

DOMAMID® 6G40

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, 40% glass fiber reinforced, for injection moulding.

General Information			
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.46	g/cm ³	ISO 1183
Molding Shrinkage ¹			ISO 2577
Across Flow : 23°C, 72 hr	0.70 to 0.90	%	
Flow : 23°C, 72 hr	0.20 to 0.40	%	
Viscosity Number	145	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	13000	MPa	ISO 527-2/1
Tensile Stress (Break)	200	MPa	ISO 527-2/5
Tensile Strain (Break)	2.5	%	ISO 527-2/5
Flexural Modulus ²	10500	MPa	ISO 178
Flexural Stress ³	280	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	20	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	110	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)	95	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	200	°C	ISO 75-2/A
Vicat Softening Temperature	215	°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
Flammability	Nominal Value	Unit	Test Method
Burning Rate	< 100	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	75.0 to 95.0	°C	

Drying Time	2.0 to 4.0	hr
Processing (Melt) Temp	240 to 280	°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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