

PA 6, 15 % glass fibers, injection molding, improved impact strength, heat-aging stabilized

| Rheological properties      | dry / cond | Unit | Test Standard   |
|-----------------------------|------------|------|-----------------|
| <b>ISO Data</b>             |            |      |                 |
| Molding shrinkage, parallel | 0.5 / *    | %    | ISO 294-4, 2577 |
| Molding shrinkage, normal   | 0.6 / *    | %    | ISO 294-4, 2577 |

| Mechanical Properties                   | dry / cond  | Unit              | Test Standard |
|-----------------------------------------|-------------|-------------------|---------------|
| <b>ISO Data</b>                         |             |                   |               |
| Tensile Modulus                         | 5600 / 2800 | MPa               | ISO 527       |
| Stress at break                         | 115 / 65    | MPa               | ISO 527       |
| Strain at break                         | 4 / 12      | %                 | ISO 527       |
| Charpy impact strength (+23 °C)         | 65 / 80     | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Charpy impact strength, -30 °C          | 50 / -      | kJ/m <sup>2</sup> | ISO 179/1eU   |
| Charpy notched impact strength (+23 °C) | - / 15      | kJ/m <sup>2</sup> | ISO 179/1eA   |

| Thermal Properties                        | dry / cond | Unit | Test Standard  |
|-------------------------------------------|------------|------|----------------|
| <b>ISO Data</b>                           |            |      |                |
| Melting temperature (10 °C/min)           | 220 / *    | °C   | ISO 11357-1/-3 |
| Temp. of deflection under load (1.80 MPa) | 195 / *    | °C   | ISO 75-1/-2    |
| Temp. of deflection under load (0.45 MPa) | 215 / *    | °C   | ISO 75-1/-2    |

| Other Properties | dry / cond | Unit              | Test Standard |
|------------------|------------|-------------------|---------------|
| <b>ISO Data</b>  |            |                   |               |
| Density          | 1230 / -   | kg/m <sup>3</sup> | ISO 1183      |

| Test specimen production            | Value | Unit | Test Standard |
|-------------------------------------|-------|------|---------------|
| <b>ISO Data</b>                     |       |      |               |
| Injection Molding, melt temperature | 280   | °C   | ISO 294       |
| Injection Molding, mold temperature | 80    | °C   | ISO 294       |

## Characteristics

### Processing

Injection Molding

### Special Characteristics

Impact modified, Heat aging stabilized

### Delivery form

Pellets

## 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

## Disclaimer

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