

Product Texts

Injection Molding, 30% Glass Beads Reinforced, Flame Retardant (halogen free), Heat Stabilized, Low Warpage

ISO 1043 PA6-GX30 FR(40+30)

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
ISO Data			
^[C] Molding shrinkage, parallel	0.8 / *	%	ISO 294-4, 2577
^[C] Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Tensile Modulus	5400 / 2100	MPa	ISO 527
^[C] Stress at break	75 / -	MPa	ISO 527
^[C] Strain at break	2.2 / -	%	ISO 527
^[C] Charpy impact strength, +23°C	40 / 60	kJ/m ²	ISO 179/1eU
^[C] Charpy impact strength, -30°C	38 / 25	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

[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	100 / *	°C	ISO 75-1/-2
^[C] Temp. of deflection under load, 0.45 MPa	195 / *	°C	ISO 75-1/-2
^[C] Coeff. of linear therm. expansion, parallel	60 / *	E-6/K	ISO 11359-1/-2
^[C] Coeff. of linear therm. expansion, normal	70 / *	E-6/K	ISO 11359-1/-2
^[C] Burning Behav. at 1.5 mm nom. thickn.	V-0 / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
ISO Data			
^[C] Comparative tracking index	550 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
^[C] Water absorption	6 / *	%	Sim. to ISO 62
^[C] Humidity absorption	1.8 / *	%	Sim. to ISO 62
^[C] Density	1410 / -	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	240 - 260	°C	-
Mold temperature	80 - 100	°C	-

Characteristics**Processing**

Injection Molding

Delivery form

Pellets

Special Characteristics

Flame retardant, Heat stabilized or stable to heat

Features

Low Warpage

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): 240 - 260 °C

admissible residence time at Tmax <5 min

Mold temperature: 80 - 100 °C