

Vydyne® P1000IX1

polyamide 6



Vydyne P1000IX1 (formerly P1000HI006 and Star X 2006) is an impact modified PA6 for injection molded applications.

General				
Regional Availability	• North America • Europe			
Additive	• Release agent			
Agency Rating	• ISO, 1043 PA6 I			
Appearance	• Natural Color			
Forms	• Pellets			
Processing Method	• Injection Molding			
Physical	dry	cond.	Unit	Test Standard
Density	1.11	-	g/cm ³	ISO 1183
Mechanical	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	2500	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	60	-	MPa	ISO 527-2
Tensile Stress (Break, 23°C)	44	-	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.8	-	%	ISO 527-2
Flexural Modulus (23°C)	1700	-	MPa	ISO 178
Flexural Strength (23°C)	65	-	MPa	ISO 178
Impact	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	9	-	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength, +23°C	N	-	kJ/m ²	ISO 180/1U
Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature				ISO 75-2/A
1.80 MPa, Unannealed	50	-	°C	
0.45 MPa, Unannealed	145	-	°C	
Injection	Value		Unit	
Drying Temperature	80		°C	
Drying Time	4		h	
Suggested Max Moisture	0.2		%	
Rear Temperature	220 - 230		°C	
Middle Temperature	230 - 240		°C	
Front Temperature	240 - 250		°C	

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Processing (Melt) Temperature	240 - 250	°C
Mold Temperature	60 - 90	°C

