

PA 6, 15 % glass fibers, injection molding, improved impact strength

Mechanical Properties	dry / cond	Unit	Test Standard
ISO Data			
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 ²	ISO 179/1eU
Charpy impact strength, -30 °C	50 / -	kJ/m ²	ISO 179/1eU
Charpy notched impact strength (+23 °C)	- / 15	kJ/m ²	ISO 179/1eA

Thermal Properties	dry / cond	Unit	Test Standard
ISO Data			
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
ISO Data			
Density	1230 / -	kg/m ³	ISO 1183

Test specimen production	Value	Unit	Test Standard
ISO Data			
Injection Molding, melt temperature	280	°C	ISO 294
Injection Molding, mold temperature	80	°C	ISO 294

Characteristics

Processing

Injection Molding

Special Characteristics

Impact modified

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

These guide values are measured and provided by the product manufacturer and have been determined on standardised test specimens and can be affected by pigmentation, mould design and processing conditions. M-Base has taken the guide values from the producer's original Technical Data Sheet. **ALBIS AND M-BASE ARE THEREFORE NOT RESPONSIBLE FOR THE ACCURACY OF THE GUIDE VALUES AND CANNOT GIVE ANY WARRANTY WITH REGARD TO THEIR CORRECTNESS.**

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