DOMO® Engineering Plastics
Technical Data Sheet

DOMAMID® 6G30H2 NC

(DOMAMID A1-008-V30-H2-N)

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

19.09.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-GF30
PHYSICAL				
Density		ISO 1183	[g/cm³]	1,36
Moisture absorption	sat., 23°C, 50% RH	ISO 62	[%]	2,3
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,25 - 0,45
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,85 - 1,05
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm³/10 min]	35
Viscosity number	96% H2SO4	ISO 307	[ml/g]	145
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	9500
Tensile stress at break	5 mm/min	ISO 527	[MPa]	180
Tensile strain at break	5 mm/min	ISO 527	[%]	3,6
Flexural modulus	5 mm/min	ISO 178	[MPa]	7200
Flexural strength	5 mm/min	ISO 178	[MPa]	270
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m²]	94
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m²]	14
THERMAL				
Melting point		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]	210
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	214
ELECTRICAL				
Volume resistivity		IEC 60093	[Ω·cm]	1E+15
Surface resistivity		IEC 60093	[Ω]	1E+14
BURNING BEHAVIOUR				
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

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

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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