

Technical Data Sheet



ALTECH PA6 A 1000/518 IM

Base Polymer	Polyamide 6
Colour	black,natural color
Special Features	impact modified,easy release (demoulding)
Market Segment	Automotive,Machinery
Typical Applications	housings,functional components,injection moulded parts

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

Properties	Value	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	2300	MPa	ISO 178
Flexural Stress (3.5% Strain)	75	MPa	ISO 178
Tensile Modulus	2500	MPa	ISO 527
Tensile Stress at Yield	65	MPa	ISO 527
Tensile Elongation at Yield	3.9	%	ISO 527
Tensile Elongation at Break	20	%	ISO 527
Impact Strength (Charpy, 23°C)	no break	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	250	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	7	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	5.5	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	60	°C	ISO 75-1/-2
DSC (Melt Point)	220	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	1.1 - 1.3	%	ISO 294-4
Shrinkage (lateral, 24h)	1.5 - 1.7	%	ISO 294-4
Physical Properties			
Density	1110	kg/m ³	ISO 1183