

# Hiprolon® 70 MNNHL G30

Polyamide 610

Arkema

Message:

Hiprolon® 70 MNNHL G30 is a polyamide 6.10 produced from a renewable source and reinforced with 30% glass fiber. This natural grade is designed for injection molding.

| General Information                          |                                  |                   |                     |
|----------------------------------------------|----------------------------------|-------------------|---------------------|
| Filler / Reinforcement                       | Glass Fiber,30% Filler by Weight |                   |                     |
| Features                                     | Renewable Resource Content       |                   |                     |
| Processing Method                            | Injection Molding                |                   |                     |
| Physical                                     | Nominal Value                    | Unit              | Test Method         |
| Density                                      | 1.31                             | g/cm <sup>3</sup> | ISO 1183            |
| Molding Shrinkage                            |                                  |                   |                     |
| Across Flow                                  | 1.0                              | %                 | ISO 2577, ISO 294-4 |
| Flow                                         | 0.50                             | %                 | ISO 294-4, ISO 2577 |
| Water Absorption (Equilibrium, 23°C, 50% RH) | 0.80                             | %                 | ISO 62              |
| Mechanical                                   | Nominal Value                    | Unit              | Test Method         |
| Tensile Modulus                              | 8300                             | MPa               | ISO 527-2           |
| Tensile Stress (Yield)                       | 150                              | MPa               | ISO 527-2           |
| Tensile Strain (Break)                       | 5.0                              | %                 | ISO 527-2           |
| Impact                                       | Nominal Value                    | Unit              | Test Method         |
| Charpy Notched Impact Strength               |                                  |                   | ISO 179/1eA         |
| -30°C                                        | 10                               | kJ/m <sup>2</sup> |                     |
| 23°C                                         | 16                               | kJ/m <sup>2</sup> |                     |
| Charpy Unnotched Impact Strength             |                                  |                   | ISO 179/1eU         |
| -30°C                                        | 89                               | kJ/m <sup>2</sup> |                     |
| 23°C                                         | 90                               | kJ/m <sup>2</sup> |                     |
| Thermal                                      | Nominal Value                    | Unit              | Test Method         |
| Heat Deflection Temperature                  |                                  |                   |                     |
| 0.45 MPa, Unannealed                         | 221                              | °C                | ISO 75-2/B          |
| 1.8 MPa, Unannealed                          | 210                              | °C                | ISO 75-2/A          |
| Vicat Softening Temperature                  | 217                              | °C                | ISO 306             |
| Melting Temperature                          | 222                              | °C                | ISO 11357-3         |
| Electrical                                   | Nominal Value                    | Unit              | Test Method         |
| Volume Resistivity                           | 1.0E+16                          | ohms · cm         | IEC 60093           |
| Comparative Tracking Index                   | > 600                            | V                 | IEC 60112           |
| Additional Information                       | Nominal Value                    | Unit              | Test Method         |
| ISO Shortname                                | PA 610, MHLR, 27-080, GF 30      |                   | ISO 1874            |
| Renewable Carbon Conent                      | > 60                             | %                 | ASTM D6866          |

| Injection              | Nominal Value | Unit |
|------------------------|---------------|------|
| Drying Temperature     | 80.0 to 90.0  | °C   |
| Drying Time            | 4.0           | hr   |
| Processing (Melt) Temp | 260 to 300    | °C   |
| Mold Temperature       | 60.0 to 110   | °C   |

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