

DOMAMID HCE 6G50

PA6-GF50

DOMO Engineering Plastics

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.4 / *	%	ISO 294-4, 2577
Mechanical properties			
ISO Data			
Tensile Modulus	17000 / 12500	MPa	ISO 527
Stress at break	240 / 170	MPa	ISO 527
Strain at break	2.5 / 3.5	%	ISO 527
Flexural modulus, 23°C	15500 / 10000	MPa	ISO 178
Charpy impact strength, +23°C	100 / 105	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	21 / 25	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	95 / 100	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	20 / 25	kJ/m ²	ISO 180/1A
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	210 / *	°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			
ISO Data			
Volume resistivity	1E13 / -	Ohm*m	IEC 62631-3-1
Surface resistivity	* / 1E13	Ohm	IEC 62631-3-2
Other properties			
Density	1560 / -	kg/m ³	ISO 1183
Material specific properties			
ISO Data			
Viscosity number	145 / *	cm ³ /g	ISO 307, 1157, 1628
Processing Recommendation Injection Molding			
Pre-drying - Temperature	75 - 85	°C	-
Pre-drying - Time	2 - 4	h	-
Melt temperature	260 - 280	°C	-
Mold temperature	90 - 100	°C	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific