

**Polyamide 6 natural Standard, lubricated to achieve improvements in injection process and moulding. Is an appropriate polyamide for any injection technique and general applications.**

TECHNICAL DATA SHEET

		STANDARD	UNIT	DRY	CONDITIONED
GENERALS	Density	ISO 1183	gr/cm <sup>3</sup>	1,13	
	Melt Flow Index	ISO 1133	gr/10 min.	-	
	Humidity Pelets	ISO 1110	%	0,2	
	Hardness	SHORE D	Points	79	
	Mold Shrinkage	-	%	~1,2	

		STANDARD	UNIT	DRY	CONDITIONED
MECHANICAL	Tensile Strength	ISO 527	N/mm <sup>2</sup>	75	
	Elongation at break	ISO 527	%	-	
	Tensile Modulus	ISO 527	N/mm <sup>2</sup>	3100	
	Charpy Impact	23 °C ISO 179	Kj/m <sup>2</sup>	NB	
		-40 °C ISO 179	Kj/m <sup>2</sup>	-	
	Charpy Impact	23 °C ISO 179	Kj/m <sup>2</sup>	5	
-40 °C ISO 179		Kj/m <sup>2</sup>	-		

		STANDARD	UNIT	DRY	CONDITIONED
ELECTRICAL	Surface Resistivity	IEC 93	Ohm	10 <sup>13</sup>	
	Dielectric strength	IEC 243	Kv/mm	-	
	Tracking index (C.T.I.)	IEC 112	Kv/mm	-	

		STANDARD	UNIT	DRY	CONDITIONED
THERMAL	Deflection Temp. Under Load	0,4 N ISO 75/A	°C	160	
	(H.D.T.)	1,8 N ISO 75/A	°C	60	
	VICAT Temperatura	ISO 306	°C	~200	

- The values provided in this data sheet correspond to our knowledge. All products must be subjected to in company test by the user before application.
- These data do not release you from the obligation to test our products as to their suitability for the intended processes and final use.
- These data may not valid such material used in combination with any other materials or additives or in - any process.
- Triesa assumes no liability and makes no warranties of any kind, expressed or implied how to use this information data.
- UL measurements are done in our lab according to this norm.

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	STANDARD	UNIT	DRY	CONDITIONED
OTHERS	UL - Flammability	UL-94	-	V-2
	Glow Wire	IEC 695	°C	-
	Fammability speed	FMV 302	mm/min.	<100
	Ashes	Triesa Test	%	-
	Water absorption (24h)	ISO 62	%	~0,4
	Lubricated			YES

RECOMMENDED VALUES

PROCESSING	Drying Material	2h - 4h 100°C
	Mold. Temperature	50°C-70°C
	Processing Temperature	225°C-240°C
	Back Temperature	225°C-230°C
	Middle Temperature	235°C-240°C
	Nozzle Temperature	240°C-245°C
	Hold Pressure	50 - 90 Mpa

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SOURCE: Triesa Quality Control; Last update: 12/05/2020