

Product Texts

Injection Molding, 40% Glass Reinforced, Heat Stabilized

ISO 1043 PA6-GF40

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	12300 / 7800	MPa	ISO 527
^[C] Stress at break	205 / 130	MPa	ISO 527
^[C] Strain at break	3 / 5	%	ISO 527
^[C] Charpy impact strength, +23°C	90 / 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	18 / 24	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	13 / 11	kJ/m ²	ISO 179/1eA
^[C] Puncture energy, +23°C	9 / -	J	ISO 6603-2
^[C] Puncture energy, -30°C	6 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	200 / *	°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] Burning Behav. at 1.5 mm nom. thickn. Thickness tested	HB / *	class	IEC 60695-11-10
^[C] Oxygen index	1.5 / *	mm	-
^[C] Oxygen index	24 / *	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Relative permittivity, 100Hz	4 / 15	-	IEC 62631-2-1
^[C] Relative permittivity, 1MHz	4 / 5	-	IEC 62631-2-1
^[C] Dissipation factor, 100Hz	70 / 2000	E-4	IEC 62631-2-1
^[C] Dissipation factor, 1MHz	150 / 1200	E-4	IEC 62631-2-1
^[C] Volume resistivity	1E13 / 1E10	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	* / 1E12	Ohm	IEC 62631-3-2
^[C] Electric strength	40 / 35	kV/mm	IEC 60243-1
^[C] Comparative tracking index	525 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	6 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1460 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Viscosity number	140 / *	cm ³ /g	ISO 307, 1157, 1628

[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