

Product Texts

Injection Molding, 25% Glass Reinforced, Flame Retardant, Heat Stabilized

ISO 1043 PA6-GF25 FR(17)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	11000 / 7300	MPa	ISO 527
^[C] Stress at break	150 / 90	MPa	ISO 527
^[C] Strain at break	2.3 / 4.4	%	ISO 527
^[C] Charpy impact strength, +23°C	55 / 55	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	45 / 50	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	10 / 15	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	- / 10	kJ/m ²	ISO 179/1eA
^[C] Puncture - maximum force, +23°C	1000 / -	N	ISO 6603-2
^[C] Puncture - maximum force, -30°C	900 / -	N	ISO 6603-2
^[C] Puncture energy, +23°C	3 / -	J	ISO 6603-2
^[C] Puncture energy, -30°C	1.9 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	205 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	215 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	20 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	90 / *	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
^[C] Burning Behav. 5V at thickness h	5VA / *	class	IEC 60695-11-20
Thickness tested	1.0 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	3.4E12 / -	Ohm*m	IEC 62631-3-1
^[C] Comparative tracking index	400 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	4.3 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.3 / *	%	Sim. to ISO 62
^[C] Density	1600 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Delivery form

Pellets

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Other text information**Injection molding**

PREPROCESSING

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 270 - 290 °C

Mold temperature: 80 - 100 °C