



Document	ISO Datasheet
Description	PA 6
Grade	DAFNEMID 6XA P04
Code	
Application	Injection moulding

20% glass fibers. UL94-V0 classified. Flame Retardant grade With halogens.

Properties	Method	Unit	Value
Physical			
Melt flow rate (235°C - 2,16 Kg)	ISO 1133	g/10'	5,0
Density at 23°C	ISO 1183	g/cm ³	1,54
Mould Shrinkage (%)	INTERNAL	%	0,2-0,4
Thermal			
Vicat A50	ISO 306	°C	215
Vicat B50	ISO 306	°C	205
Ball Pressure Test	IEC 60695-10-2	°C	165
HDT, A (1.80 MPa)	ISO 75/Af	°C	200
HDT, B (0.45 MPa)	ISO 75/Af	°C	210
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	6800
Flexural strength (23°C - 2 mm/min)	ISO 178	MPa	140
Tensile stress at yield (23°C-5 mm/min)	ISO 527-2	MPa	100
Tensile elong. at break (23°C-5 mm/min)	ISO 527-2	%	5,0
Rockwell hardness (L scale)	ISO 2039-2		100
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m ²	6
Charpy notched impact strength (23°C)	ISO 179/1eA	KJ/m ²	6
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m ²	35
Flammability			
Glow Wire Flammability Index GWFI (1,0 mm)	IEC 60695-2-12	°C	960
Glow Wire Flammability Index GWFI (3,0 mm)	IEC 60695-2-12	°C	960
Glow Wire Ignition Temperature GWIT (1,0 mm)	IEC 60695-2-13	°C	850
Glow Wire Ignition Temperature GWIT (2,0 mm)	IEC 60695-2-13	°C	850

Glow Wire Ignition Temperature GWIT (3,0 mm)	IEC 60695-2-13	°C	875
Flammability class (1,7 mm)	UL94		V0
Electrical			
Comparative tracking index CTI	IEC 60112	V	>300
Processing Conditions			
Melt Temperature Range	ISO 294	°C	230-260
Mold Temperature Range	ISO 294	°C	70-90
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°:	QMFZ2.E220931		
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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