

ECONAMID® 6ST1

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, improved impact resistance, for injection moulding.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.11	g/cm ³	ISO 1183
Viscosity Number	135	cm ³ /g	ISO 307
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	110		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2/1
Tensile Stress (Yield)	65.0	MPa	ISO 527-2/50
Tensile Strain (Break)	> 50	%	ISO 527-2/50
Flexural Modulus ¹	2500	MPa	ISO 178
Flexural Stress ²	90.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	13	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	No Break		
23°C	No Break		
Notched Izod Impact Strength (23°C)	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break		ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	155	°C	ISO 75-2/B
1.8 MPa, Unannealed	55.0	°C	ISO 75-2/A
Vicat Softening Temperature	185	°C	ISO 306/B50
Melting Temperature	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
Burning Rate	< 100	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	

Drying Time	2.0 to 4.0	hr
Processing (Melt) Temp	240 to 260	°C
Mold Temperature	60.0 to 90.0	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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