



Document	ISO Datasheet
Description	PA 6
Grade	A 6 GF50
Code	
Application	Injection moulding

50% glass fiber reinforced polyamide 6.

Properties	Method	Unit	Value
<b>Physical</b>			
Density at 23°C	ISO 1183	g/cm <sup>3</sup>	1,56
Mould Shrinkage (%)	INTERNAL	%	0,1-0,3
<b>Thermal</b>			
Vicat B50	ISO 306	°C	215
HDT, A (1.80 MPa)	ISO 75/Af	°C	210
<b>Mechanical at 23 °C</b>			
Flexural Modulus (23°C - 2 mm/min)	ISO 178	MPa	12000
Tensile Modulus (23°C - 1 mm/min)	ISO 527-2	MPa	13000
Tensile stress at break (23°C-5 mm/min)	ISO 527-2	MPa	200
Tensile elong. at break (23°C-5 mm/min)	ISO 527-2	%	2,5
Izod notched impact strength (23°C) ISO	ISO 180/1A	KJ/m <sup>2</sup>	13
Charpy unnotched impact strength (23°C)	ISO 179/1eU	KJ/m <sup>2</sup>	75
<b>Flammability Class</b>			
Flammability class (1,6 mm)	UL94		HB
<b>Processing Conditions</b>			
Melt Temperature Range	ISO 294	°C	240-280
Mold Temperature Range	ISO 294	°C	60-80
Injection Velocity	ISO 294		MEDIUM
Drying Temperature		°C	80-100
Drying Time		Hour	3
<b>Regulations compliance</b>			
RoHS compliance status	COMPLIANT		
EN71			
UL listed file n°			

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Water contact approvals

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Food contact status

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<sup>§</sup> 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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