

**Product Texts**

Injection Molding, 30% Glass Reinforced, Improved Impact

ISO 1043 PA6-I-GF30

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Molding shrinkage, parallel	0.3 / *	%	ISO 294-4, 2577
<sup>[C]</sup> Molding shrinkage, normal	0.8 / *	%	ISO 294-4, 2577

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	8500 / 4200	MPa	ISO 527
<sup>[C]</sup> Stress at break	130 / 80	MPa	ISO 527
<sup>[C]</sup> Strain at break	4.1 / 8.6	%	ISO 527
Flexural modulus, 23°C	7400 / 4200	MPa	ISO 178
<sup>[C]</sup> Charpy impact strength, +23°C	85 / 100	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	95 / 90	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	20 / 37	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	13 / 13	kJ/m <sup>2</sup>	ISO 179/1eA
Izod impact strength, +23°C	75 / 95	kJ/m <sup>2</sup>	ISO 180/1U
Izod notched impact strength, +23°C	20 / 35	kJ/m <sup>2</sup>	ISO 180/1A
Izod notched impact strength	15 / 15	kJ/m <sup>2</sup>	ISO 180/1A
Temperature	-30	°C	-

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	220 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	198 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	218 / *	°C	ISO 75-1/-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

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Density	1320 / -	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	≤0.12	%	-
Melt temperature	260 - 290	°C	-
Mold temperature	80 - 100	°C	-

**Characteristics**

**Processing**

Injection Molding

**Special Characteristics**

High impact or impact modified

**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 - 0.12%

Drying temperature dry air dryer: 80 °C

Drying time dry air dryer 2 - 6 h

**PROCESSING**

Melt temperature (Tmin - Tmax): 260 - 290 °C

Mold temperature: 80 - 100 °C