



## Edgetek™ ET6000-5015 LD Black 70

### Polyamide 6

#### Key Characteristics

| General               |                                                     |                                              |                                           |
|-----------------------|-----------------------------------------------------|----------------------------------------------|-------------------------------------------|
| Material Status       | • Commercial: Active                                |                                              |                                           |
| Regional Availability | • Europe                                            |                                              |                                           |
| Features              | • Good Heat Resistance<br>• Good Stiffness          | • Good Strength<br>• Heat Stabilized         | • High Impact Resistance<br>• Low Density |
| Uses                  | • Appliance Components<br>• Automotive Applications | • Consumer Applications<br>• General Purpose | • Industrial Applications                 |
| RoHS Compliance       | • RoHS Compliant                                    |                                              |                                           |
| Appearance            | • Black                                             |                                              |                                           |
| Forms                 | • Pellets                                           |                                              |                                           |
| Processing Method     | • Injection Molding                                 |                                              |                                           |

#### Technical Properties <sup>1</sup>

| Physical                     | Typical Value (English)   | Typical Value (SI)     | Test Method |
|------------------------------|---------------------------|------------------------|-------------|
| Density                      | 1.09 g/cm <sup>3</sup>    | 1.09 g/cm <sup>3</sup> | ISO 1183    |
| Mechanical                   | Typical Value (English)   | Typical Value (SI)     | Test Method |
| Tensile Modulus <sup>2</sup> | 580000 psi                | 4000 MPa               | ISO 527     |
| Tensile Stress               | 11600 psi                 | 80.0 MPa               | ISO 527-2/5 |
| Tensile Strain (Break)       | 4.0 %                     | 4.0 %                  | ISO 527-2/5 |
| Impact                       | Typical Value (English)   | Typical Value (SI)     | Test Method |
| Notched Izod Impact Strength | 5.7 ft-lb/in <sup>2</sup> | 12 kJ/m <sup>2</sup>   | ISO 180/A   |

#### Processing Information

| Injection          | Typical Value (English) | Typical Value (SI) |
|--------------------|-------------------------|--------------------|
| Drying Temperature | 176 °F                  | 80 °C              |
| Drying Time        | 2.0 hr                  | 2.0 hr             |
| Rear Temperature   | 455 to 473 °F           | 235 to 245 °C      |
| Middle Temperature | 464 to 482 °F           | 240 to 250 °C      |
| Front Temperature  | 473 to 491 °F           | 245 to 255 °C      |
| Nozzle Temperature | 482 to 500 °F           | 250 to 260 °C      |
| Mold Temperature   | 140 to 176 °F           | 60 to 80 °C        |

#### Notes

<sup>1</sup> Typical values are not to be construed as specifications.

<sup>2</sup> 0.039 in/min (1.0 mm/min)