

Product Texts

Injection Molding, 30% Glass Reinforced, Improved flow, Improved Impact

ISO 1043 PA6-I-GF30

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	9000 / -	MPa	ISO 527
Stress at break	150 / -	MPa	ISO 527
Strain at break	4 / -	%	ISO 527
Flexural modulus, 23°C	8300 / -	MPa	ISO 178
Flexural strength	235 / -	MPa	ISO 178
^[C] Charpy impact strength, +23°C	90 / 90	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	85 / 85	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	12 / 20	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	10 / 10	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	75 / 85	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	13 / 20	kJ/m ²	ISO 180/1A
Izod notched impact strength	10 / 10	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Temp. of deflection under load, 1.80 MPa	206 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	150 / *	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
Water absorption	2.13 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2.13 / *	%	Sim. to ISO 62
^[C] Density	1340 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	270	°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	260 - 280	°C	-
Mold temperature	80 - 100	°C	-

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

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): 260 - 280 °C

Mold temperature: 80 - 100 °C