

Product description

An easy flowing, finely crystalline injection moulding grade for very fast processing. Parts produced include thin-walled technical parts (eg housing, fittings, grips, small parts and fixing clamps).

Physical form and storage

The product is supplied dry and ready to use in moisture-proof packaging. The material is in the form of cylindrical or flat pellets. Its bulk density is about 0,7 g/cm³. Standard packs are the special 25 kg bag and the 1000 kg bulk container (octagonal IBC=intermediate bulk container made from corrugated board with a liner bag). Subject to agreement other forms of packaging and shipment in tankers by road or rail are also possible. All containers are tightly sealed and should be opened only immediately prior to processing. To ensure that the perfectly dry material delivered cannot absorb moisture from the air the containers must be stored in dry rooms and always carefully sealed again after some of the material has been withdrawn. Ultramid® can be stored for a longer period of time in dry, well vented rooms without any change to properties. After longer storage times (> 3 months for IBC or > 2 years for bags) or if material from previously opened containers is used, drying is recommended to remove absorbed moisture. Containers stored in cold rooms should be allowed to equalise to normal temperature so that no condensation forms on the pellets.

Product safety

In case processing is done under conditions as recommended (cf. processing data sheet) melts are thermally stable and do not generate hazards by molecular degradation or the evolution of gases and vapors. Like all thermoplastic polymers the product decomposes on exposure to excessive thermal load, e.g. when it is overheated or as a result of cleaning by burning off. Further information is available from the safety data sheet.

Note

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein may change without prior information and do not constitute the agreed contractual quality of the product. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed. In order to check the availability of products please contact us or our sales agency.

Typical values for uncoloured product at 23 °C ¹⁾	Test method	Unit	Values ²⁾
Properties			
Polymer abbreviation	-	-	PA6
Density	ISO 1183	kg/m ³	1130
Viscosity number (0.5% in 96 % H ₂ SO ₄)	ISO 307, 1157, 1628	cm ³ /g	145
Water absorption, saturation in water at 23°C	similar to ISO 62	%	9 - 10
Moisture absorption, equilibrium 23°C/50% r.h.	similar to ISO 62	%	2.6 - 3.4
Processing			
Melting temperature, DSC	ISO 11357-1/-3	°C	220
MVR 275 °C/5 kg	ISO 1133	cm ³ /10min	160
Melt temperature, injection moulding/extrusion	-	°C	250 - 270
Mould temperature, injection moulding	-	°C	40 - 60
Moulding shrinkage, constrained ³⁾	-	%	0.63
Molding shrinkage (parallel)	ISO 294-4	%	0.83
Molding shrinkage (normal)	ISO 294-4	%	0.88
Flammability			
Automotive materials (Thickness >= 1mm) ⁴⁾	ISO 3795, FMVSS 302	-	+
Mechanical properties			dry / cond.
Tensile modulus	ISO 527-1/-2	MPa	3500 / 1200
Yield stress, 50 mm/min	ISO 527-1/-2	MPa	90 / 45
Yield strain, 50 mm/min	ISO 527-1/-2	%	4 / 20
Nominal strain at break, 50 mm/min	ISO 527-1/-2	%	10 / >50
Tensile creep modulus, 1000 h, strain <= 0.5%, 23°C	ISO 899-1	MPa	* / 1100
Flexural modulus	ISO 178	MPa	3000 / -
Charpy unnotched impact strength (23°C)	ISO 179/1eU	kJ/m ²	250 / N
Charpy unnotched impact strength (-30°C)	ISO 179/1eU	kJ/m ²	200 / -
Charpy notched impact strength (23°C)	ISO 179/1eA	kJ/m ²	4 / 50
Charpy notched impact strength (-30°C)	ISO 179/1eA	kJ/m ²	3 / -
Izod notched impact strength (23°C)	ISO 180/A	kJ/m ²	5 / N
Izod notched impact strength (-30°C)	ISO 180/A	kJ/m ²	5 / -
Charpy notched impact strength ISO 179/1eA (-40°C)	ISO 179/1eA	kJ/m ²	3 / 2
Charpy impact strength ISO 179-1eU (+23°C), MPTS	ISO 179/1eU	kJ/m ²	250 / -
Izod notched impact strength ISO 180/A (23°C), MPTS	ISO 180/A	kJ/m ²	4 / -
Izod notched impact strength ISO 180/A (-30°C), MPTS	ISO 180/A	kJ/m ²	3 / -
Thermal properties			
HDT A (1.80 MPa)	ISO 75-1/-2	°C	65
HDT B (0.45 MPa)	ISO 75-1/-2	°C	180
Max. service temperature (short cycle operation)	-	°C	180
Temperature index at 50% loss of tensile strength after 5000 h	IEC 60216	°C	97
Temperature index at 50% loss of tensile strength after 20000 h	IEC 60216	°C	87
Coefficient of linear thermal expansion, longitudinal (23-55)°C	ISO 11359-1/-2	E-6/K	102
Thermal conductivity	DIN 52612-1	W/(m K)	0.33
Specific heat capacity	-	J/(kg*K)	1700
Electrical properties			dry / cond.
Relative permittivity (1 MHz)	IEC 62631-2-1	-	3.3 / 7
Dissipation factor (1 MHz)	IEC 62631-2-1	E-4	300 / 3000
Volume resistivity	IEC 62631-3-1	Ohm*m	1E13 / 1E10
Surface resistivity	IEC 62631-3-2	Ohm	1E13 / 1E10
Comparative tracking index, CTI, test liquid A	IEC 60112	-	600

Footnotes

1) If product name or properties don't state otherwise.

2) The asterisk symbol "*" signifies inapplicable properties.

3) Test box with central gating, dimensions of base (107*47*1,5) mm, processing condition: TM = 260°C, TW = 60°C

4) + = passed

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