

**ECONAMID FL 6G30**

PA6-GF30

DOMO Engineering Plastics

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Molding shrinkage, parallel	<b>0.3 / *</b>	%	ISO 294-4, 2577
Molding shrinkage, normal	<b>0.8 / *</b>	%	ISO 294-4, 2577
<b>Mechanical properties</b>			
<b>ISO Data</b>			
Tensile Modulus	<b>9000 / 5700</b>	MPa	ISO 527
Stress at break	<b>140 / 90</b>	MPa	ISO 527
Strain at break	<b>3 / 6</b>	%	ISO 527
Flexural modulus, 23°C	<b>7500 / 4400</b>	MPa	ISO 178
Charpy impact strength, +23°C	<b>40 / 55</b>	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy notched impact strength, +23°C	<b>6 / 10</b>	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	<b>35 / 50</b>	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	<b>5.5 / 10</b>	kJ/m <sup>2</sup>	ISO 180/1A
Rockwell hardness	<b>R 122</b>	-	ISO 2039-2
<b>Thermal properties</b>			
<b>ISO Data</b>			
Melting temperature, 10°C/min	<b>221 / *</b>	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	<b>200 / *</b>	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	<b>215 / *</b>	°C	ISO 75-1/-2
Vicat softening temperature, B	<b>210 / *</b>	°C	ISO 306
Burning behav. at thickness h	<b>HB / *</b>	class	IEC 60695-11-10
Thickness tested	<b>0.8 / *</b>	mm	-
<b>Electrical properties</b>			
<b>ISO Data</b>			
Volume resistivity	<b>1E13 / -</b>	Ohm*m	IEC 62631-3-1
Surface resistivity	<b>* / 1E13</b>	Ohm	IEC 62631-3-2
<b>Other properties</b>			
Density	<b>1360 / -</b>	kg/m <sup>3</sup>	ISO 1183
<b>Material specific properties</b>			
<b>ISO Data</b>			
Viscosity number	<b>135 / *</b>	cm <sup>3</sup> /g	ISO 307, 1157, 1628
<b>Processing Recommendation Injection Molding</b>			
Pre-drying - Temperature	<b>75 - 85</b>	°C	-
Pre-drying - Time	<b>2 - 4</b>	h	-
Melt temperature	<b>240 - 270</b>	°C	-
Mold temperature	<b>90 - 100</b>	°C	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America, Europe, Asia Pacific