²	ISO 180/1U
Izod notched impact strength, +23°C	**4**	kJ/m²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**221**	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**65**	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**175**	°C	ISO 75-1/-2
Vicat softening temperature, B	**200**	°C	ISO 306
Burning behav. at thickness h	**HB**	class	IEC 60695-11-10
Thickness tested	**0.8**	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	**1E13**	Ohm*m	IEC 62631-3-1
Surface resistivity	**1E13**	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	**1140**	kg/m³	ISO 1183

Material specific properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	**180**	cm³/g	ISO 307, 1157, 1628

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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

Applications

General Purpose

Regional Availability

North America, Europe, Asia Pacific