

# Technical Data Sheet



## Piramid® B2 L Natural (PA6 Lubricated Fast Cycle Natural)

### Lubricated Polyamide 6 ,Unreinforced, High Cycle ,Natrual color

#### PRODUCTION PROPERTIES

Piramid® B2 L Natural (PA6 Lubricated Fast Cycle Natural) is n polyamide 6, Unfilled nylon 6 resin , improved injection processing properties. Specially developed for Cable ties.

- lubricated for improved machine feed and mold release performance.
- Optimized with good melt strength for high line speeds in thin wall sections,
- High strength with good toughness
- Rapid crystallization are designed for fast cycling.

#### TYPICAL APPLICATIONS/ END USES

Cable ties , Clips & Fasteners , Connectors , Electrical/Electronic Applications , Fixation systems,Switch , Plug

Test Item	Test Method	Unit	Dry as moulded	conditioned 23° C, 50% r.H.
<b>Physical</b>				
Density	ISO1183	g/cm3		1.14
Melting Point	DSC	°C		220
Water Absorption(24hr,23°C)	ISO62	%		1.1
Molding shrinkage			80*80*3mm t	1.0-1.3
Melt Volume Rate	SO1133	cc/10min	(235°C)2.16kg	105
<b>Mechanical</b>				
Tensile Strength	ISO527	Mpa	10mm/min	70
Tensile strain at break	ISO527	%		54
Flexural Modulus	ISO178	MPa		2850
Flexural Strength	ISO178	MPa	2mm/min	95
Notched Izod Impact	ISO179	KJ/m2	3.5m/s-1J	7
Izod Impact Strength	ISO179	KJ/m2	3.5m/s-5.5J	NB
<b>Electrical</b>				
Surface Resistivity	IEC60093	Ω		1.0E +14
Volume Resistivity	IEC60093	Ω • cm		1.0E +15
Relative Permittivity	IEC60250			
Electric Strength	EC60243-1	kv/mm		
Dissipation Factor	EC60250			0.02
Comparative Tracking Index	IEC60112	v		
<b>Flammability</b>				
Flammability Rating	UL-94			HB
Glow Wire Flammability Index	IEC 60695-2-12	°C		

#### PROCESSING GUIDELINES

##### MATERIAL HANDLING

Polyamides must be properly dried in order to provide parts with optimum strength and toughness. polyamide6grades are hygroscopic and will become degraded by excessive moisture during the injection molding process. Thematerial is supplied in airtight bags,ready for use. In case that the virgin material has absorbed moisture, If dryingbecomes necessary, a dehumidifying or desiccant dryer operating at 80 °C (176 °F) is recommended. Drying time isdependent on moisture level, but 4-6 hours is generally sufficient, but final moisture content must be less than0.2%

##### TEMPERATURE

The recommend melt temperatures are 275 °C to 305 °C. Nylon 66 resin is easy todecompose under too high temperature, and then decrease product properties

**Mold Temperature** :60-80 °C , but temperatures of as low as 45 °C and as high as 105 °C can be usedwhere applicable

**Fill Rate** : Fast fill rates are recommended to ensure uniform melt delivery to the cavity andprevent premature freezing. Surface appearance is directly affected by injection rate

**Injection Pressure** :60-90MPa

Thank you for your Attention!

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