

Product Texts

PA6/ABS blend, 8% glass fibre injection moulding grade. Natural colour.

Suitable for parts requiring improved stiffness and low moisture absorption. Excellent aesthetic surface aspect.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.4 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	4100 / 2600	MPa	ISO 527
^[C] Yield stress	87 / 53	MPa	ISO 527
^[C] Yield strain	4 / 6.5	%	ISO 527
^[C] Nominal strain at break	6.5 / 25	%	ISO 527
^[C] Charpy impact strength, +23°C	55 / 85	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	7.5 / -	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	108 / *	°C	ISO 75-1/-2
^[C] Vicat softening temperature, B	165 / *	°C	ISO 306

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	5.7 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1150 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Characteristics

Processing

Injection Molding

Special Characteristics

Platable

Delivery form

Granules, Natural Color

Regional Availability

North America, Europe, Asia Pacific, South and Central America, Near East/Africa

Additives

Release agent

Other text information

Injection molding

The material is delivered in moisture-proof packaging ready for processing. Maximum recommended water content for best processing is 0.15%. Typical conditions with a desiccant drier: temperature 80 °C, dew point -20 °C or below, time 2-4 h or more. Special care must be taken to avoid moisture absorption and contamination with other polymers when adding regrind material. Colour variation and mechanical properties reduction may occur and should always be carefully monitored.

Injection Molding Processing Parameters

Melt Temperature	Mold Temperature	Injection Speed
240 - 260°C	40 - 60°C	medium