

DOMAMID® 6AV

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, general purpose, for injection moulding.

General Information				
UL YellowCard		E170540-225449		
Features		General Purpose		
Uses		General Purpose		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	165	--	cm ³ /10min	ISO 1133
Molding Shrinkage ¹				ISO 2577
Across Flow : 23°C, 72 hr	1.0 to 1.2	--	%	
Flow : 23°C, 72 hr	0.90 to 1.1	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	120	--		ISO 2039-2
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3200	1000	MPa	ISO 527-2/1
Tensile Stress				
Yield	--	40.0	MPa	ISO 527-2/5
Yield	80.0	--	MPa	ISO 527-2/50
Tensile Strain				
Break	--	> 50	%	ISO 527-2/5
Break	40	--	%	ISO 527-2/50
Flexural Modulus ²	2800	900	MPa	ISO 178
Flexural Stress ³	135	35.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.0	--	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Notched Izod Impact Strength (23°C)	5.0	--	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break	No Break		ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method

Heat Deflection Temperature				
0.45 MPa, Unannealed	175	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	65.0	--	°C	ISO 75-2/A
Vicat Softening Temperature	200	--	°C	ISO 306/B50
Melting Temperature	222	--	°C	ISO 11357-3
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+13	--	ohms	IEC 60093
Volume Resistivity	1.0E+15	--	ohms·cm	IEC 60093
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	< 100	--	mm/min	FMVSS 302
Flame Rating (0.800 mm)	V-2	--		UL 94
Glow Wire Flammability Index (1.00 to 3.00 mm)	750 to 850	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature	75.0 to 85.0		°C	
Drying Time	2.0 to 4.0		hr	
Processing (Melt) Temp	230 to 250		°C	
Mold Temperature	60.0 to 90.0		°C	
NOTE				
1.	50% RH			
2.	2.0 mm/min			
3.	2.0 mm/min			

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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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