

**Product Texts**

PA 6, 30 % glass fibres, injection moulding, flame retardant

<b>Processing/Physical Characteristics</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melt volume-flow rate, MVR	33 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	260 / *	°C	-
Load	5 / *	kg	-
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

<b>Mechanical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Tensile Modulus	11000 / 7000	MPa	ISO 527
Stress at break	140 / 80	MPa	ISO 527
Strain at break	2.5 / 3.4	%	ISO 527
Charpy impact strength, +23°C	55 / 55	kJ/m <sup>2</sup>	ISO 179/1eU
Charpy impact strength, -30°C	45 / -	kJ/m <sup>2</sup>	ISO 179/1eU

<b>Thermal properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	203 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	218 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Burning behav. at thickness h	V-0 / *	class	IEC 60695-11-10
Thickness tested	0.8 / *	mm	-

<b>Electrical properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Electric strength	34.5 / -	kV/mm	IEC 60243-1
Comparative tracking index	400 / -	-	IEC 60112

<b>Other properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
Humidity absorption	1.3 / *	%	Sim. to ISO 62
Density	1670 / -	kg/m <sup>3</sup>	ISO 1183

<b>Material specific properties</b>	<b>dry / cond</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Viscosity number	134 / *	cm <sup>3</sup> /g	ISO 307, 1157, 1628

<b>Test specimen production</b>	<b>Value</b>	<b>Unit</b>	<b>Test Standard</b>
<b>ISO Data</b>			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

**Characteristics****Processing**

Injection Molding

**Delivery form**

Pellets

**Special Characteristics**

Flame retardant, Light stabilized or stable to light

**Regional Availability**

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

**Additives**

Lubricants, Release agent, Plasticizer

**Other text information****Injection Molding**

## PREPROCESSING

Max. Water content: 0.1 %

Drying temperature: 80 °C

Drying time:

Dry air dryer 2-20 h (will depend on the initial moisture content)

## PROCESSING

Melt temperature: 240 - 260 °C

Mold temperature: 80 - 100 °C