

INNOMID® CS 6-9830

Polyamide 6 Alloy

Inno-Comp Ltd.

Message:

INNOMID ® CS 6-9830 is a 30 % glass-fibre-filled polyamide (PA-6) compound. This grade is available in nature and custom coloured form.

Recommended application

INNOMID ® CS 6-9830 is recommended for producing injection moulded products, where the required properties are high strength and stiffness.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 30% filler by weight		
Features	Rigidity, high		
	High strength		
Appearance	Available colors		
	Natural color		
Forms	Particle		
Processing Method	Injection molding		
Resin ID (ISO 1043)	PA-6 GF30		
Physical	Nominal Value	Unit	Test Method
Density (23°C)	1.36	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	46.0	cm ³ /10min	ISO 1133
Molding Shrinkage			ISO 294-4
Vertical flow direction	0.70	%	ISO 294-4
Flow direction	0.10	%	ISO 294-4
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9400	MPa	ISO 527-2/2
Tensile Stress (Break)	150	MPa	ISO 527-2/1A/50
Flexural Modulus ¹	6600	MPa	ISO 178
Flexural Stress ²	245	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	9.0	kJ/m ²	ISO 179/1eA
23°C	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	69	kJ/m ²	ISO 179/1eU
23°C	73	kJ/m ²	ISO 179/1eU
Notched Izod Impact			ISO 180/A
-30°C	9.0	kJ/m ²	ISO 180/A
23°C	11	kJ/m ²	ISO 180/A

Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	200	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	DIN 53482
Comparative Tracking Index (Solution A)	550	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.20 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	60.0 - 80.0	°C	
Suggested Max Moisture	0.10	%	
Rear Temperature	220 - 260	°C	
Middle Temperature	220 - 260	°C	
Front Temperature	220 - 260	°C	
Processing (Melt) Temp	240 - 260	°C	
Mold Temperature	60.0 - 100	°C	
Injection Rate	Moderate		
Injection instructions			
Holding Pressure: 50-100% of actual injection pressure			
NOTE			
1.	Type 1A, 2.0 mm/min		
2.	Type 1A, 2.0 mm/min		

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