

ECONAMID® 6FL

Polyamide 6
DOMO Engineering Plastics SPA

Message:
Polyamide 6, for injection moulding.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (275°C/0.325 kg)	9.0	g/10 min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2800	MPa	ISO 527-2/1
Tensile Stress (Yield)	65.0	MPa	ISO 527-2/50
Tensile Strain (Yield)	12	%	ISO 527-2/50
Flexural Modulus ¹	2000	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	5.0	kJ/m ²	ISO 180/1A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	170	°C	ISO 75-2/B
1.8 MPa, Unannealed	75.0	°C	ISO 75-2/A
Vicat Softening Temperature	205	°C	ISO 306/B50
Melting Temperature	218 to 222	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 95.0	°C	
Drying Time	4.0 to 6.0	hr	
Processing (Melt) Temp	230 to 260	°C	
Mold Temperature	40.0 to 80.0	°C	
NOTE			

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