

Preliminary data for 35% long fiber single pellet color filled PA6

Property

TYPICAL PROPERTIES ⁽¹⁾			
MECHANICAL	Value	Unit	Standard
Tensile Stress, brk, Type I, 5 mm/min	175	MPa	ASTM D 638
Tensile Strain, brk, Type I, 5 mm/min	2.6	%	ASTM D 638
Tensile Modulus, 5 mm/min	9160	MPa	ASTM D 638
Flexural Stress, yield, 2 mm/min	261	MPa	ISO 178
Flexural Modulus, 2 mm/min	7990	MPa	ISO 178
IMPACT	Value	Unit	Standard
Izod Impact, unnotched, 23°C	1270	J/m	ASTM D 4812
Izod Impact, notched, 23°C	188	J/m	ASTM D 256
Izod Impact, notched, -40°C	233	J/m	ASTM D 256
Izod Impact, unnotched 80*10*4 +23°C	82	kJ/m ²	ISO 180/1U
Izod Impact, notched 80*10*4 +23°C	19	kJ/m ²	ISO 180/1A
Izod Impact, notched 80*10*4 -40°C	27	kJ/m ²	ISO 180/1A
THERMAL	Value	Unit	Standard
HDT/Af, 1.8 MPa Flatw 80*10*4 sp=64mm	215	°C	ISO 75/Af
PHYSICAL	Value	Unit	Standard
Density	1.39	g/cm ³	ASTM D 792

Source GMD, last updated:08/12/2008

Processing

Parameter	Value	Unit
Injection Molding		
Drying Temperature	80	°C
Drying Time	4	hrs
Maximum Moisture Content	0.15 - 0.25	%
Melt Temperature	270 - 295	°C
Front - Zone 3 Temperature	270 - 290	°C
Middle - Zone 2 Temperature	270 - 290	°C
Rear - Zone 1 Temperature	260 - 275	°C
Mold Temperature	85 - 100	°C
Back Pressure	0.2 - 0.3	MPa
Screw Speed	20 - 60	rpm

Source GMD, last updated:08/12/2008

THESE PROPERTY VALUES ARE NOT INTENDED FOR SPECIFICATION PURPOSES.

PLEASE CHECK WITH YOUR [\(LOCAL SALES OFFICE\)](#) FOR AVAILABILITY IN YOUR REGION

(1) Typical values only. Variations within normal tolerances are possible for various colors. All values are measured after at least 48 hours storage at 23°C/50% relative humidity. All properties, except the melt volume and melt flow rates, are measured on injection molded samples. All samples tested under ISO test standards are prepared according to ISO 294.

- (2) Only typical data for selection purposes. Not to be used for part or tool design.
- (3) This rating is not intended to reflect hazards presented by this or any other material under actual fire conditions.
- (4) Internal measurements according to UL standards.

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