

Polymer	Characteristics	Application	Quality	Product Number
polyamide 6	PA6 basic type	injection moulding	prime	101000

Properties (in natural colour at 23°C)	Unit	Test Method	Value
<b>General</b>			
Symbols and abbreviated terms		STN EN ISO 1043-1	PA 6
Density	g/cm <sup>3</sup>	STN EN ISO 1183-1	1,13
Fillings: GF, GB, MF, G			
Stabilisation: TS, LS, K			
Modification: FR, HI, MI, ME			
Colour: NA, F, BK			NA/F
<b>Processing</b>			
Processing method: IM, E	°C		IM
Melting point DSC	°C	STN EN ISO 11357-1	220
Melt temperature range	°C		250-270
Mould temperature range	°C		60-80
Injection pressure	MPa		70-120
Drying: temperature/time	°C/H		80/4
Water content	%	STN EN ISO 3344	0,15
Melt flow rate min. 230°C/2,16 kg	g/10 min	STN EN ISO 1133	6
Manufacturing shrinkage length / width	%	STN EN ISO 294-4	1,8/1,83
<b>Mechanical</b>			
Tensile strength	MPa	STN EN ISO 527-2	85
Elongation	%	STN EN ISO 527-2	3,5
Tensile modulus	MPa	STN EN ISO 527-2	3100
Flexural modulus	MPa	STN EN ISO 178	2700
Flexural strength	MPa	STN EN ISO 178	115
Charpy impact strength 23°C	kJ/m <sup>2</sup>	STN EN ISO 179	120
Charpy impact strength -20°C	kJ/m <sup>2</sup>	STN EN ISO 179	80
Charpy notched impact strength 23°C	kJ/m <sup>2</sup>	STN EN ISO 179	1,6
Charpy notched impact strength -20°C	kJ/m <sup>2</sup>	STN EN ISO 179	1,5
<b>Thermal</b>			
Heat deflection temperature	°C	STN EN ISO 75-2 (A)	50
Vicat softening point B	°C	STN EN ISO 306	190
<b>Flammability</b>			
Flammability	°flam.	UL - 94	HB
Glow wire test	°C	STN EN 60695-2-12	960 (3mm)

Electrical			
Comparative tracking index CTI, A	V	STN EN 60112	600
Volume resistivity	Ohm.m	STN 34 6460	1x10 <sup>12</sup>
Surface resistivity	Ohm	STN 34 6460	1x10 <sup>14</sup>
Electric strength	kV/mm	STN EN 60243-2	18

### Features

Basic type PA 6 for injection moulding, modified for general use, with excellent manufacturing properties. Use: automotive, engineering, electrical and consumer-goods industry - electrical tools, fasteners, clamps, hobby tools, toys. Delivered in the natural mode and in the full RAL colour scale.

### Packaging, transportation, storage

The product is packed either in hermetically closed thick-walled 25 kg PE bags placed on a 1.000 kg palette coated by a stretch film, or in PE bag inserted in bigbag placed on a 1.000 kg palette or in PE bag inserted in paper octabin placed on a 1.000 kg palette or in other packaging according to customer requirements. The transport is provided in closed-up vehicles where the material is protected against movement and mechanical damage. The product requires stocking in closed-up, dry places protected against sun and thermal radiation.

### NOTE:

Data and values are average measured values, they are intended for technical service advices and can be changed without prior notice.

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