Latamid 6 H2E04 G/30

Polyamide 6

LATI S.p.A.

Message:

Compound based on Polyamide 6 (PA 6).
Heat stabilised. Toughened. Glass fibres.
Good elongation properties.

General Information	
Filler / Reinforcement	Glass Fiber,30% Filler by Weight
Additive	Heat Stabilizer Impact Modifier
Features	Heat Stabilized Impact Modified

Physical	Nominal Value	Unit	Test Method
Density	1.33	g/cm³	ISO 1183
Molding Shrinkage [1]			ISO 294-4
Across Flow : 2.00 mm	0.55 to 0.75	%	
Flow : 2.00 mm	0.25 to 0.50	%	
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus			ISO 527-2/1
23°C	8300	MPa	
60°C	6700	MPa	
90°C	4400	MPa	
120°C	3600	MPa	
150°C	2900	MPa	
Tensile Stress			ISO 527-2/5
Yield, 60°C	120	MPa	
Yield, 90°C	95.0	MPa	
Yield, 120°C	80.0	MPa	
Yield, 150°C	70.0	MPa	
Break, 23°C	150	MPa	
Break, 60°C	115	MPa	
Break, 90°C	90.0	MPa	
Break, 120°C	75.0	MPa	
Break, 150°C	65.0	MPa	
Tensile Strain			ISO 527-2/5
Yield, 60°C	4.6	%	
Yield, 90°C	6.0	%	

Yield, 120°C	7.0	%	
Yield, 150°C	8.0	%	
Break, 23°C	3.5	%	
Break, 60°C	4.8	%	
Break, 90°C	6.0	%	
Break, 120°C	7.0	%	
Break, 150°C	8.0	%	
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	80	kJ/m^2	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179/1eU
Notched Izod Impact (23°C, 3.20 mm)	180	J/m	ASTM D256A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, Unannealed	220	°C	ISO 75-2/B
1.8 MPa, Unannealed	205	°C	ISO 75-2/A
Continuous Use Temperature [2]	100	°C	
Vicat Softening Temperature	215	°C	ISO 306/B50
CLTE - Flow (30 to 100°C)	3.0E-5	cm/cm/°C	ASTM D696
Injection	**Nominal Value**	**Unit**	
Drying Temperature	90.0 to 100	°C	
Drying Time	3.0	hr	
Processing (Melt) Temp	240 to 260	°C	
Mold Temperature	60.0 to 80.0	°C	
Injection Rate	Moderate		
NOTE			
1.	at 60 Mpa of cavity pressure		
2.	20,000 hr		

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