

ECONAMID ORO 6G30

PA6-GF30

DOMO Engineering Plastics

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8	%	ISO 294-4, 2577

Mechanical properties	Value	Unit	Test Standard
ISO Data			
Tensile Modulus	9500	MPa	ISO 527
Stress at break	180	MPa	ISO 527
Strain at break	3.5	%	ISO 527
Flexural modulus, 23°C	8600	MPa	ISO 178
Charpy impact strength, +23°C	95	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	15	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	85	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	15	kJ/m ²	ISO 180/1A

Thermal properties	Value	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	221	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	200	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	220	°C	ISO 75-1/-2
Vicat softening temperature, B	215	°C	ISO 306
Burning behav. at thickness h	HB	class	IEC 60695-11-10
Thickness tested	0.8	mm	-

Electrical properties	Value	Unit	Test Standard
ISO Data			
Volume resistivity	1E13	Ohm*m	IEC 62631-3-1
Surface resistivity	1E13	Ohm	IEC 62631-3-2

Other properties	Value	Unit	Test Standard
Density	1360	kg/m ³	ISO 1183

Material specific properties	Value	Unit	Test Standard
ISO Data			
Viscosity number	180	cm ³ /g	ISO 307, 1157, 1628

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	75 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	250 - 280	°C	-
Mold temperature	90 - 100	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific