DOMAMID® 6G15H

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, 15% glass fiber reinforced, heat stabilized, for injection moulding.

General Information			
UL YellowCard	E170540-225450		
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	Heat Stabilizer		
Features	Heat Stabilized		
Processing Method	Injection Molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.23	g/cm³	ISO 1183
Molding Shrinkage [1]			ISO 2577
Across Flow : 23°C, 72 hr	0.80 to 1.0	%	
Flow : 23°C, 72 hr	0.40 to 0.60	%	
Hardness	**Nominal Value**	**Unit**	**Test Method**
Rockwell Hardness (R-Scale)	120		ISO 2039-2
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	6100	MPa	ISO 527-2/1
Tensile Stress (Break)	130	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	%	ISO 527-2/5
Flexural Modulus [2]	5200	MPa	ISO 178
Flexural Stress [3]	200	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength (23°C)	6.5	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	45	kJ/m²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	6.5	kJ/m²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	40	kJ/m²	ISO 180/1U
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, Unannealed	215	°C	ISO 75-2/B
1.8 MPa, Unannealed	190	°C	ISO 75-2/A
Vicat Softening Temperature	210	°C	ISO 306/B50
Melting Temperature	222	°C	ISO 11357-3
Electrical	**Nominal Value**	**Unit**	**Test Method**
Surface Resistivity	1.0E+13	ohms	IEC 60093
Volume Resistivity	1.0E+15	ohms·cm	IEC 60093
Comparative Tracking Index (Solution A)	500	V	IEC 60112

Flammability	Nominal Value	Unit	Test Method
Burning Rate	< 100	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB		UL 94

Injection	Nominal Value	Unit
Drying Temperature	75.0 to 95.0	°C
Drying Time	2.0 to 4.0	hr
Processing (Melt) Temp	240 to 260	°C
Mold Temperature	80.0 to 90.0	°C

NOTE	
1.	50% RH
2.	2.0 mm/min
3.	2.0 mm/min

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China