

ECONAMID® 6G30FL

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, 30% glass fiber reinforced, for injection moulding.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Viscosity Number	135	cm ³ /g	ISO 307
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	122		ISO 2039-2
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	9000	MPa	ISO 527-2/1
Tensile Stress (Break)	140	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus ¹	7500	MPa	ISO 178
Flexural Stress ²	200	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	6.0	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	5.5	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	35	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	215	°C	ISO 75-2/B
1.8 MPa, Unannealed	205	°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
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 270	°C
Mold Temperature	90.0 to 100	°C
NOTE		
1.	2.0 mm/min	
2.	2.0 mm/min	

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