



Edgetek™ ET6000-5018 LD Natural 70

Polyamide 6

Key Characteristics

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

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density	1.03 g/cm ³	1.03 g/cm ³	ISO 1183
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus ²	870000 psi	6000 MPa	ISO 527
Tensile Stress	10200 psi	70.0 MPa	ISO 527-2/5
Tensile Strain (Break)	2.0 %	2.0 %	ISO 527-2/5
Flexural Modulus ²	761000 psi	5250 MPa	ISO 178
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Charpy Unnotched Impact Strength	9.5 ft·lb/in ²	20 kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength	1.9 ft·lb/in ²	4.0 kJ/m ²	ISO 180/A
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Heat Deflection Temperature 264 psi (1.8 MPa), Unannealed	365 °F	185 °C	ISO 75-2/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

¹ Typical values are not to be construed as specifications.

² 0.039 in/min (1.0 mm/min)