

DOMAMID® 6LVGM3010H2 BK

(DOMAMID A1-124-M20-V10-H2-DB)

Polyamide 6, 30% glass fiber and mineral, improved flowability, heat stabilized, for injection moulding, black

19.09.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-(GF10+GB20)
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,36
Moisture absorption	sat., 23°C, 50% RH	ISO 62	[%]	2,2
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,55 - 0,75
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,90 - 1,10
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm ³ /10 min]	70
Viscosity number	96% H ₂ SO ₄	ISO 307	[ml/g]	130
MECHANICAL				
				dam / cond.*
Tensile modulus	1 mm/min	ISO 527	[MPa]	8500 / 5800
Tensile stress at break	5 mm/min	ISO 527	[MPa]	120 / 75
Tensile strain at break	5 mm/min	ISO 527	[%]	3,0 / 3,0
Tensile stress at yield	5 mm/min	ISO 527	[MPa]	120 / 70
Tensile strain at yield	5 mm/min	ISO 527	[%]	3,0 / 3,0
Flexural modulus	5 mm/min	ISO 178	[MPa]	8000 / 3800
Flexural strength	5 mm/min	ISO 178	[MPa]	180 / 100
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	40 / 45
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	5 / 12
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]	200
ELECTRICAL				
Volume resistivity		IEC 60093	[Ω·cm]	1E+15
Surface resistivity		IEC 60093	[Ω]	1E+14

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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