

Polyamide 6 natural Standard, lubricated to achieve improvements in injection process and moulding. Is an appropriate polyamide for any injection technique and general applications.

TECHNICAL DATA SHEET

		STANDARD	UNIT	DRY	CONDITIONED
GENERALS	Density	ISO 1183	gr/cm ³	1,13	
	Melt Flow Index	ISO 1133	gr/10 min.	-	
	Humidity Pelets	ISO 1110	%	0,2	
	Hardness	SHORE D	Points	79	
	Mold Shrinkage	-	%	~1,2	

		STANDARD	UNIT	DRY	CONDITIONED	
MECHANICAL	Tensile Strenth	ISO 527	N/mm ²	75		
	Elogantion at break	ISO 527	%	-		
	Tensile Modulus	ISO 527	N/mm ²	3100		
	Charpy Impact	23 °C ISO 179		Kj/m ²	NB	
		-40 °C ISO 179		Kj/m ²	-	
	Charpy Impact	23 °C ISO 179		Kj/m ²	5	
-40 °C ISO 179			Kj/m ²	-		

		STANDARD	UNIT	DRY	CONDITIONED
ELECTRICAL	Surface Resistivity	IEC 93	Ohm	10 ¹³	
	Dielectric strength	IEC 243	Kv/mm	-	
	Tracking index (C.T.I.)	IEC 112	Kv/mm	-	

		STANDARD	UNIT	DRY	CONDITIONED
THERMAL	Deflection Temp. Under Load	0,4 N ISO 75/A	°C	160	
	(H.D.T.)	1,8 N ISO 75/A	°C	60	
	VICAT Temperatura	ISO 306	°C	~200	

- The values provided in this data sheet correspond to our knowledge. All products must be subjected to in company test by the user before application.
- These datas do not release you from the obligation to test our products as to their suitability for the intended processes and final use.
- These data may not valid such material used in combination with any other materials or additives or in - any process.
- Triesa assumes no liability and makes no warranties of any kind, expressed or implied how to use this information data.
- UL measurements are done in our lab according to this norm.

V3.00/2021

	STANDARD	UNIT	DRY	CONDITIONED
OTHERS	UL - Flammability	UL-94	-	V-2
	Glow Wire	IEC 695	°C	-
	Fammability speed	FMV 302	mm/min.	<100
	Ashes	Triesa Test	%	-
	Water absorption (24h)	ISO 62	%	~0,4
	Lubricated			YES

RECOMMENDED VALUES

PROCESSING	Drying Material	2h - 4h 100°C
	Mold. Temperature	50°C-70°C
	Processing Temperature	225°C-240°C
	Back Temperature	225°C-230°C
	Middle Temperature	235°C-240°C
	Nozzle Temperature	240°C-245°C
	Hold Pressure	50 - 90 Mpa

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