

ECONAMID® FL 6M30 500

(ECONAMID 6M30STFL)

Polyamide 6, 30% mineral filler, improved impact modification, for injection moulding

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-I-MD30
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,34
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	3800
Tensile stress at break	5 mm/min	ISO 527	[MPa]	60
Tensile strain at break	5 mm/min	ISO 527	[%]	20
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	7
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	70
ELECTRICAL				
Volume resistivity		IEC 60093	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 60093	[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 : 260-280 °C
 Recommended mould temperature : 80-120 °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

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