

TECHNICAL DATA SHEET

ECOSTAR®

PRODUCT CODE : M01900013
PRODUCT DESCRIPTION : PA6, UNR NATURAL

PHYSICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	DENSITY	-	ISO 1183	g/cm ³	1.12-1.15
	MOLDING SHRINKAGE	PARALLEL/NORMAL	ISO 294-4	%	<1,5
	MOISTURE CONTENT	-	ISO 15512	%	<0.2

MECHANICAL	PROPERTIES	CONDITION	STANDARD	UNITS	VALUE
	YIELD STRENGTH	+23°C	ISO 527-2	MPa	50-70
	TENSILE STRESS AT BREAK	+23°C	ISO 527-2	MPa	-
	TENSILE STRAIN AT BREAK	+23°C	ISO 527-2	%	>10
	TENSILE MODULUS	+23°C	ISO 527-2	MPa	2000-3000
	IZOD IMPACT STRENGTH, NOTCHED	+23°C	ISO 180/A	kJ/m ²	7-11

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	600
	VOLUME RESISTIVITY	-	IEC 60093	Ohm.cm	1E+15
	SURFACE RESISTIVITY	-	IEC 60093	Ohm	1E+13

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	PROPERTIES	UNITS	VALUE
INJECTION PROCESS	PREDRYING TEMPERATURE	°C	80-110
	PREDRYING TIME	hours	3-4
	MELTING TEMPERATURE	°C	230-250
	NOZZLE TEMPERATURE	°C	210-230
	PRE- 3 REGION TEMPERATURE	°C	240-260
	MID-2 REGION TEMPERATURE	°C	240-260
	AFT-1 REGION TEMPERATURE	°C	240-260
	MOLD TEMPERATURE	°C	50-90
	HOLD PRESSURE	MPa	50-100

Data are based on dry conditions

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