

DOMAMID® 6G30FC

Polyamide 6

DOMO Engineering Plastics SPA

Message:

Polyamide 6, 30% glass fiber reinforced, for injection moulding. Food contact compliant

General Information				
Filler / Reinforcement		Glass Fiber,30% Filler by Weight		
Features		Food Contact Acceptable		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Melt Volume-Flow Rate (MVR) (275°C/5.0 kg)	45.0	--	cm ³ /10min	ISO 1133
Molding Shrinkage ¹				ISO 2577
Across Flow : 23°C, 72 hr	0.80 to 1.0	--	%	
Flow : 23°C, 72 hr	0.30 to 0.50	--	%	
Viscosity Number	145	--	cm ³ /g	ISO 307
Hardness	Dry	Conditioned	Unit	Test Method
Rockwell Hardness (R-Scale)	122	--		ISO 2039-2
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	9500	6000	MPa	ISO 527-2/1
Tensile Stress (Break)	180	110	MPa	ISO 527-2/5
Tensile Strain				
Break	3.5	--	%	ISO 527-2/5
Break	--	6.0	%	ISO 527-2/50
Flexural Modulus ²	8500	5000	MPa	ISO 178
Flexural Stress ³	270	160	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	15	25	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	90	110	kJ/m ²	ISO 179/1eU
Notched Izod Impact Strength (23°C)	15	25	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength (23°C)	80	90	kJ/m ²	ISO 180/1U
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	220	--	°C	ISO 75-2/B

1.8 MPa, Unannealed	200	--	°C	ISO 75-2/A
Vicat Softening Temperature	215	--	°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
Comparative Tracking Index (Solution A)	500	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	< 100	--	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB	--		UL 94
Glow Wire Flammability Index (1.00 to 3.00 mm)	650	--	°C	IEC 60695-2-12
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	90.0 to 100		°C	
NOTE				
1.	50% RH			
2.	2.0 mm/min			
3.	2.0 mm/min			

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