

Description

Unreinforced polyamide PA6, standard for fast injection cycles, heat stabilized, for injection moulding.

Product Applications

The good thermal properties, the high fluidity and mould release, added to the high crystallisation speed, make it particularly for the production of parts by fast moulding cycles.

This product is available in natural and in colours on request.

Processing

The material is supplied in airtight bags, ready for use. In the case that the virgin material has absorbed moisture, it must be dried to a final moisture content less than 0.2% with a dehumidified air drying equipment at approx. 80°C.

Recommended moulding conditions:

- Barrel temperatures :

| | |
|------------------|-------------|
| feed zone | 220 - 230°C |
| compression zone | 225 - 235°C |
| front zone | 230 - 240°C |

- Mould temperatures: 20 - 50 °C

For more detailed information, please refer to the technical sheet "Injection moulding".

Safety

Please refer to the Safety Data Sheet

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The values of properties are for natural grade.

| Properties | Standards | Unit | Values | |
|---|------------------|----------|------------|---------|
| | | | d.a.m*. | Cond.** |
| Physical | | | | |
| Water absorption (24 h at 23°C) | ISO 62 | % | 1.30 | - |
| Density | ISO 1183-A | g/cm3 | 1.14 | - |
| Mechanical | | | | |
| Tensile modulus | ISO 527 type 1 A | MPa | 2950 | 1100 |
| Tensile strength at yield | ISO 527 type 1 A | MPa | 85 | 45 |
| Flexural modulus | ISO 178 | MPa | 2900 | 1000 |
| Flexural maximum stress | ISO 178 | MPa | 115 | 40 |
| Charpy notched impact strength | ISO 179/1eA | kJ/m2 | 5 | 84 |
| Charpy unnotched impact strength | ISO 179/1eU | kJ/m2 | NB | NB |
| Izod notched impact strength | ISO 180/1A | kJ/m2 | 4.5 | 75 |
| Thermal | | | | |
| Melting Temperature | ISO 11357 | °C | 222 | - |
| Heat deflection temperature, 1,8 Mpa | ISO 75/Af | °C | 80 | - |
| Coef. of Linear thermal expansion normal or perpendicular (23°C to 85°C) | ISO 11359 | E-5 / °C | 7 | - |
| Electrical | | | | |
| Relative permittivity | IEC 60250 | | 3.40 | 3.90 |
| Dissipation factor | IEC 60250 | | 0.02 | 0.10 |
| Volume resistivity | IEC 60093 | Ohm.cm | 10E14 | 10E11 |
| Surface resistivity | IEC 60093 | Ohm | 10E12 | 10E10 |
| Dielectric strength | IEC 60243 | kV/mm | - | 18 |
| Comparative tracking index sol. A | IEC 60112 | Volt | 600 | - |
| Specific | | | | |
| IMDS id number | Rhodia | | 4673925/ 3 | - |

Identification Code : >PA6<

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CHALLENGING BOUNDARIES

Engineering Plastics