

DOMAMID® 6G30H1

(DOMAMID 6G30H)

Polyamide 6, 30% glass fiber reinforced, heat stabilized, for injection moulding

09.03.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-GF30
ISO 1874-1 designation		ISO 1874-1		PA6,MH,14-090,GF30
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,4
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,3 - 0,5
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,8 - 1,0
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm ³ /10 min]	45
Viscosity number	96% H ₂ SO ₄	ISO 307	[ml/g]	145
MECHANICAL				
				dam / cond.*
Tensile modulus	1 mm/min	ISO 527	[MPa]	9500 / 6000
Tensile stress at break	5 mm/min	ISO 527	[MPa]	180 / 110
Tensile strain at break	5 mm/min	ISO 527	[%]	3,5 / 6,0
Flexural modulus	2 mm/min	ISO 178	[MPa]	8500 / 5000
Flexural strength	2 mm/min	ISO 178	[MPa]	270 / 160
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	90 / 105
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	15 / 25
Izod impact unnotched	+23 °C	ISO 180/1U	[kJ/m ²]	80 / 90
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	15 / 25
Hardness Rockwell		ISO 2039/2	[ScaleR]	122 / -
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	220
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	200
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	215
ELECTRICAL				
Volume resistivity		IEC 60093	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 60093	[Ω]	10 ¹³
Comparative Tracking Index (CTI)	Solution A	IEC 60112	[V]	500
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB
Glow Wire Flammability Index (GWFI)	1 - 3 mm	IEC 60695-2-12	[°C]	650
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for natural colored products

*: 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 : 240-270 °C
 Recommended mould temperature : 90-100 °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.

The information provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all conditions under which this information and our products of other manufactures in combination with our products may be used. Domo accepts no responsibility for results obtained by the application of this information or for the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each product or product combination for their own purposes. Unless otherwise agreed in writing, Domo sells the product without warranties. Buyers and users assume all responsibility and liability for loss or damage arising from handling and use of our products, whether used alone or in combination with other products. Unless specifically indicated, the grades mentioned are not suitable for applications in the pharmaceutical/medical sector.

Domo Engineering Plastics GmbH

P: +49 33862139776

Fax: +49 33862139766

Mail: info.dep@domo.org

Domo Engineering Plastics Italy SpA

P: +39 04640587676

Fax: +39 04640587676

Mail: info.depi@domo.org

www.domochemicals.com