

Gravi-Tech™ X ET6000-0581 MG Black

Polyamide 6
PolyOne Corporation

Message:
High gravity PA6 compound

General Information			
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	2.88	g/cm ³	ASTM D792
Molding Shrinkage	0.50 - 0.80	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	60.0	MPa	ASTM D638
Flexural Modulus ²	11000	MPa	ASTM D790
Flexural Strength ³	120	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm, Injection Molded)	30	J/m	ASTM D256A
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	145	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	> 1.0E+12	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.20 mm)	HB		Internal method
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 90.0	°C	
Drying Time	2.0 - 4.0	hr	
Processing (Melt) Temp	240 - 280	°C	
Mold Temperature	65.0 - 85.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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