

Product Texts

Injection Molding, 25% Glass Reinforced, Flame Retardant (halogen free), Heat Stabilized

ISO 1043 PA6-GX25 FR(30)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.6 / *	%	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	5600 / 2300	MPa	ISO 527
^[C] Stress at break	85 / 40	MPa	ISO 527
^[C] Strain at break	3.2 / 25	%	ISO 527
Flexural modulus, 23°C	5100 / 2300	MPa	ISO 178
^[C] Charpy impact strength, +23°C	30 / 70	kJ/m ²	ISO 179/1eU
^[C] Charpy notched impact strength, +23°C	- / 10	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	25 / 60	kJ/m ²	ISO 180/1U
Izod notched impact strength, +23°C	10 / 10	kJ/m ²	ISO 180/1A
Izod notched impact strength	10 / 10	kJ/m ²	ISO 180/1A
Temperature	-30	°C	-
Ball indentation hardness	180 / -	MPa	ISO 2039-1

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Melting temperature, 10°C/min	222 / *	°C	ISO 11357-1/-3
^[C] Temp. of deflection under load, 1.80 MPa	170 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	50 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	90 / *	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-2 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-
^[C] Oxygen index	27 / *	%	ISO 4589-1/-2

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Volume resistivity	>1E13 / -	Ohm*m	IEC 62631-3-1
^[C] Electric strength	30 / -	kV/mm	IEC 60243-1
^[C] Comparative tracking index	550 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	7 / *	%	Sim. to ISO 62
^[C] Humidity absorption	2.1 / *	%	Sim. to ISO 62
^[C] Density	1340 / -	kg/m ³	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
ISO Data			
^[C] Injection Molding, melt temperature	260	°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	≤0.07	%	-
Melt temperature	250 - 270	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Special Characteristics

Flame retardant, Halogen-free, Heat stabilized or stable to heat

Delivery form

Pellets

Regional Availability

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

Other text information**Injection molding**

PREPROCESSING

Residual moisture content: 0.03 - 0.07%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

PROCESSING

Melt temperature (Tmin - Tmax): 250 - 270 °C

Mold temperature: 80 - 100 °C