

Product Texts

25% glass fibre reinforced PA 6

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.003	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.012	mm/mm	ASTM D 955

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	8500 / 4800	MPa	ISO 527
^[C] Stress at break	152 / 90	MPa	ISO 527
^[C] Strain at break	3.5 / 7.5	%	ISO 527
^[C] Charpy impact strength, +23°C	65 / N	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	55 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	10 / 18	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	7 / -	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	200 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	215 / *	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	210 / *	°C	ISO 306
^[C] Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-
Yellow Card available	yes / *	-	-
^[C] Burning Behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-
Yellow Card available	yes / *	-	-
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Thickness tested	1.5	mm	-
DTUL @ 66 psi	210	°C	ASTM D 648
DTUL @ 264 psi	200	°C	ASTM D 648

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	1E11 / 1E8	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	* / >1E15	Ohm	IEC 62631-3-2
^[C] Comparative tracking index	450 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	1.9 / *	%	Sim. to ISO 62
^[C] Density	1320 / -	kg/m ³	ISO 1183
Density	1320	kg/m ³	ASTM D 792

[C]: CAMPUS

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Viscosity number	145 / *	cm ³ /g	ISO 307, 1157, 1628

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4 - 6	h	-
Melt temperature	250 - 280	°C	-
Mold temperature	60 - 90	°C	-

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Granules

Regional Availability

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

Other text information

Injection molding

PREPROCESSING; **Pretreatment**

Predrying: 4-6h / 80°C

PROCESSING ;**Processing:**

Melttemperature	250 - 280	°C
Mouldtemperature	60 - 90	°C