

Product Texts

Injection Molding, 60% Glass Reinforced, Heat Stabilized, Improved flow

ISO 1043 PA6-GF60

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.5 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	20200 / 13000	MPa	ISO 527
^[C] Stress at break	215 / 140	MPa	ISO 527
^[C] Strain at break	2.3 / 2.8	%	ISO 527
Flexural modulus, 23°C	18500 / 14000	MPa	ISO 178
^[C] Charpy impact strength, +23°C	88 / -	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	15 / -	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	80 / 75	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	15 / -	kJ/m ²	ISO 180/1A
^[C] Puncture - maximum force, +23°C	1100 / -	N	ISO 6603-2
^[C] Puncture - maximum force, -30°C	950 / -	N	ISO 6603-2
^[C] Puncture energy, +23°C	4.2 / -	J	ISO 6603-2
^[C] Puncture energy, -30°C	3.4 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	208 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	217 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	11 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	85 / *	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Density	1690 / -	kg/m ³	ISO 1183
Bulk density	760	kg/m ³	-

[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	≤0.15	%	-
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 AvailabilityNorth America, Europe, Asia Pacific, South and Central America,
Near East/Africa**Other text information****Injection molding**

PREPROCESSING

Residual moisture content: 0.05 - 0.15%

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