

Product Description

Polyamide 6 - Unfilled

Product Applications

Automotive: Switch Parts, Plug & Socket, Handle and Grab Handle

Electrical & Electronic: Energy Meter Parts, Solar Panel Parts, Rotor Switch and Sensor

General

Material Status	<ul style="list-style-type: none"> Commercial : Active
Filler/Reinforcement	<ul style="list-style-type: none"> Unfilled
Forms	<ul style="list-style-type: none"> Pellets
Additive	<ul style="list-style-type: none"> Mold Release
Appearance/Color	<ul style="list-style-type: none"> Black
Processing Method	<ul style="list-style-type: none"> Injection molding

Physical	Typical Value	Unit	Test Method
Specific Gravity	1.13	-	ASTM D-792
Water Absorption			
Saturation, 23°C	6.0	%	ISO-62
Equilibrium, 23°C, 50%RH	2.2	%	

Mechanical	Dry	Unit	Test Method
Tensile Stress (Yield)	55	MPa	ASTM D-638
Tensile Strain (Break)	10	%	ASTM D-638
Flexural Strength	92	MPa	ASTM D-790
IZOD Impact Strength (23°C)			
Notch	70	J/m	ASTM D-256A

Flammability	Dry	Unit	Test Method
Flammability Classification			
1.50mm	HB	Rating	UL 94

Electrical	Dry	Unit	Test Method
Dielectric Strength	25	Kvmm ⁻¹	ASTM D 149
Surface Resistivity	10 ¹¹	Ohm/sq	IEC 60093
Volume Resistivity	10 ¹¹	Ohm/cm	IEC 60093

Injection Molding – XU150BB01**Drying Conditions**

Drying Time(hour)	Temperature	Remarks
3-4	85-90°C	Temperature should not be more than 90°C to avoid discoloration Moisture content after drying should be <0.2% Avoid sudden cooling of dry pellet

Injection Molding Temperatures (°C)

Mold	Melt	Nozzle	Centre	Feed zone
55 – 80	240 – 265	235 -255	235 -250	230-250

Physical form and storage

ESTOPLAST XU is supplied in pellet form. It should be pre-dried as per the guideline mentioned above prior to molding. Standard packing size is 25kg. In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged.

Product Safety

ESTOPLAST XU is thermally stable up to 350°C and does not give rise to hazardous material due to degradation or evolution of gases and vapors. ESTOPLAST XU decomposes above 350°C and gives carbon dioxide and water on charring.

For more information on safety, refer individual product MSDS. Available on request.

Note

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