

Technical Data Sheet



ALTECH PA6 A 1000/199 BK1011-13LSC

Base Polymer	Polyamide 6
Filler/Additive System	laser optimisation,Laser sensitive additive
Colour	black
Special Features	fast solidifying,easy release (demoulding),easy flow,laser etchable (blue etching)
Market Segment	Automotive
Typical Applications	housings,handles,functional components,injection moulded parts

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h dependant on moisture content max. moisture content <0,15 %
Processing Injection Moulding	melt temperature 250-270 °C mould temperature 60-100 °C
Storage	dry, protected from light

Properties	dry/cond.	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	2800 / -	MPa	ISO 178
Tensile Modulus	3200 / -	MPa	ISO 527
Tensile Elongation at Yield	10 / -	%	ISO 527
Tensile Elongation at Break	10 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	no break / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	4 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
Vicat B50	200 / *	°C	ISO 306
HDT / A (1,8 MPa)	65 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	1 - 1.2	%	ISO 294-4
Shrinkage (lateral, 24h)	1.2 - 1.4	%	ISO 294-4
Physical Properties			
Density	1130 / -	kg/m ³	ISO 1183