

Product Texts

25% Mineral Reinforced, Heat Stabilized, Flame Retardant (halogen free)

ISO 1043 PA6-MD25 FR(30)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melt volume-flow rate, MVR	20 / *	cm ³ /10min	ISO 1133
Temperature	250 / *	°C	-
Load	2.16 / *	kg	-
^[C] Molding shrinkage, parallel	0.9 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577
^[C] Density of melt	1170	kg/m ³	-
^[C] Thermal conductivity of melt	0.201	W/(m K)	-
^[C] Spec. heat capacity of melt	2250	J/(kg K)	-
^[C] Eff. thermal diffusivity	7.63E-8	m ² /s	-

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	6500 / 2700	MPa	ISO 527
^[C] Stress at break	70 / 38	MPa	ISO 527
^[C] Strain at break	2.5 / 30	%	ISO 527
^[C] Charpy impact strength, +23°C	29 / 100	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	35 / 35	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	2 / 4	kJ/m ²	ISO 179/1eA
^[C] Charpy notched impact strength, -30°C	2 / 2	kJ/m ²	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	110 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	205 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	50 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	50 / *	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-
Yellow Card available	yes / *	-	-
^[C] Burning Behav. at thickness h	V-2 / *	class	IEC 60695-11-10
Thickness tested	3.0 / *	mm	-
Yellow Card available	yes / *	-	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
^[C] Surface resistivity	* / >1E15	Ohm	IEC 62631-3-2
^[C] Comparative tracking index	* / 600	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	6.2 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1380 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Delivery form

Pellets

Additives

Release agent

Special Characteristics

Flame retardant, Halogen-free, Heat stabilized or stable to heat

Regional Availability

North America, Europe, Asia Pacific

Other text information

Injection molding

[Injection Molding Recommendations](#)

[Steel recommendations for molds screws and barrels](#)

[Trouble shooting guideline for injection molding](#)