

DOMAMID® 6LVG40

(DOMAMID 6G40AF)

Polyamide 6, 40% glass fiber reinforced, improved flowability, for injection moulding

20.04.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-GF40
ISO 1874-1 designation		ISO 1874-1		PA6,M,12-120,GF40
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,5
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,2 ÷ 0,4
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,7 ÷ 0,9
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm ³ /10 min]	40
Viscosity number	96% H ₂ SO ₄	ISO 307	[ml/g]	125
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	12500
Tensile stress at break	5 mm/min	ISO 527	[MPa]	195
Tensile strain at break	5 mm/min	ISO 527	[%]	2,5
Flexural modulus	2 mm/min	ISO 178	[MPa]	10500
Flexural strength	2 mm/min	ISO 178	[MPa]	275
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	100
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	18
Izod impact unnotched	+23 °C	ISO 180/1U	[kJ/m ²]	90
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	17
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
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB
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

PROCESSING CONDITIONS:

Drying temperature/time : 75-85°C / 2-4h (with dew point of dried air < -30 °C)
 Recommended melt temperature : 240-280 °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.

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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