


**TECHNICAL DATA SHEET [TDS]**
**PA6 Dinalon**
**REFERENCE: B1S25 G15B15 E-0020**
**PRODUCT DESCRIPTION**

PA6 Dinalon, 30% Glass reinforced, Food/ environmental grade, Natural

| PROPERTIES                                | UNITS             | METHOD      | VALUE D.A.M |
|-------------------------------------------|-------------------|-------------|-------------|
| <b>Physical</b>                           |                   |             |             |
| Relative density                          | g/cm <sup>3</sup> | ISO 1183    | 1.36        |
| Humidity                                  | %                 | ISO 15512-B | < 0.25      |
| <b>Mechanical</b>                         |                   |             |             |
| Tensile modulus (1 mm/min)                | MPa               | ISO 527     | 6800        |
| Stress at break (5 mm/min)                | MPa               | ISO 527     | 124         |
| Strain at break (5 mm/min)                | %                 | ISO 527     | 2,9         |
| Flexural modulus (2 mm/min)               | MPa               | ISO 178     | 5900        |
| Flexural strength (2 mm/min)              | MPa               | ISO 178     | 180         |
| Charpy notched impact strength (23°C)     | kJ/m <sup>2</sup> | ISO 179/1eA | 6           |
| Charpy unnotched impact strength (23°C)   | kJ/m <sup>2</sup> | ISO 179/1eU | 40          |
| <b>Thermal</b>                            |                   |             |             |
| Heat deflection temperature HDT (1.80MPa) | °C                | ISO 75-A    | 194         |
| <b>Processing</b>                         |                   |             |             |
| Melt temperature range                    | °C                | -           | 245-275     |
| Recommended mould temperature             | °C                | -           | 60-90       |
| Drying temperature                        | °C                | -           | 80          |
| Drying time                               | h                 | -           | 2 - 4       |

**UPDATE DATE**

nov.-2017

The data submitted here are, to the best of Grupo Repol's knowledge, representative of the range of properties for the listed products, but should not be used to establish process limits or used as the direct basis of design. Colorants or other additives may alter these properties. The data are given for natural grade unless otherwise specified.

