

Technical Data Sheet



ALTECH PA6 A 1000/318 IM

Base Polymer	Polyamide 6
Colour	grey
Special Features	impact modified,easy release (demoulding),heat stabilised,injection moulding grade
Market Segment	Automotive,Machinery
Typical Applications	housings,functional components

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h dependant on moisture content max. moisture content <0,15 %
Processing Injection Moulding	melt temperature 250-270 °C mould temperature 60-100 °C
Storage	dry, protected from light

Properties	dry/cond.	Dimension	Test Norm
Mechanical Properties			
Flexural Modulus	2300 / -	MPa	ISO 178
Flexural Stress (3.5% Strain)	74 / -	MPa	ISO 178
Tensile Modulus	2500 / -	MPa	ISO 527
Tensile Stress at Yield	66 / -	MPa	ISO 527
Tensile Elongation at Yield	3.9 / -	%	ISO 527
Tensile Elongation at Break	18 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	no break / -	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	no break / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	18 / -	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	12 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	57 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.9 - 1.1	%	ISO 294-4
Shrinkage (lateral, 24h)	1 - 1.2	%	ISO 294-4
Physical Properties			
Density	1120 / -	kg/m ³	ISO 1183