

Product Texts

Injection Molding, 25% Glass Reinforced, Heat Stabilized, Recycled Content

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

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Certifications

Recycled Resin Content

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