

Document	ISO Datasheet
Description	PA 6
Grade	DAFNEMID 6A
Code	
Application	Handles, electric cards, connectors, seat parts, door opening system, ventilator

PA6 medium viscosity.

Properties	Method	Unit	Value
Physical			
Melt flow rate (235°C - 2,16 Kg)	ISO 1133	g/10'	20
Density at 23°C	ISO 1183	g/cm3	1,13
Mould Shrinkage (%)	INTERNAL	%	1,1 – 1,5
Water absorption	ISO 62	%	2,6
Thermal			
Vicat A50	ISO 306	°C	215
Vicat B50	ISO 306	°C	198
Ball Pressure Test	IEC 60695-10-2	°C	165
Maximum service temperature	IEC 216	°C	85
HDT, A (1.80 MPa)	ISO 75/Af	°C	70
HDT, B (0.45 MPa)	ISO 75/Af	°C	180
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	2700
Flexural strength (23°C - 2 mm/min)	ISO 178	MPa	100
Tensile Modulus (23°C - 1 mm/min)	ISO 527-2	MPa	3000
Tensile stress at yield (23°C-50 mm/min)	ISO 527-2	MPa	80
Tensile elong. at break (23°C-50 mm/min)	ISO 527-2	%	>20
Rockwell hardness (L scale)	ISO 2039-2		100
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m ²	4
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m ²	5
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m ²	NB
Flammability			

Glow Wire Flammability Index GWFI (1,0 mm)	IEC 60695-2-12	°C	750
Glow Wire Flammability Index GWFI (3,0 mm)	IEC 60695-2-12	°C	750
Glow Wire Ignition Temperature GWIT (1,0 mm)	IEC 60695-2-13	°C	725
Glow Wire Ignition Temperature GWIT (3,0 mm)	IEC 60695-2-13	°C	700
Flammability class (0,8 mm)	UL94		V2
Flammability class (1,6 mm)	UL94		V2
Electrical			
Surface resistivity	IEC 60093	Ohm	1E12
Volume resistivity	IEC 60093	Ohm*m	1E13
Comparative tracking index CTI	IEC 60112	V	600
Processing Conditions			
Melt Temperature Range	ISO 294	°C	220-240
Mold Temperature Range	ISO 294	°C	60-80
Injection Velocity	ISO 294		MEDIUM
Drying Temperature		°C	80-100
Drying Time		Hour	3
Regulations compliance			
RoHS compliance status:	COMPLIANT		
EN71:			
UL listed file n°:			
Water contact approvals.			
Food contact status:			

§ Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 4.0 x 10.0 x 170 mm sample.

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