

Chemlon® 60Z

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60Z is an industrial, unfilled injection moulding grade of nylon 6, suitable for applications requiring a low cost product of modest specification and wide tolerance.

General Information				
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.11 - 1.15	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.1 - 2.0	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.8	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2500	1500	MPa	ISO 527-2
Tensile Stress	55.0	30.0	MPa	ISO 527-2
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	3.0	8.0	kJ/m ²	ISO 180/A
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	120	--	°C	ISO 75-2/B
1.8 MPa, not annealed	55.0	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+15	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	13	9.0	kV/mm	IEC 60243-1
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Oxygen Index	21	--	%	ISO 4589-2
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	20		hr	
Rear Temperature	230 - 280		°C	
Middle Temperature	230 - 280		°C	
Front Temperature	230 - 280		°C	
Processing (Melt) Temp	240 - 270		°C	
Mold Temperature	60.0 - 80.0		°C	
Injection Rate	Fast			

Back Pressure	Low
Screw Speed	Fast
Injection instructions	
No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.	
NOTE	

1. Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

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