

TECHNYL® 1015CR BRIGHT

Polyamide 6
Solvay Engineering Plastics

Message:
Polyamide 6, unfilled, standard for fast injection cycles, for injection moulding

General Information				
Features		Fast Molding Cycle		
		Good Mold Release		
		High Flow		
Uses		Fasteners		
		Gears		
Appearance		Natural Color		
Processing Method		Injection Molding		
Part Marking Code (ISO 11469)		>PA6<		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Molding Shrinkage				Internal Method
Across Flow	1.5 to 2.0	--	%	
Flow	1.3 to 1.7	--	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.3	--	%	ISO 62
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	115	--		ASTM D785
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength (Yield)	90.0	--	MPa	ASTM D638
Tensile Elongation (Break)	30	--	%	ASTM D638
Flexural Modulus	3050	--	MPa	ASTM D790
Flexural Strength (Break)	120	--	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	85	--	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Deflection Temperature Under Load				ASTM D648
0.45 MPa, Unannealed	60.0	--	°C	
1.8 MPa, Unannealed	180	--	°C	
Melting Temperature	222	--	°C	ISO 11357-3
CLTE - Flow (23 to 85°C)	7.0E-5	--	cm/cm/°C	ISO 11359-2

Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+13	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+11	ohms·cm	IEC 60093
Electric Strength	--	18	kV/mm	IEC 60243-1
Dissipation Factor (1 MHz)	0.020	0.10		IEC 60250
Comparative Tracking Index (Solution A)	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating	HB	--		UL 94
Glow Wire Flammability Index (0.800 mm)	675	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Suggested Max Moisture	0.20		%	
Rear Temperature	230 to 235		°C	
Middle Temperature	235 to 245		°C	
Front Temperature	245 to 250		°C	
Mold Temperature	60.0 to 80.0		°C	

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