

**Product Texts**

Blow Molding Grade, 25% Glass Reinforced, Heat Stabilized, Improved Impact, Recycled Content

ISO 1043 PA6-I-GF25

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.7 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	8000 / 4000	MPa	ISO 527
<sup>[C]</sup> Stress at break	130 / 70	MPa	ISO 527
<sup>[C]</sup> Strain at break	3.2 / 8.5	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	75 / 95	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	85 / -	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	15 / 30	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	10 / -	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Puncture - maximum force, +23°C	1100 / -	N	ISO 6603-2
<sup>[C]</sup> Puncture - maximum force, -30°C	800 / -	N	ISO 6603-2
<sup>[C]</sup> Puncture energy, +23°C	5.8 / -	J	ISO 6603-2
<sup>[C]</sup> Puncture energy, -30°C	3.2 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	219 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	190 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	30 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	130 / *	E-6/K	ISO 11359-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Density	1280 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

**Characteristics****Processing**

Blow Molding

**Delivery form**

Pellets

**Special Characteristics**

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

**Certifications**

Contains renewable resources, Recycled Resin Content

**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