

PA 6 injection molding grade,lubricated, fast cycle time, for general purpose application, natural color.

Property	Test Condition	Unit	Standard	Value	Value
<b>Rheological properties</b>				D.A.M.	Moisture Content
Molding shrinkage, parallel	60x60x2mm/MT 80°C	%	ISO 294	1.2	
Molding shrinkage, normal	60x60x2mm/MT 80°C	%	ISO 294	1.3	
<b>Mechanical properties</b>					
Tensile modulus	1 mm/min	MPa	ISO 527-1,-2	3300	-
Yield Strength	50 mm/min	MPa	ISO 527-1,-2	75	-
Elongation at break	50 mm/min	%	ISO 527-1,-2	>20	-
Charpy notched impact strength	23°C	kJ/m <sup>2</sup>	ISO 179-1eA	2.5	-
Charpy notched impact strength	-30°C	kJ/m <sup>2</sup>	ISO 179-1eA	1.0	
Flexural modulus	2 mm/min	MPa	ISO 178	3000	-
Flexural strength	2 mm/min	MPa	ISO 178	115	-
<b>Thermal properties</b>					
Melting temperature	10°C/min	°C	ISO 11357-1,-3	220	
Temperature of deflection under load	1.8 MPa	°C	ISO 75-1,-2	75	
Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2	185	
Burning behavior UL 94	1.6 mm	Class	UL 94	V2	
<b>Other properties (23°C)</b>					
Density		g/cm <sup>3</sup>	ISO 1183	1.14	
<b>Processing contitions for test specimens</b>					
Injection molding-Melt temperature		°C	ISO 294	230-250	
Injection molding-Mold temperature		°C	ISO 294	80	
Drying temperature		°C	-	80	
Drying time dry air dryer		h	-	2 - 6	

#### Disclaimer

Disclaimer for sales products

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#### Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the colouring.

#### Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.