

Polyamide 6 compound 20% glass fiber reinforced | Colour: Black for injection moulding

Property	Method	Measurement condition	Unit	Values
Melt Flow Rate	ISO 1133	275 °C / 5 kg	cm ³ /10 min	80
Density	ISO 1183	-	kg/m ³	1310
Dry as moulded				
Tensile modulus	ISO 527-1	1 mm/min	MPa	4000
Tensile stress at break	ISO 527-1	5 mm/min	MPa	80
Tensile strain at break	ISO 527-1	5 mm/min	%	3
Charpy Impact Strength at 23 °C	ISO 179/1A	unnotched	KJ/m ²	25
Charpy Impact Strength at 23 °C	ISO 179/1A	notched		4
Melting Point	ISO 11357-1	DSC	°C	220

Application data

Description	Black opaque 20% glassfilled Polyamid with good flow.
Application	Injection Moulding
Drying conditions	80 °C , 4-6 hours moisture content < 0,15%
Moulding temperature - Nozzle	270 - 290 °C
Moulding temperature - Barrel	270 - 280 °C
Mould Temperature	85 - 95 °C
Compression ratio	2:1 - 2,5:1
Injection Pressure	90% of ram travel
Injection Speed	Fast ram speed
Hold Pressure	Low
Screw speed	0,1 - 0,2 m/s
Cushion	4 - 6 mm
Back Pressure	0 - 3,0 MPa

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