



# 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)

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**CONTACT INFORMATION****Americas**

United States - Avon Lake  
+1 440 930 1000

United States - McHenry  
+1 815 385 8500

**Asia**

China - Guangzhou  
+86 20 8732 7260

China - Shenzhen  
+86 755 2969 2888

China - Suzhou  
+86 512 6823 24 38

China - Suzhou  
+86 512 6265 2600

Hong Kong -  
+852 2690 5332

Taiwan - Yonghe City,  
+886 9396 99740, +886 2929 1849

**Europe**

Germany - Gaggenau  
+49 7225 6802 0

Spain - Barbastro (Huesca)  
+34 974 310 314



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[www.polyone.com](http://www.polyone.com)

**PolyOne Americas**

33587 Walker Road  
Avon Lake, Ohio 44012  
United States  
+1 440 930 1000  
+1 866 POLYONE

**PolyOne Asia**

No. 88 Guoshoujing Road  
Z.J Hi-tech Park, Pudong  
Shanghai, 201203, China  
+86 21 5080 1188

**PolyOne Europe**

6 Giällewee  
+352 269 050 35

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