

### ISONYL® 6 – PA 6

Structure	Semicrystalline
Density	1.14 (unfilled)–1.35 g/cm <sup>3</sup> (30% glass fiber reinforced)
General properties	Tenacious when moist (2-3% water), hard, stiff, abrasion resistant. Highly hygroscopic and good antifriction properties.
Barrel temperature	(+ 15°C - 15°C) to be added for glass fiber reinforced to decrease for flame retardant grades)
Feed zone:	60 – 90 °C
Zone 1:	230 – 240 °C
Zone 2:	230 – 250 °C
Zone 3:	240 – 250 °C
Zone 4:	240 – 250 °C
Zone 5:	240 – 250 °C
Nozzle:	240 – 250 °C
Melt temperature	240 – 250 °C
Mould temperature	60 – 110 °C
Injection temperature	900 – 1600 bar
Post-pressure	Between 40 and 60% of injection pressure, high post-pressure time
Counterpressure	30 – 90 bar
Injection speed	High.
Screw speed	Equal to peripheric speed of 1.0 m/s
Metering	0.5 – 3.5 diameters
Cushion	2 – 6 mm, depends on metering and screw diameter
Drying	4 hours at 80°C. Store the product in sealed and waterproof bags.
Recycle	Maximum 10% of regrinded material. This percentage decreases for technical and aesthetic parts.
Shrinkage	0.7–2.0% unfilled; 0.3-0.8% reinforced.
Barrel equipment	Standard screw, non-return valve, free-flow nozzle

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Quenching

Not necessary to purge with other materials. Purge with natural product suggested after flame retardant processing.

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