

DOMAMID® 6G15H2 BK

(DOMAMID A1-021-V15-H2-DB)

Polyamide 6, 15% glass fiber reinforced, heat stabilized, for injection moulding, black

19.09.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-GF15
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,23
Moisture absorption	sat., 23°C, 50% RH	ISO 62	[%]	2,7
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,50 - 0,70
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,10 - 1,30
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm ³ /10 min]	75
Viscosity number	96% H ₂ SO ₄	ISO 307	[ml/g]	138
MECHANICAL				
				dam / cond.*
Tensile modulus	1 mm/min	ISO 527	[MPa]	5600 / 3900
Tensile stress at break	5 mm/min	ISO 527	[MPa]	120 / 75
Tensile strain at break	5 mm/min	ISO 527	[%]	3 / 10,5
Flexural modulus	5 mm/min	ISO 178	[MPa]	4800 / 2600
Flexural strength	5 mm/min	ISO 178	[MPa]	180 / 105
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	35 / 40
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	5,5 / 15
THERMAL				
Melting point		ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	215
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	190
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	210
BURNING BEHAVIOUR				
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded).

*: conditioned according to ISO 1110

PROCESSING CONDITIONS:

Drying temperature/time : 75-85°C / 2-4h (with dew point of dried air < -30 °C)
 Recommended melt temperature : 250-290 °C
 Recommended mould temperature : 80-100 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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