

DOMAMID® 6GM304

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, 30% glass fibre and mineral filler, for injection moulding.

General Information				
Filler / Reinforcement		Glass\Mineral,30% Filler by Weight		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Molding Shrinkage ¹				ISO 2577
Across Flow : 23°C, 72 hr	0.70 to 0.90	--	%	
Flow : 23°C, 72 hr	0.30 to 0.50	--	%	
Water Absorption				ISO 62
Saturation, 23°C	7.0	--	%	
Equilibrium, 23°C, 50% RH	2.1	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	7000	4000	MPa	ISO 527-2/1
Tensile Stress (Break)	110	65.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.0	10	%	ISO 527-2/5
Flexural Modulus ²	6700	--	MPa	ISO 178
Flexural Stress ³	170	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	5.5	11	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	40	95	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	5.0	10	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	35	90	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	210	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	185	--	°C	ISO 75-2/A
Vicat Softening Temperature	200	--	°C	ISO 306/B50
Melting Temperature	222	--	°C	ISO 11357-3

Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+13	--	ohms	IEC 60093
Volume Resistivity	1.0E+15	--	ohms·cm	IEC 60093
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	< 100	--	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB	--		UL 94
Injection	Dry	Unit		
Drying Temperature	75.0 to 95.0		°C	
Drying Time	2.0 to 4.0		hr	
Processing (Melt) Temp	240 to 270		°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

