

Product Texts

PA 6-Copolymer, 40 % glass fibres, injection moulding, impact modified, heat-ageing stabilized

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577
Density of melt	1200	kg/m ³	-
Thermal conductivity of melt	0.225	W/(m K)	-
Spec. heat capacity of melt	2020	J/(kg K)	-
Eff. thermal diffusivity	1.03E-7	m ² /s	-
Ejection temperature	140	°C	-

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	10500 / 5700	MPa	ISO 527
Stress at break	150 / 90	MPa	ISO 527
Strain at break	4 / 7.5	%	ISO 527
Charpy impact strength, +23°C	80 / 85	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	90 / 90	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	25 / 35	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	15 / 15	kJ/m ²	ISO 179/1eA
Puncture - maximum force, +23°C	1250 / -	N	ISO 6603-2
Puncture - maximum force, -30°C	1070 / -	N	ISO 6603-2
Puncture energy, +23°C	8 / -	J	ISO 6603-2
Puncture energy, -30°C	4.7 / -	J	ISO 6603-2

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	210 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	195 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Comparative tracking index	600 / -	-	IEC 60112

Other properties	dry / cond	Unit	Test Standard
Density	1410 / -	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	290	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Other text information

Injection Molding

PREPROCESSING

Max. Water content: 0.1 %

Drying temperature: 80 °C

Drying time:

Dry air dryer 2-20 h (will depend on the initial moisture content)

PROCESSING

Melt temperature: 270 - 290 °C

Mold temperature: 80 - 120 °C