

Polyamide 6**unreinforced, toughness-modified, natural color**

| Physical properties | | Test method | Specimen | Units | Typical value |
|---|-----------------|-------------|-----------------|-------------------|---------------|
| Specific gravity | | ISO 1183-3 | | g/cm ³ | 1,06 |
| Water absorption | 23°C / 24h | ISO 62 | MPTS ISO 3167 A | % | <1,3 |
| Mechanical properties at 23°C / 50% rh | | | | | |
| Tensile strength | dry, @50 mm/min | ISO 527 | MPTS ISO 3167 A | MPa | 50 |
| Elongation at maximum force | dry, @50 mm/min | ISO 527 | MPTS ISO 3167 A | % | 5,5 |
| Modulus of elasticity | dry, @1 mm/min | ISO 527 | MPTS ISO 3167 A | GPa | 2 |
| Charpy impact strength | dry | ISO 179 1eU | 80x10x4mm | kJ/m ² | NB |
| Charpy impact strength | dry | | 80x10x4mm | kJ/m ² | NB |
| Charpy impact strength, notched | dry | ISO 179 1eA | 80x10x4mm | kJ/m ² | 20 |
| Thermal properties | | | | | |
| Melting temperature | DSC | ISO 11357 | molded sample | °C | 220 |

Main features

Impact resistance.

Polyamide 6**unreinforced, toughness-modified, natural color****Recommended processing parameters****Predrying**

It is advisable to predry the granulate with a suitable dryer immediately before processing. The granulate may absorb moisture from the environment.

| Dryer type | Temperature °C | Drying time in h |
|---------------------|----------------|------------------|
| Dehumidifying dryer | 75 | 10 - 16 |
| or | 105 | 4 - 6 |

Processing

| | | |
|------------------|----|-----------|
| Zone 1 | °C | 250 - 270 |
| Zone 2 | °C | 270 - 290 |
| Zone 3 | °C | 280 - 300 |
| Nozzle | °C | 270 - 280 |
| Mold | °C | 70 - 110 |
| Melt temperature | °C | 270 |

In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!

Delivery form & storage

Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.

Additional information

During processing the moisture level should not exceed 0.05%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. Excessively high predrying temperatures may cause discoloration. The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application. Please contact us for further information.

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