

PA 6 injection molding grade, 30% glass fiber reinforced, impact strength improved at low temperature, black color.

Property	Test Condition	Unit	Standard	Value	Value
Rheological properties				D.A.M.	Moisture Content
Melt volume-flow rate	275 °C;5 kg	cm ³ /(10min)	ISO 1133	55	
Molding shrinkage, parallel	60x60x2mm/MT 80°C	%	ISO 294	0.3	
Molding shrinkage, normal	60x60x2mm/MT 80°C	%	ISO 294	0.7	
Mechanical properties					
Tensile Stress at break	50 mm/min	Mpa	ISO 527-1,-2	120	-
Tensile Strain at break	50 mm/min	%	ISO 527-1,-2	3.0	-
Charpy notched impact strength	23°C	kJ/m ²	ISO 179-1eA	11.0	-
Charpy notched impact strength	-30°C	kJ/m ²	ISO 179-1eA	9.0	-
Izod notched impact strength	23°C	kJ/m	ISO 180-1A	10.5	-
Izod notched impact strength	-30°C	kJ/m	ISO 180-1A	8.5	-
Flexural modulus	5 mm/min	MPa	ISO 178	8300	-
Flexural strength	5 mm/min	Mpa	ISO 178	215	-
Thermal properties					
Melting temperature	10°C/min	°C	ISO 11357-1,-3		220
Temperature of deflection under load	1.80 MPa	°C	ISO 75-1,-2		210
Temperature of deflection under load	0.45 MPa	°C	ISO 75-1,-2		215
Burning behavior UL 94	1.6 mm	Class	UL 94		HB
Other properties (23°C)					
Water absorption (Saturation value)	Water at 23°C/24hr	%	ISO 62		0.9
Water absorption (Equilibrium value)	23°C; 50 % RH	%	ISO 62		-
Density		kg/m ³	ISO 1183		1,34
Glass fiber / glass bead / filler content		%	ISO 3451-1		30
Bulk density		kg/m ³	ISO 60		-
Processing conditions for test specimens					
Injection molding-Melt temperature		°C	ISO 294		260-285
Injection molding-Mold temperature		°C	ISO 294		80 - 120
Drying temperature		°C	-		80
Drying time dry air dryer		h	-		2 - 6
Residual moisture content		%	Karl Fischer		<0.1

Disclaimer

Disclaimer for sales products

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Test values

Unless specified to the contrary, the values given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum values. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mould/die, the processing conditions and the colouring.

Processing note

Under the recommended processing conditions small quantities of decomposition product may be given off during processing. To preclude any risk to the health and well-being of the machine operatives, tolerance limits for the work environment must be ensured by the provision of efficient exhaust ventilation and fresh air at the workplace in accordance with the Safety Data Sheet. In order to prevent the partial decomposition of the polymer and the generation of volatile decomposition products, the prescribed processing temperatures should not be substantially exceeded. Since excessively high temperatures are generally the result of operator error or defects in the heating system, special care and controls are essential in these areas.