

ECONAMID® FNP 6

Polyamide 6, for injection moulding

10.03.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,13
RHEOLOGICAL				
Viscosity number	96% H ₂ SO ₄	ISO 307	[ml/g]	135
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	2800
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	65
Tensile strain at yield	50 mm/min	ISO 527	[%]	12
Flexural modulus	2 mm/min	ISO 178	[MPa]	2000
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	5
Hardness Rockwell		ISO 2039/2	[ScaleR]	120
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	170
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	75
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	205
ELECTRICAL				
Volume resistivity		IEC 62631-3-1	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 62631-3-2	[Ω]	10 ¹³
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for black products

PROCESSING CONDITIONS:

Drying temperature/time	: 75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	: 230-270 °C
Recommended mould temperature	: 40-80 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part. ECONAMID grades are not recommended for injection moulding hot runner systems with a diameter below 1mm

The information provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all conditions under which this information and our products of other manufactures in combination with our products may be used. Domo accepts no responsibility for results obtained by the application of this information or for the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each product or product combination for their own purposes. Unless otherwise agreed in writing, Domo sells the product without warranties. Buyers and users assume all responsibility and liability for loss or damage arising from handling and use of our products, whether used alone or in combination with other products. Unless specifically indicated, the grades mentioned are not suitable for applications in the pharmaceutical/medical sector.