ECONAMID FL 6G35H1

PA6-GF35 DOMO Engineering Plastics

Processing/Physical Characteristics	dry / cond	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	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	**10000 / 6900**	MPa	ISO 527
Stress at break	**145 / 95**	MPa	ISO 527
Strain at break	**2.5 / 5.5**	%	ISO 527
Flexural modulus, 23°C	**8500 / 5500**	MPa	ISO 178
Charpy impact strength, +23°C	**45 / 60**	kJ/m²	ISO 179/1eU
Charpy notched impact strength, +23°C	**6.5 / 11**	kJ/m²	ISO 179/1eA
Izod impact strength, +23°C	**40 / 55**	kJ/m²	ISO 180/1U
Izod notched impact strength, +23°C	**6.5 / 10.5**	kJ/m²	ISO 180/1A
Rockwell hardness	**R 122**	-	ISO 2039-2

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	**221 / ***	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	**205 / ***	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	**215 / ***	°C	ISO 75-1/-2
Vicat softening temperature, B	**210 / ***	°C	ISO 306
Burning behav. at thickness h	**HB / ***	class	IEC 60695-11-10
Thickness tested	**0.8 / ***	mm	-

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

Other properties	dry / cond	Unit	Test Standard
Density	**1410 / -**	kg/m³	ISO 1183

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
Viscosity number	**135 / ***	cm³/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	**240 - 270**	°C	-
Mold temperature	**90 - 100**	°C	-

Characteristics

Processing
Injection Molding

Regional Availability
North America, Europe, Asia Pacific

Special Characteristics
Heat stabilized or stable to heat