

ISSUED: 04/11/2014

ISO 9001 CERTIFIED

Promyde B936 L is a lubricated Polyamide 6 grade of high viscosity with improved transparency for extrusion.

PROPERTIES	CONDITIONS	TEST METHOD	UNITS	VALUES
PHYSICAL PROPERTIES				
Density	23 °C	ISO 1183	g/cm ³	1,11
Melt volume rate	275 °C/5Kg	ISO 1133	cm ³ /g	30
Haze	Mold T ^a =30°C; Thickness 1,5mm	ASTM D1003	%	7
Moisture absorption	23 °C / 50% r.h.	ISO 62	%	3
Water absorption	23 °C / saturation in water	ISO 62	%	9,5
Flammability	1,5 mm	UL-94		V-2
Glow wire flammability index	1,5 mm	IEC 60695-2-12,13	°C	800
Glow wire ignitability temperature	1,5 mm	IEC 60695-2-12,13	°C	675
MECHANICAL PROPERTIES (dry/cond.)*				
Tensile modulus	23 °C, 1 mm/min	ISO 527-1/-2	MPa	2.600/ 1.000
Tensile strength	23 °C, 50 mm/min	ISO 527-1/-2	MPa	75 / 35
Elongation at yield	23 °C, 50 mm/min	ISO 527-1/-2	%	4 / 40
Elongation at break	23 °C, 50 mm/min	ISO 527-1/-2	%	140/ > 50
Flexural modulus	23 °C, 2 mm/min	ISO 178	MPa	2.500 / 1.000
Flexural strength	23 °C, 2 mm/min	ISO 178	MPa	100 / 30
Charpy unnotched impact strength ¹⁾	23°C -30°C	ISO 179/1eU	kJ/m ²	95 / NB - / -
Charpy notched impact strength	23°C -30°C	ISO 179/1eA	kJ/m ²	5,0 / 30 - / -
THERMAL PROPERTIES				
Melting temperature (DSC)	10°C/min	ISO 3146	°C	200
Heat Deflection Temperature (HDT)	1,8 MPa 0,45 MPa	ISO 75-1/-2	°C	55 180
Thermal coefficient of linear expansion	23-80°C long. 23-80°C transv.	ISO 11359-1/-2	10 ⁻⁴ /K	0,7 1
ELECTRICAL PROPERTIES (dry/cond.)*				
Dielectric constant	1MHz	IEC 60250		3,5 / 7
Dissipation factor	1 MHz	IEC 60250		300 / 3.000
Volume resistivity		IEC 60093	Ω.m	10 ¹³ / 10 ¹⁰
Surface resistivity		IEC 60093	Ω	10 ¹³ / 10 ¹⁰
Comparative tracking index		IEC 60112		600

1) NB: No break.

* dry = dry as moulded / cond.= conditioned according to ISO 1110

CHARACTERISTICS

Promyde B936 L is a lubricated Polyamide 6 grade of high viscosity with improved transparency for extrusion. Its main characteristic is **improved transparency** whilst maintaining excellent polyamide 6 mechanical properties.

APPLICATIONS

Promyde B936 L is appropriate for extrusion applications where improved transparency is desired in applications under 60°C

FORMAT AND STORAGE

Promyde B936 L is supplied in moisture-proof packaging. Typical formats are Big Bags, Octabins, 25kg bags, and bulk silo trucks. All containers are perfectly sealed. The product should be stored in a dry place and opened just before processing.

PROCESSING GUIDELINES

Drying

Material is supplied ready to process with low moisture content. When moisture absorption is prevented drying is not required. When drying is necessary, conditions are:

Drying temperature ≤ 80 °C

Drying time: 4-6 hours

Extrusion Processing

Excellent processing can be obtained by using following temperatures at the extruder:

Feed section: 210-235°C

Compression section: 235-245°C

Metering section: 240-250°C

Melt: 245-250°C

Shrinkage

The shrinkage of product made of Promyde B936 L is influenced by wall thickness and extrusion conditions.

Moisture

A particular characteristic of unreinforced polyamide 6 is its combination of moderate tensile and flexural strength with rigidity, good impact strength, and friction resistance. However, when product absorbs moisture, tensile and flexural strength decrease and toughness increases.

NOTE

All recommendations are based on knowledge and experience; The values have been established on standardized tests. The figures should be regarded as guide values and not as binding minimum values. As many factors may affect processing or applications, we recommend that customers make their own tests to determine the suitability of a product for its particular use.