

POLYAMIDE (PA 6) Granule.
(Natural Virgin)

Description	PA 6 Un Filled Natural Compound	
Product Application	The Grade is used in all Sectors of Industry, Fasteners, clip, Gears, Bobbins Hand mixer cover.	
Benefits	Offering an excellent Flow ability. It is particularly suitable for the production of technical Molding with fast injection cycle.	
Processing Guide	The material is supplied in airtight 3 layer Paper + PE + Aluminium Foil Liner Bags . Still Nylon being hygroscopic material it is recommended for hot air drying at 80°C for 4 to 6 Hrs ensuring maximum water content as 0.2 %	
Pre-Heating		
	Injection Molding Conditions	
	Barrel Temperatures	
Feed Zone	230°C	240°C
Compression Zone	240°C	250°C
Mixing Zone	250°C	260°C
Mold Temperatures	60°C	80°C
Post Molding Recommendations	Molded Compounds should be conditioned in water at a min of 95°C until they absorb 0.8 – 1.2 % of water above their original weight.	
Safety Information	Detailed information regarding safety are available on the safety Data Sheet (MSDS). MSDS is sent with the first material order available by contacting our customer services	
Regulations Compliance	Directive 1907/2006/EC. This grade complies with ROHS directive 2002/95/EC	

LALITH EXPORTERS

5, First Floor, H.K. COMPLEX

Near . Dharnidhar Derasar, Paldi, Ahmedabad-380007 (INDIA)

**TECHNICAL DATA SHEET
OF
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Properties	Test Method	Unit	Typical Data	
			Dry	Conditioned
MECHANICAL PROPERTIES				
Tensile Strength	ASTM D-638	M Pa	75	55
Elongation at Break	ASTM D-638	%	>50	>50
Flexural Strength	ASTM D-790	M Pa	110	95
Flexural Modulus	ASTM D-790	M Pa	3000	2300
Izod Notched Impact Strength (23°C)	ASTM D-256 A	Kg-cm/cm	5	8
Rockwell Hardness (M.Scale)	ASTM D-785	M Scale	70	-
Rockwell Hardness (R. Scale)	ASTM D-785	R Scale	80	-
THERMAL PROPERTIES				
Heat Deflection Temperature @18.5Kg/Sq.Cm Load	ASTM D-648	°C	70	
Heat Deflection Temperature @4.5Kg/Sq.Cm Load	ASTM D-648	°C	150	
Melting Point	ASM D-2117	°C	220	
Flammability UL 94 (Thickness 0.8mm)	ISO1210/UL-94	-	H.B	
ELECTRIAL PROPERTIES				
Dielectric Strength	IEC 60243	KV/mm	28	
Comparative Tracking Index	IEC 60112	Volts	600	
Volume Resistivity	IEC 60093	Ohms – m	1E13	1E11
Surface Resistivity	IEC 60093	Ohms	-	1E14
RHEOLOGICAL PROPERTIES				
MFI	ASTM D-1238	Gm/10 min	-	
Mold Shrinkage (Parallel)	ASTM D-955	%	1.18	
Mold Shrinkage (Normal)	ASTM D-955	%	1.18	
OTHER PROPERTIES				
Specific Gravity	ASTM D-792	-	1.13	
Filler Content	ASTM D-5630	%	N/A	
Water Absorption (Saturation, immersed)	ASTM D-570	%	9.5	
Water Absorption (23°C , 24 Hrs.)	ASTM D-570	%	2.58	

Disclaimer of Warranty and Liability

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and is in no way binding. This information must on no account be used as a substitutive for necessary prior tests which alone can ensure that a product is suitable for a given use. ANY WARRANTY OF PRODUCT PERFORMANCE, MERCHANTABILITY FITNESS FOR A PARTICULAR PURPOSE IS EXPRESSLY EXCLUDED. Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document and NPL is at their disposal to supply any other information.

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