

ALTECH PA6 A 1000/199 BK1129-12LS

(Last update: 08.10.2024)

MOCOM

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



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Flammability

Flammability (1.5 mm)	V-2 / *	class	UL 94
Yellow Card available	yes / *	-	-
Flammability (3.0 mm)	V-2 / *	class	UL 94
Yellow Card available	yes / *	-	-

Liability Exclusion

These are guide values and not a specification. The test values mentioned are representative values only and not binding minimum or maximum figures. These test values have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions.

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