

Witcom PA6 2011/342

Polyamide 6

Witcom Engineering Plastics B.V.

Message:

Witcom PA6 2011/342 is a polyamide 6 (nylon 6) product that contains a filler. It can be processed by injection molding and is available in Europe.

Features include:

flame retardant/rated flame

Flame Retardant

Conductivity

insulation

Halogen-free

General Information			
Filler / Reinforcement	Filler		
Additive	Flame retardancy		
Features	Heat conduction		
	Insulation		
	Halogen-free		
	Flame retardancy		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.86	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.40 - 0.70	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	3.5	%	ISO 62
Equilibrium, 23°C, 50% RH	1.2	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	< 65.0	MPa	ISO 527-2
Tensile Strain (Break)	1.0 - 2.0	%	ISO 527-2
Flexural Modulus	14000	MPa	ISO 178
Flexural Stress	110	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	4.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	20	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	195	°C	ISO 75-2/A
Thermal Conductivity	1.3	W/m/K	ASTM E1530
RTI Imp (3.00 mm)	95.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+12	ohms	ASTM D257

Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	V-0		ISO 1210
Glow Wire Flammability Index (1.60 mm)	960	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	3.0 - 5.0	hr	
Suggested Max Moisture	0.10	%	
Processing (Melt) Temp	250 - 270	°C	
Mold Temperature	60.0 - 95.0	°C	
Injection Rate	Fast		
Back Pressure	0.00 - 1.00	MPa	
Injection instructions			

Screw speed: 0.1 - 0.2 m/s Injection pressure: Keep to a minimum Hold pressure: Keep to a minimum

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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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