

**Product Texts**

PA6 15% glass fibre reinforced injection moulding grade. Heat stabilized. Black colour.

Suitable for parts requiring improved stiffness and excellent heat ageing resistance.

| Processing/Physical Characteristics        | dry / cond | Unit | Test Standard   |
|--|------------|------|-----------------|
| <b>ISO Data</b>                            |            |      |                 |
| <sup>[C]</sup> Molding shrinkage, parallel | 0.4 / *    | %    | ISO 294-4, 2577 |
| <sup>[C]</sup> Molding shrinkage, normal   | 1.1 / *    | %    | ISO 294-4, 2577 |

[C]: CAMPUS

| Mechanical properties                                | dry / cond  | Unit              | Test Standard |
|--|-------------|-------------------|---------------|
| <b>ISO Data</b>                                      |             |                   |               |
| <sup>[C]</sup> Tensile Modulus                       | 5700 / 3200 | MPa               | ISO 527       |
| <sup>[C]</sup> Stress at break                       | 125 / 75    | MPa               | ISO 527       |
| <sup>[C]</sup> Strain at break                       | 3.9 / 10    | %                 | ISO 527       |
| <sup>[C]</sup> Charpy impact strength, +23°C         | 48 / -      | kJ/m <sup>2</sup> | ISO 179/1eU   |
| <sup>[C]</sup> Charpy notched impact strength, +23°C | 6.5 / -     | kJ/m <sup>2</sup> | ISO 179/1eA   |

[C]: CAMPUS

| Thermal properties                                      | dry / cond | Unit  | Test Standard   |
|---|------------|-------|-----------------|
| <b>ISO Data</b>   |            |       |                 |
| <sup>[C]</sup> Melting temperature, 10°C/min            | 220 / *    | °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> Vicat softening temperature, B           | 205 / *    | °C    | ISO 306         |
| <sup>[C]</sup> Burning Behav. at thickness h            | HB / *     | class | IEC 60695-11-10 |
| Thickness tested  | 0.8 / *    | mm    | -               |

[C]: CAMPUS

| Electrical properties              | dry / cond  | Unit  | Test Standard |
|------------------------------------|-------------|-------|---------------|
| <b>ISO Data</b>                    |             |       |               |
| <sup>[C]</sup> Volume resistivity  | 1E13 / 1E11 | Ohm*m | IEC 62631-3-1 |
| <sup>[C]</sup> Surface resistivity | * / 1E10    | Ohm   | IEC 62631-3-2 |

[C]: CAMPUS

| Other properties                   | dry / cond | Unit              | Test Standard  |
|------------------------------------|------------|-------------------|----------------|
| <sup>[C]</sup> Water absorption    | 8.5 / *    | %                 | Sim. to ISO 62 |
| <sup>[C]</sup> Humidity absorption | 2.5 / *    | %                 | Sim. to ISO 62 |
| <sup>[C]</sup> Density             | 1230 / -   | kg/m <sup>3</sup> | ISO 1183       |

[C]: CAMPUS

**Characteristics**

**Processing**

Injection Molding

**Delivery form**

Granules, Black

**Additives**

Release agent

**Special Characteristics**

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**

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  
240 - 280°C

Mold Temperature  
80 - 90°C

Injection Speed  
medium-high