

ECONAMID® 6G15FL

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, 15% glass fibre, for injection moulding.

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.22	g/cm ³	ISO 1183
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	120		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5000	MPa	ISO 527-2/1
Tensile Stress (Break)	120	MPa	ISO 527-2/5
Tensile Strain (Break)	4.0	%	ISO 527-2/5
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	4.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	20	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	205	°C	ISO 75-2/B
1.8 MPa, Unannealed	190	°C	ISO 75-2/A
Vicat Softening Temperature	210	°C	ISO 306/B50
Melting Temperature	218 to 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
Flammability	Nominal Value	Unit	Test Method
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 85.0	°C	
Drying Time	4.0 to 6.0	hr	
Processing (Melt) Temp	235 to 275	°C	
Mold Temperature	70.0 to 120	°C	

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