

### ECONAMID® 6FL

Polyamide 6, for injection moulding.

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
<b>PHYSICAL</b>				
Density		ISO 1183	[g/cm <sup>3</sup> ]	1,13
<b>MECHANICAL</b>				
Tensile modulus	1 mm/min	ISO 527	[MPa]	2800
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	65
Tensile strain at yield	50 mm/min	ISO 527	[%]	12
Flexural modulus	2 mm/min	ISO 178	[MPa]	2000
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m <sup>2</sup> ]	45
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m <sup>2</sup> ]	6
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m <sup>2</sup> ]	5
Hardness Rockwell		ISO 2039/2	[ScaleR]	120
<b>THERMAL</b>				
Melting point	DSC	ISO 11357-1	[°C]	220 ± 2
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	170
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	75
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	205
Melt Flow Index (MFI)	275°C/ 0,325g	ISO 1133	[g/10']	9
<b>ELECTRICAL</b>				
Volume resistivity		IEC 93	[Ω·cm]	10 <sup>15</sup>
Surface resistivity		IEC 93	[Ω]	10 <sup>13</sup>
<b>BURNING BEHAVIOUR</b>				
Flammability	0,8 mm	UL 94	[Class]	HB

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products

#### PROCESSING CONDITIONS:

Drying temperature/time	: 75-95°C/4-6h
Recommended melt temperature	: 230-260 °C
Recommended mould temperature	: 40-80 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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