

Product Texts

Injection Molding, 35% Glass Reinforced, Heat Stabilized, Recycled Content

ISO 1043 PA6-GF35

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^(C) Molding shrinkage, parallel	0.2 / *	%	ISO 294-4, 2577
^(C) Molding shrinkage, normal	0.7 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^(C) Tensile Modulus	11000 / 6500	MPa	ISO 527
^(C) Stress at break	185 / 110	MPa	ISO 527
^(C) Strain at break	3.3 / 6.5	%	ISO 527
Flexural modulus, 23°C	10500 / 6200	MPa	ISO 178
Flexural strength	290 / 180	MPa	ISO 178
^(C) Tensile creep modulus, 1h	* / 6000	MPa	ISO 899-1
^(C) Tensile creep modulus, 1000h	* / 4900	MPa	ISO 899-1
^(C) Charpy impact strength, +23°C	90 / 100	kJ/m ²	ISO 179/1eU
^(C) Charpy impact strength, -30°C	75 / 70	kJ/m ²	ISO 179/1eU
^(C) Charpy notched impact strength, +23°C	12 / 20	kJ/m ²	ISO 179/1eA
^(C) Charpy notched impact strength, -30°C	- / 10	kJ/m ²	ISO 179/1eA
Izod impact strength, +23°C	80 / 90	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	15 / 20	kJ/m ²	ISO 180/1A
Izod notched impact strength	10 / 10	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
^(C) Puncture - maximum force, +23°C	1060 / -	N	ISO 6603-2
^(C) Puncture - maximum force, -30°C	945 / -	N	ISO 6603-2
^(C) Puncture energy, +23°C	3.9 / -	J	ISO 6603-2
^(C) Puncture energy, -30°C	3.3 / -	J	ISO 6603-2
Ball indentation hardness	230 / 120	MPa	ISO 2039-1

[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	205 / *	°C	ISO 75-1/-2
^(C) Temp. of deflection under load, 0.45 MPa	215 / *	°C	ISO 75-1/-2
Vicat softening temperature, B	200 / *	°C	ISO 306
^(C) Coeff. of linear therm. expansion, parallel	20 / *	E-6/K	ISO 11359-1/-2
^(C) Coeff. of linear therm. expansion, normal	95 / *	E-6/K	ISO 11359-1/-2
^(C) Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-
^(C) Oxygen index	23 / *	%	ISO 4589-1/-2
Glow Wire Flammability Index (GWFI)	650	°C	IEC 60695-2-12
GWFI - thickness tested (1)	2	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^(C) Comparative tracking index	475 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^(C) Water absorption	6.5 / *	%	Sim. to ISO 62
^(C) Humidity absorption	1.9 / *	%	Sim. to ISO 62

Durethan® ECOBKV35H2.0 901510

PA6-GF35

Envalior

[C] Density	1410 / -	kg/m ³	ISO 1183
Bulk density	700	kg/m ³	-

[C]: CAMPUS

Material specific properties	dry / cond	Unit	Test Standard
ISO Data			
[C] Viscosity number	140 / *	cm ³ /g	ISO 307, 1157, 1628

[C]: CAMPUS

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

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	2 - 6	h	-
Processing humidity	≤0.12	%	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 120	°C	-

Characteristics**Processing**

Injection Molding

Features

Thermal Stability

Delivery form

Pellets

Certifications

Recycled Resin Content, ISCC Plus

Additives

Release agent

Regional Availability

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

Special Characteristics

Heat stabilized or stable to heat

Other text information**Injection molding****PREPROCESSING**

Residual moisture content: 0.03 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 270 - 290 °C

Mold temperature: 80 - 120 °C