

Product name: VEKTRAMID PA6 ABI compound
Use of the product: Injection molding (medium)
Company: POLIVEKTRIS

The compound is supplied dry and ready for use. Depending on the storage conditions between delivery and usage moisture levels can vary and have to take care of.

PROPERTIES	TEST CONDITION	UNITS	METHOD	RESULT
GENERAL PROPERTIES				
Form	-	-	-	pellets
Color	-	-	-	black
Density	23°	g/cm3	ISO 1183	~1.14
Mold Shrinkage (average)	60x60x2mm/MT 80°C	%	ISO 294	0.4-0.8
Relative Viscosity	H2SO4	cm3/(10min)	ISO 1133	-
Melt Flow Rate (MFR)	-	g/10 min	ISO1133	5-15
Melting temperature	10°C/min	°C	ISO 11357-1,-3	220-240
Not cut through granules	-	%	-	<0.60
Moisture content	-	%	-	<0.40
Ash content	-	%	-	-
Filler content	-	%	ISO 3451-1	-
PHISICAL-MECHANICAL PROPERTIES [dry]				
Tensile modulus	1 mm/min	Mpa	ISO 527-2	2250
Maximum tensile strength	20mm/min	Mpa	ISO 527-1,2	-
Tensile strength at yield	20 mm/min	Mpa	ISO 527-1,2	50
Tensile strength at break	20 mm/min	Mpa	ISO 527-1,2	40
Elongation at yield	20 mm/min	%	ISO 527-1,2	-
Elongation at break	20 mm/min	%	ISO 527-1,2	2-5
Charpy impact strength (UNNOTCHED)	23°	KJ/m2	ISO 179/1eU	nb
Charpy impact strength (UNNOTCHED)	-30°	KJ/m2	ISO 179/1eU	-
Charpy impact strength (NOTCHED)	23°	KJ/m2	ISO 179/1eA	-
Izod notched impact strength	23°	KJ/m2	ISO 180-1A	-
Flexural modulus	20 mm/min	Mpa	ISO 178	2800
Maximum flexural strength	20 mm/min	N (Mpa)	ISO 178	90
Rockwell hardness		N/mm2	ISO2039	-
THERMAL PROPERTIES				
Vicat softening temperature B	9,8N	°C	ISO 306	-
Heat deflection temperature	0,45 Mpa	°C	ISO 75-2	-
Heat deflection temperature	1,80 Mpa	°C	ISO 75-2	-
Heat resistance (ball test)	-	°C	IEC 60695-10-2	-
PROCESSING CONDITIONS				
Injection molding melt tem.		°C	ISO 294	-
Injection molding mold tem.		°C	ISO 294	70-90
Drying temperature		°C		80-100
Drying time dry air dryer	-	h		4

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These test values have been determined on standardized test specimen and they can be affected by pigmentation, mould design and processing conditions.