

Technical Data

Product Description		
(ECONAMID 6FLH)		
Polyamide 6, heat stabilized, for injection moulding		
General		
Material Status	• Commercial: Active	
Literature ¹	<ul style="list-style-type: none"> • Brochure - DOMO ENGINEERING PLASTICS: In Chemicals We Trust. (English) • Brochure - PRODUCTS LIST: DOMAMID & ECONAMID (English) • Technical Datasheet (English) 	
Search for UL Yellow Card	• DOMO Engineering Plastics	
Availability	• Asia Pacific	• Europe • North America
Additive	• Heat Stabilizer	
Features	• Heat Stabilized	
Processing Method	• Injection Molding	
Resin ID (ISO 1043)	• PA6	
Physical	Nominal Value Unit	Test Method
Density	1.14 g/cm ³	ISO 1183
Melt Mass-Flow Rate (MFR) (275°C/0.325 kg)	9.0 g/10 min	ISO 1133
Molding Shrinkage ³		ISO 2577
Across Flow : 23°C, 72 hr	0.90 to 1.1 %	
Flow : 23°C, 72 hr	0.80 to 1.0 %	
Mechanical	Nominal Value Unit	Test Method
Tensile Modulus	2950 MPa	ISO 527-2/1
Tensile Stress (Yield)	65.0 MPa	ISO 527-2/50
Tensile Strain (Yield)	12 %	ISO 527-2/50
Flexural Modulus ⁴	2650 MPa	ISO 178
Flexural Stress ⁴	95.0 MPa	ISO 178
Impact	Nominal Value Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0 kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	ISO 179/1eU
Notched Izod Impact Strength (23°C)	5.5 kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	No Break	ISO 180/1U
Hardness	Nominal Value Unit	Test Method
Rockwell Hardness (R-Scale)	120	ISO 2039-2
Thermal	Nominal Value Unit	Test Method
Heat Deflection Temperature		
0.45 MPa, Unannealed	170 °C	ISO 75-2/B
1.8 MPa, Unannealed	75.0 °C	ISO 75-2/A
Vicat Softening Temperature	205 °C	ISO 306/B50
Melting Temperature	221 °C	ISO 11357-3
Electrical	Nominal Value Unit	Test Method
Surface Resistivity	1.0E+13 ohms	IEC 60093
Volume Resistivity	1.0E+15 ohms·cm	IEC 60093
Flammability	Nominal Value Unit	Test Method
Flame Rating (0.8 mm)	HB	UL 94
Injection	Nominal Value Unit	
Drying Temperature	75 to 85 °C	
Drying Time	2.0 to 4.0 hr	
Processing (Melt) Temp	230 to 260 °C	
Mold Temperature	40 to 80 °C	



Notes

- ¹ These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.
- ² Typical properties: these are not to be construed as specifications.
- ³ 50% RH
- ⁴ 2.0 mm/min

