

DOMAMID® HCE 6G65

(DOMAMID 6G65HCE)

Polyamide 6, 65% glass fiber reinforced, improved surface finish, for injection moulding

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-GF65
ISO 1874-1 designation		ISO 1874-1		PA6,M,12-250,GF65
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,8
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,1 ÷ 0,2
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,2 ÷ 0,4
Water absorption	T=23°C / sat.	ISO 62	[%]	2,5
RHEOLOGICAL				
Viscosity number	96% H2SO4	ISO 307	[ml/g]	125
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	24000
Tensile stress at break	5 mm/min	ISO 527	[MPa]	250
Tensile strain at break	5 mm/min	ISO 527	[%]	1,5
Flexural modulus	2 mm/min	ISO 178	[MPa]	22500
Flexural strength	2 mm/min	ISO 178	[MPa]	390
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	85
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	17
Izod impact unnotched	+23 °C	ISO 180/1U	[kJ/m ²]	80
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	18
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]	210
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	210
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

PROCESSING CONDITIONS:

Drying temperature/time : 75-85°C / 2-4h (with dew point of dried air < -30 °C)
 Recommended melt temperature : 260-290 °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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