

## Product Texts

Polyamide 6, prime quality compound, available in custom colors also heat stabilized (H) and UV stabilized (UV).

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ISO Data</b>			
Melt flow index, MFI	22	g/10min	ISO 1133
Temperature	250	°C	-
Load	2.16	kg	-
Molding shrinkage, parallel	1.4	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Yield stress	75	MPa	ISO 527
Stress at break	70	MPa	ISO 527
Strain at break	55	%	ISO 527
Flexural modulus, 23°C	2800	MPa	ISO 178
Flexural strength	100	MPa	ISO 178
Charpy notched impact strength, +23°C	8	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	N	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	5.5	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	4	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

Thermal properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Melting temperature, 10°C/min	220	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	60	°C	ISO 75-1/-2
Vicat softening temperature, B	200	°C	ISO 306
Burning behav. at 1.5 mm nom. thickn.	HB	class	IEC 60695-11-10
Thickness tested	1.6	mm	-
Burning behav. at thickness h	V-2	class	IEC 60695-11-10
Thickness tested	0.8	mm	-
Glow Wire Flammability Index (GWFI)	750	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

Electrical properties	Value	Unit	Test Standard
<b>ISO Data</b>			
Electric strength	18	kV/mm	IEC 60243-1
Comparative tracking index	600	-	IEC 60112

Other properties	Value	Unit	Test Standard
Humidity absorption	1.5	%	Sim. to ISO 62
Density	1130	kg/m <sup>3</sup>	ISO 1183

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	75	°C	-
Pre-drying - Time	3 - 4	h	-
Processing humidity	≤0.12	%	-
Melt temperature	240 - 270	°C	-
Mold temperature	70 - 90	°C	-
Zone 1	220 - 230	°C	-
Zone 2	230 - 245	°C	-
Zone 3	250 - 260	°C	-
Nozzle temperature	250 - 260	°C	-
Screw speed	50 - 80	rpm	-
Back pressure	0.4 - 0.8	MPa	-

Holding pressure

**6 - 8**

MPa

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**Characteristics****Special Characteristics**

U.V. stabilized or stable to weather, Heat stabilized or stable to heat

**Regional Availability**

Europe