

PRODUCT CODE
PRODUCT DESCRIPTION

: M01000030
: PA6, UNREINFORCED, HEAT STABILIZED, BLACK FOR INJECTION MOLDING

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.13-1.15
	MOLDING SHRINKAGE	PARALLEL	ISO 294-4	%	1.0-1.2
	MOISTURE CONTENT	-	ISO 15512	%	<0.2

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	65-75
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	-
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	>15
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	2800-3500
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	4-7

THERMAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	VICAT SOFTENING TEMPERATURE	50 N	ISO 306	°C	195
	HEAT DEFLECTION TEMPERATURE	0,45 MPa	ISO 75	°C	175
	HEAT DEFLECTION TEMPERATURE	1,80 MPa	ISO 75	°C	60
	MELTING TEMPERATURE	10 K/min	ISO 11357	°C	220-225

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ELECTRICAL & FLAMMABILITY	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	FLAME RATING	0,75 mm	UL 94	-	-
	FLAME RATING	1,6 mm	UL 94	-	-
	GLOW WIRE FLAMMABILITY INDEX	2 mm	IEC 60695	°C	-
	GLOW WIRE IGNITABILITY TEMPERATURE	2 mm	IEC 60695	°C	-
	COMPARATIVE TRACKING INDEX	Solution A	ISO 60112	Volt	-
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	1E+15
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	1E+13

EXTRUSION PROCESS	PROPERTIES	UNITS	VALUE
	PREDRYING TEMPERATURE	°C	80-110
	PREDRYING TIME	Hours	3-4
	MELTING TEMPERATURE	°C	220-250
	EXTRUSION TEMPERATURE PROFILE_1	°C	210-230
	EXTRUSION TEMPERATURE PROFILE_2	°C	240-260
	EXTRUSION TEMPERATURE PROFILE_3	°C	240-260

Data are based on dry conditions

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