

PA6 high impact compound known for its exceptional stiffness, impact strength, and dimensional stability, heat stabilized.

Form	Granules			
Color available	All color			
Processing method	Injecton			
Features	Lubricated	Heat stabilized		
Additive				
Available	Resistant to hydrolysis		Resistant to metals	Colored
According or exceeded	VW TL 50125-PA6-002	STELLANTIS MS DB 41-CPN 3526	FORD ESF-M4D426-A	
According or exceeded	GMP.PA6.004	PACKARD M-2170	STELLANTIS MS-DB-41 Type PA CPN2785	
According or exceeded	GMP.PA6.016	FORD ESF-M4D423-A	GMP.PA6.003	
Physical properties	ASTM	ISO	Unit	Value
Description	-	1043	-	PA6-HI
Density	D1505	1183	g/cm ³	1.09
Ash content	D2584	3451	%	-
Linear molds shrinkage	D955	294-4	%	1.3 ÷ 1.7
Relative Viscosity (RV) 1% [m/v] in 96% [m/m] sulfuric acid	-	307	-	2.7
Viscosity Number (VN) 0,5% [m/v] in 96% [m/m] sulfuric acid	-	307	ml/g	143
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	D1238	1133	gr/10'	-
Mechanical properties				Dry/Wet
Tensile strength at yield	D638	527	MPa	50/33
Tensile strength at break	D638	527	MPa	-
Tensile elongation at break	D638	527	%	2
Tensile modulus	D638	527	MPa	1950/1000
Flexural stress	D790	178	MPa	80/40
Flexural modulus	D790	178	MPa	1850/850
IZOD impact strength, notched 23°C	-	ISO 180 1eA	kJ/m ²	70/90
IZOD impact strength, notched -30°C	-	ISO 180 1eA	kJ/m ³	-
Charpy impact strength, unnotched 23°C	-	ISO 179 1eA	kJ/m ²	-
Thermal properties				
Vicat Method B50 (50N/50°C)	D1525	306	°C	-
H.D.T. method B (0.45MPa)	D647	75	°C	135
H.D.T. method A (1.82 MPa)	D648	75	°C	52
Aging test (150°C)	-	-	hrs	> 200
Flammability properties				
Flame rating 1.6 mm	UL 94	UL 94	Class	HB
Flame rating 3.2 mm	UL 94	UL 94	Class	HB
Automotive materials (Thickness >=1 mm)	FMVSS 302	3795	mm/min	< 100
Processing conditions				
Rear temperature	-	-	°C	250 ÷ 255
Middle temperature	-	-	°C	250 ÷ 255
Front temperature	-	-	°C	250 ÷ 255
Nozzle temperature	-	-	°C	250 ÷ 255
Molds temperature	-	-	°C	80 ÷ 90
Injection Pressure	-	-	MPa	3.50 ÷ 12.5
Injection rate	-	-	-	Fast
Back Pressure	-	-	MPa	0.2 ÷ 3
Ejection emperature	-	-	°C	155
Drying (Optional)	-	-	hrs / °C	2 ÷ 4 h - 80°C
Suggested Max Moisture	-	-	%	0.05