

Vydyne® 61540VE11

polyamide 6



Vydyne 61540VE11 is a high density, PA6 for injection molded applications.

General				
Regional Availability	• North America • Europe			
Agency Rating	• ISO, 1043 PA6 (GF+ME)55			
Forms	• Pellets			
Processing Method	• Injection Molding			

Physical	dry	cond.	Unit	Test Standard
Density	3.30	-	g/cm ³	ISO 1183

Mechanical	dry	cond.	Unit	Test Standard
Tensile Stress (Yield, 23°C)	135	-	MPa	ISO 527-2
Tensile Strain (Break, 23°C)	2	-	%	ISO 527-2
Flexural Modulus (23°C)	11400	-	MPa	ISO 178
Flexural Strength (23°C)	192	-	MPa	ISO 178

Impact	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	11	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	44	-	kJ/m ²	ISO 180/1U

Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature, 1.80 MPa, Unannealed	200	-	°C	ISO 75-2/A

Injection	Value	Unit
Drying Temperature	80	°C
Drying Time	4	h
Suggested Max Moisture	0.2	%
Rear Temperature	250 - 260	°C
Middle Temperature	250 - 280	°C
Front Temperature	250 - 280	°C
Processing (Melt) Temperature	250 - 280	°C
Mold Temperature	50 - 90	°C

