



Document	ISO Datasheet
Description	PA 6
Grade	I 6 GF30 BK
Code	
Application	Injection moulding

30% glass fiber reinforced PA6. Industrial grade.

Properties	Method	Unit	Value
Physical			
Density at 23°C	ISO 1183	g/cm ³	1,36
Mould Shrinkage (%)	INTERNAL	%	0,3-0,5
Filler Content (1h/600°C)	ISO 3451-1	%	30
Thermal			
Vicat B50	ISO 306	°C	190
HDT, A (1.80 MPa)	ISO 75/Af	°C	180
Mechanical at 23 °C			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	6000
Tensile Modulus (23°C - 1 mm/min)	ISO 527-2	MPa	7000
Tensile stress at break (23°C-5 mm/min)	ISO 527-2	MPa	100
Tensile elong. at break (23°C-5 mm/min)	ISO 527-2	%	4,0
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m ²	9
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m ²	65
Flammability Class			
Flammability class (3,0 mm)	UL94		HB
Processing Conditions			
Melt Temperature Range	ISO 294	°C	230-260
Mold Temperature Range	ISO 294	°C	60-80
Injection Velocity	ISO 294		MEDIUM
Drying Temperature		°C	80-100
Drying Time		Hour	3
Regulations compliance			
RoHS compliance status	NOT COMPLIANT		
EN71			

UL listed file n°

Water contact approvals

Food contact status

[§] Moulding shrinkage is not an intrinsic property of plastics. It also depends on moulding parameters. The values reported have been calculated in the direction parallel to the flow in a 3.0 x 12.7 x 127 mm sample.

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