

# SLOVAMID® 6 LI/1

Polyamide 6

Plastcom

Message:

PA 6 with the content of thermoplastic kaoutchouc. Impacted, for mouldings with high toughness either at minus temperatures, suitable for external use, eg. ski shoes, sports and safety helmets, protection ledges of the car-doors. Delivered in natural mode and in the full RAL colour scale.

| General Information                       |                           |                   |             |
|-------------------------------------------|---------------------------|-------------------|-------------|
| Additive                                  | Impact Modifier           |                   |             |
| Features                                  | Impact Modified           |                   |             |
|                                           | Low Temperature Toughness |                   |             |
|                                           | Ultra High Toughness      |                   |             |
| Uses                                      | Automotive Applications   |                   |             |
|                                           | Safety Helmets            |                   |             |
|                                           | Sporting Goods            |                   |             |
| Appearance                                | Colors Available          |                   |             |
|                                           | Natural Color             |                   |             |
| Processing Method                         | Injection Molding         |                   |             |
| Resin ID (ISO 1043)                       | PA 6                      |                   |             |
| Physical                                  | Nominal Value             | Unit              | Test Method |
| Density                                   | 1.10                      | g/cm <sup>3</sup> | ISO 1183    |
| Melt Mass-Flow Rate (MFR) (230°C/2.16 kg) | 10                        | g/10 min          | ISO 1133    |
| Molding Shrinkage                         |                           |                   | STM 64 0808 |
| Across Flow                               | 2.0                       | %                 |             |
| Flow                                      | 2.1                       | %                 |             |
| Water Content                             | 0.20                      | %                 | ISO 960     |
| Mechanical                                | Nominal Value             | Unit              | Test Method |
| Tensile Modulus                           | 2750                      | MPa               | ISO 527-2   |
| Tensile Stress (Yield)                    | 65.0                      | MPa               | ISO 527-2   |
| Tensile Strain (Yield)                    | 4.0                       | %                 | ISO 527-2   |
| Flexural Modulus                          | 2400                      | MPa               | ISO 178     |
| Flexural Stress                           | 95.0                      | MPa               | ISO 178     |
| Impact                                    | Nominal Value             | Unit              | Test Method |
| Charpy Notched Impact Strength            |                           |                   | ISO 179     |
| -20°C                                     | 8.0                       | kJ/m <sup>2</sup> |             |
| 23°C                                      | 11                        | kJ/m <sup>2</sup> |             |
| Charpy Unnotched Impact Strength          |                           |                   | ISO 179     |

| -20°C                                              | No Break      |      |                |
|----------------------------------------------------|---------------|------|----------------|
| 23°C                                               | No Break      |      |                |
| Thermal                                            | Nominal Value | Unit | Test Method    |
| Heat Deflection Temperature (0.45 MPa, Unannealed) | 68.0          | °C   | ISO 75-2/B     |
| Vicat Softening Temperature                        | 218           | °C   | ISO 306/B      |
| Melting Temperature (DSC)                          | 222           | °C   | ISO 3146       |
| Flammability                                       | Nominal Value | Unit | Test Method    |
| Flame Rating                                       | HB            |      | UL 94          |
| Glow Wire Ignition Temperature                     | 850           | °C   | IEC 60695-2-13 |
| Injection                                          | Nominal Value | Unit |                |
| Drying Temperature                                 | 80.0          | °C   |                |
| Drying Time                                        | 4.0           | hr   |                |
| Processing (Melt) Temp                             | 240 to 260    | °C   |                |
| Mold Temperature                                   | 50.0 to 60.0  | °C   |                |
| Injection Pressure                                 | 80.0 to 150   | MPa  |                |

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