

DOMAMID® 6G65HCE

Polyamide 6

DOMO Engineering Plastics SPA

Message:

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

General Information			
Filler / Reinforcement	Glass Fiber,65% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.77	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 2577
Across Flow : 23°C, 72 hr	0.20 to 0.40	%	
Flow : 23°C, 72 hr	0.10 to 0.30	%	
Water Absorption (Saturation, 23°C)	3.0	%	ISO 62
Viscosity Number	125	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	24000	MPa	ISO 527-2/1
Tensile Stress (Break)	250	MPa	ISO 527-2/5
Tensile Strain (Break)	1.5	%	ISO 527-2/5
Flexural Modulus ²	20500	MPa	ISO 178
Flexural Stress ³	390	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	17	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	85	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	18	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	80	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	220	°C	ISO 75-2/B
1.8 MPa, Unannealed	210	°C	ISO 75-2/A
Vicat Softening Temperature	210	°C	ISO 306/B50
Melting Temperature	222	°C	ISO 11357-3
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms · cm	IEC 60093
Comparative Tracking Index (Solution A)	500	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Burning Rate	< 100	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB		UL 94

Glow Wire Flammability Index (1.00 to 3.00 mm)	650	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 95.0	°C	
Drying Time	2.0 to 4.0	hr	
Processing (Melt) Temp	260 to 290	°C	
Mold Temperature	90.0 to 100	°C	
NOTE			
1.	50% RH		
2.	2.0 mm/min		
3.	2.0 mm/min		

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