

**Technyl® eXten D 437P**

PA610

Solvay Engineering Plastics

**Product Texts**High viscosity unfilled polyamide PA6 10 for extrusion applications.**Rheological properties**      **dry / cond**      **Unit**      **Test Standard****ISO Data**

Molding shrinkage, parallel	2.4 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	2.3 / *	%	ISO 294-4, 2577

**Mechanical properties**      **dry / cond**      **Unit**      **Test Standard****ISO Data**

Tensile Modulus	890 / 830	MPa	ISO 527-1/-2
Stress at 50% strain	50 / 41	MPa	ISO 527-1/-2
Strain at break	>50 / >50	%	ISO 527-1/-2
Charpy impact strength (+23°C)	N / N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	N / N	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength (+23°C)	25 / 55	kJ/m <sup>2</sup>	ISO 179/1eA
Charpy notched impact strength, -30°C	4 / 3.5	kJ/m <sup>2</sup>	ISO 179/1eA

**Thermal properties**      **dry / cond**      **Unit**      **Test Standard****ISO Data**

Melting temperature (10°C/min)	215 / *	°C	ISO 11357-1/-3
Thickness tested	1.6 / *	mm	IEC 60695-11-10
UL recognition	UL / *	-	-
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10

**Other properties**      **dry / cond**      **Unit**      **Test Standard****ISO Data**

Water absorption	3.1 / *	%	Sim. to ISO 62
Humidity absorption	0.5 / *	%	Sim. to ISO 62
Density	1050 / -	kg/m <sup>3</sup>	ISO 1183

**Other text information****Injection Molding**The material is supplied in airtight bags, ready for use. In the case that the virgin material has absorbed

moisture, it must be dried to a final moisture content less than 0,1% with a dehumidified air drying equipment at approximately 80°C.

Extrusion conditions

Feed zone °C 205-215

Compression zone °C 215-225

Front zone °C 215-225

Die temperatures °C 220-230

**Chemical Media Resistance****Acids**

-  Acetic Acid (5% by mass) (23°C)
-  Sulfuric Acid (38% by mass) (23°C)
-  Sulfuric Acid (5% by mass) (23°C)

**Alcohols**

-  Ethanol (23°C)

**Hydrocarbons**

 Toluene (23°C)

**Ketones**

 Acetone (23°C)

**Mineral oils**

 SAE 10W40 multigrade motor oil (23°C)

**Standard Fuels**

 Standard fuel with alcohol (pref. ISO 1817 Liquid 4) (23°C)

**Salt solutions**

 Zinc Chloride solution (50% by mass) (23°C)

**Other**

 Hydrogen peroxide (23°C)  
 Ethylene Glycol (50% by mass) in water (108°C)  
 50% Oleic acid + 50% Olive Oil (23°C)  
 Deionized water (90°C)  
 Phenol solution (5% by mass) (23°C)