DOMO® Engineering Plastics
Technical Data Sheet

DOMAMID® 6V0M

Polyamide 6, flame retardant, halogen and phosphorous free, for injection moulding.

13/03/2014

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm³]	1,17
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,9 ÷ 1,1
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,9 ÷ 1,1
MECHANICAL				**dam / cond.***
Tensile modulus	1 mm/min	ISO 527	[MPa]	3400 / 1500
Tensile strain at break	50 mm/min	ISO 527	[%]	15 / >50
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	80 / 40
Flexural modulus	2 mm/min	ISO 178	[MPa]	3200 / 1300
Flexural strength	2 mm/min	ISO 178	[MPa]	120 / 50
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m²]	80 / NB
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m²]	4 / 10
Izod impact unnotched	+23 °C	ISO 180/1A	[kJ/m²]	70 / NB
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m²]	3,5 / 10
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	222
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	180
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	70
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	205
ELECTRICAL				
Volume resistivity		IEC 93	[Ω·cm]	10^{15}
Surface resistivity		IEC 93	[Ω]	10^{13}
Comparative Tracking Index (CTI)	Solution A	IEC 112	[V]	600
BURNING BEHAVIOUR				
Flammability	1,5 mm	UL 94	[Class]	V0
Glow Wire Flammability Index (GWFI)	1 - 3 mm	IEC 60695-2-12	[°C]	960
Glow Wire Ignition Temperature (GWIT)	1 - 3 mm	IEC 60695-2-13	[°C]	750
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for natural colored products
**: conditioned according to ISO 1110*

PROCESSING CONDITIONS:

Drying temperature/time	: 75-85°C / 2-4h
Recommended melt temperature	: 230-250 °C
Recommended mould temperature	: 60-80 °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.

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