

Product Texts

PA 6, injection molding grade, 35 % glass fibers, very good heat-ageing resistance

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577
Density of melt	1200	kg/m ³	-
Thermal conductivity of melt	0.236	W/(m K)	-
Spec. heat capacity of melt	2050	J/(kg K)	-
Eff. thermal diffusivity	9.61E-8	m ² /s	-
Ejection temperature	140	°C	-

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
Tensile Modulus	11500 / 6300	MPa	ISO 527
Stress at break	190 / 85	MPa	ISO 527
Strain at break	3 / 8	%	ISO 527
Charpy impact strength, +23°C	75 / 85	kJ/m ²	ISO 179/1eU
Charpy impact strength, -30°C	65 / 55	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, +23°C	15 / 20	kJ/m ²	ISO 179/1eA
Charpy notched impact strength, -30°C	10 / -	kJ/m ²	ISO 179/1eA
Puncture energy, +23°C	9 / 13	J	ISO 6603-2
Puncture energy, -30°C	7 / 5	J	ISO 6603-2

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
Temp. of deflection under load, 1.80 MPa	205 / *	°C	ISO 75-1/-2
Temp. of deflection under load, 0.45 MPa	215 / *	°C	ISO 75-1/-2
Burning behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.6 / *	mm	-
Burning behav. at thickness h	HB / *	class	IEC 60695-11-10
Thickness tested	3.2 / *	mm	-
Oxygen index	23 / *	%	ISO 4589-1/-2

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
Relative permittivity, 100Hz	5 / -	-	IEC 62631-2-1
Relative permittivity, 1MHz	4 / -	-	IEC 62631-2-1
Dissipation factor, 100Hz	450 / -	E-4	IEC 62631-2-1
Dissipation factor, 1MHz	265 / -	E-4	IEC 62631-2-1
Volume resistivity	7E12 / -	Ohm*m	IEC 62631-3-1
Comparative tracking index	425 / -	-	IEC 60112

Other properties	dry / cond	Unit	Test Standard
Water absorption	6.5 / *	%	Sim. to ISO 62
Humidity absorption	1.9 / *	%	Sim. to ISO 62
Density	1410 / -	kg/m ³	ISO 1183

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

Characteristics

Processing

Injection Molding

Additives

Release agent

Delivery form

Pellets

Regional AvailabilityNorth America, Europe, Asia Pacific, South and Central America,
Near East/Africa**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: 270 - 290 °C

Mold temperature: 80 - 120 °C