

Witcom PA6 4C+G-XHI

Polyamide 6

Witcom Engineering Plastics B.V.

Message:

Witcom PA6 4C + G-XHI is a polyamide 6 (nylon 6) product, which contains 20% glass and carbon fiber reinforced materials. It can be processed by injection molding and is available in Europe.

- Features include:
- flame retardant/rated flame
 - Impact modification
 - Conductivity

General Information			
Filler / Reinforcement	Glass and carbon fiber reinforced materials, 20% filler by weight		
Additive	Impact modifier		
Features	Impact modification		
	Conductivity		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm ³	ISO 1183
Molding Shrinkage - Flow (3.00 mm)	0.20 - 0.40	%	ISO 2577
Water Absorption			ISO 62
Saturated, 23°C	6.0	%	ISO 62
Equilibrium, 23°C, 50% RH	1.8	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	< 120	MPa	ISO 527-2
Tensile Strain (Break)	4.0 - 6.0	%	ISO 527-2
Flexural Modulus	7000	MPa	ISO 178
Flexural Stress	140	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	30	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	90	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	195	°C	ISO 75-2/A
RTI Imp (3.00 mm)	95.0	°C	UL 746
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+4 - 1.0E+6	ohms	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating (3.00 mm)	HB		ISO 1210
Glow Wire Flammability Index (1.60 mm)	750	°C	IEC 60695-2-12
Injection	Nominal Value	Unit	

Drying Temperature	80.0	°C
Drying Time	3.0 - 5.0	hr
Suggested Max Moisture	0.10	%
Processing (Melt) Temp	250 - 270	°C
Mold Temperature	40.0 - 80.0	°C
Injection Rate	Fast	
Back Pressure	0.00 - 1.00	MPa

Injection instructions

Screw speed: 0.1 - 0.2 m/s Injection pressure: Keep to a minimum Hold pressure: Keep to a minimum

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