

Technical Data Sheet



ALTECH PA6 A 1000/199 BK1129-12LS

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 (light 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 / 900	MPa	ISO 178
Flexural Stress (3.5% Strain)	90 / 25	MPa	ISO 178
Tensile Modulus	3200 / 1000	MPa	ISO 527
Tensile Stress at Yield	81 / 45	MPa	ISO 527
Tensile Elongation at Yield	3.5 / 22	%	ISO 527
Tensile Elongation at Break	15 / 200	%	ISO 527
Impact Strength (Charpy, 23°C)	60 / 1000	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	30 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	5 / 25	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	4.5 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
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
Flammability			
Flammability (1.5 mm)	V-2 / *	class	UL 94

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(Last update: 08.10.2024)

Yellow Card available	yes / *	-	-
Flammability (3.0 mm)	V-2 / *	class	UL 94
Yellow Card available	yes / *	-	-