

**Product Texts**

Blow Molding Grade, 15% Glass Reinforced, Extrusion, Heat Stabilized, Improved Impact

ISO 1043 PA6-I-GF15

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.9 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.6 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	5300 / 2500	MPa	ISO 527
<sup>[C]</sup> Stress at break	105 / 55	MPa	ISO 527
<sup>[C]</sup> Strain at break	5 / 19	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	80 / 105	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	85 / 90	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	15 / 30	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	- / 10	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Puncture - maximum force, +23°C	1200 / -	N	ISO 6603-2
<sup>[C]</sup> Puncture - maximum force, -30°C	630 / -	N	ISO 6603-2
<sup>[C]</sup> Puncture energy, +23°C	4.9 / -	J	ISO 6603-2
<sup>[C]</sup> Puncture energy, -30°C	2.5 / -	J	ISO 6603-2

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	221 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	175 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	210 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, parallel	40 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Coeff. of linear therm. expansion, normal	130 / *	E-6/K	ISO 11359-1/-2
<sup>[C]</sup> Burning Behav. at 1.5 mm nom. thickn.	HB / *	class	IEC 60695-11-10
Thickness tested	1.5 / *	mm	-

[C]: CAMPUS

Electrical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Comparative tracking index	375 / -	-	IEC 60112

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Density	1200 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Test specimen production	Value	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> 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	≤0.06	%	-
Melt temperature	270 - 290	°C	-

Mold temperature

**80 - 120**

°C

-

**Characteristics****Processing**

Profile Extrusion, Sheet Extrusion, Other Extrusion, Blow Molding

**Special Characteristics**

High impact or impact modified, 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: 0.00 - 0.06%

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