

Polymer	Characteristics	Application	Quality	Product Number
polyamide 6	PA6 reinforced with graphite	injection moulding	prime	147000

Properties (in natural colour at 23°C)	Unit	Test Method	Value
General			
Symbols and abbreviated terms		STN EN ISO 1043-1	PA 6
Density	g/cm ³	STN EN ISO 1183-1	1,16
Type of the filler: GF, GB, MF, G			G
Stabilisation: TS, LS, K			
Modification: FR, HI, MI, ME			
Colour: NA, F, BK			BK
Processing			
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		50-80
Injection pressure	MPa		70-120
Drying: temperature/time	°C/H		80/4
Water content	%	STN EN ISO 3344	0,15
Melt flow rate 230°C/2,16 kg	g/10 min	STN EN ISO 1133	10
Manufacturing shrinkage length / width	%	STN EN ISO 294-4	1,2/1,65
Mechanical			
Tensile strength	MPa	STN EN ISO 527-2	80
Elongation	%	STN EN ISO 527-2	7
Tensile modulus	MPa	STN EN ISO 527-2	3900
Flexural modulus	MPa	STN EN ISO 178	2600
Flexural strength	MPa	STN EN ISO 178	110
Charpy impact strength 23°C	kJ/m ²	STN EN ISO 179	60
Charpy impact strength -20°C	kJ/m ²	STN EN ISO 179	60
Charpy notched impact strength 23°C	kJ/m ²	STN EN ISO 179	3
Charpy notched impact strength -20°C	kJ/m ²	STN EN ISO 179	3
Thermal			
Heat deflection temperature	°C	STN EN ISO 75-2 (A)	50
Vicat softening point B	°C	STN EN ISO 306	200
Flammability			
Flammability	°flam.	UL - 94	HB
Glow wire test	°C	STN EN 60695-2-12	650 (3mm)

Electrical			
Comparative tracking index CTI, A	V	STN EN 60112	
Volume resistivity	Ohm.m	STN 34 6460	
Surface resistivity	Ohm	STN 34 6460	
Electric strength	kV/mm	STN EN 60243-2	

Features

PA 6 for injection moulding with addition of 5% graphite, moulding surface abrasion is significantly lowered. Used mainly in the production of crates and cases for bearings, sliding bolts and slides. Delivered in black.

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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