

Product Texts

Injection Molding, 35% Glass Reinforced, Heat Stabilized

ISO 1043 PA6-GF35

| Mechanical properties | dry / cond | Unit | Test Standard |
|--|--------------|-------------------|---------------|
| ISO Data | | | |
| ^[C] Tensile Modulus | 11000 / 6800 | MPa | ISO 527 |
| ^[C] Stress at break | 190 / 120 | MPa | ISO 527 |
| ^[C] Strain at break | 3 / 5 | % | ISO 527 |
| ^[C] Charpy impact strength, +23°C | 85 / 95 | kJ/m ² | ISO 179/1eU |
| ^[C] Charpy impact strength, -30°C | 75 / 75 | kJ/m ² | ISO 179/1eU |
| ^[C] Charpy notched impact strength, +23°C | 15 / 22 | kJ/m ² | ISO 179/1eA |
| ^[C] Charpy notched impact strength, -30°C | 10 / 10 | kJ/m ² | ISO 179/1eA |

[C]: CAMPUS

| Thermal properties | dry / cond | Unit | Test Standard |
|--|------------|-------|----------------|
| ISO Data | | | |
| ^[C] Melting temperature, 10°C/min | 220 / * | °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 | 80 / * | E-6/K | ISO 11359-1/-2 |

[C]: CAMPUS

| Other properties | dry / cond | Unit | Test Standard |
|------------------------------------|------------|-------------------|----------------|
| ^[C] Water absorption | 6.5 / * | % | Sim. to ISO 62 |
| ^[C] Humidity absorption | 1.9 / * | % | Sim. to ISO 62 |
| ^[C] Density | 1410 / - | 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

| Processing Recommendation Injection Molding | Value | Unit | Test Standard |
|---|-----------|------|---------------|
| Pre-drying - Temperature | 80 | °C | - |
| Pre-drying - Time | 2 - 6 | h | - |
| Processing humidity | ≤0.12 | % | - |
| Melt temperature | 270 - 290 | °C | - |
| Mold temperature | 80 - 120 | °C | - |

Characteristics**Processing**

Injection Molding

Special Characteristics

Heat stabilized or stable to heat

Delivery form

Pellets

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 - 120 °C