

Product Texts

Injection Molding, 30% Glass Reinforced, Heat Stabilized, Recycled Content, Improved flow

ISO 1043 PA6-GF30

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	75 / *	cm ³ /10min	ISO 1133
Temperature	270 / *	°C	-
Load	5 / *	kg	-
^[C] Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	9400 / 5500	MPa	ISO 527
^[C] Stress at break	170 / 100	MPa	ISO 527
^[C] Strain at break	3 / 5.8	%	ISO 527
^[C] Charpy impact strength, +23°C	70 / 80	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	55 / 55	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	11 / 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	800 / 1050	N	ISO 6603-2
^[C] Puncture - maximum force, -30°C	700 / 750	N	ISO 6603-2
^[C] Puncture energy, +23°C	2 / 4.6	J	ISO 6603-2
^[C] Puncture energy, -30°C	2 / 2	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	221 / *	°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	219 / *	°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	100 / *	E-6/K	ISO 11359-1/-2
^[C] Burning rate, FMVSS, Thickness 1 mm	61.7	mm/min	ISO 3795 (FMVSS 302)

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Electric strength	33 / 25	kV/mm	IEC 60243-1
^[C] Comparative tracking index	400 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	7 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2.1 / *	%	Sim. to ISO 62
^[C] Density	1350 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	270	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

[C]: CAMPUS

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

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): 250 - 290 °C

Mold temperature: 80 - 120 °C