

Polymer	Characteristics	Application	Quality	Product Number
polyamide 6	PA6 reinforced with glass fiber, mineral filler, heat stabilised	injection moulding	prime	169002

Properties (in natural colour at 23°C)	Unit	Test Method	Value
<b>General</b>			
Symbols and abbreviated terms		STN EN ISO 1043-1	PA 6
Density	g/cm <sup>3</sup>	STN EN ISO 1183-1	1,36
Type of the filler: GF, GB, MF, G			GF, MF
Stabilisation: TS, LS, K			TS
Modification: FR, HI, MI, ME			
Colour: NA, F, BK			NA/F
<b>Processing</b>			
Processing method: IM, E	°C		IM
Melting point DSC	°C	STN EN ISO 11357-1	222
Melt temperature range	°C		250 - 280
Mould temperature range	°C		70 - 90
Injection pressure	MPa		60 - 150
Drying: temperature/time	°C/H		80/4
Water content	%	STN EN ISO 3344	0,1
Melt flow rate 230°C/2,16 kg	g/10 min	STN EN ISO 1133	10
Manufacturing shrinkage length / width	%	STN EN ISO 294-4	0,5/0,7
<b>Mechanical</b>			
Tensile strength	MPa	STN EN ISO 527-2	100
Elongation	%	STN EN ISO 527-2	3
Tensile modulus	MPa	STN EN ISO 527-2	6300
Flexural modulus	MPa	STN EN ISO 178	4500
Flexural strength	MPa	STN EN ISO 178	155
Charpy impact strength 23°C	kJ/m <sup>2</sup>	STN EN ISO 179	40
Charpy impact strength -20°C	kJ/m <sup>2</sup>	STN EN ISO 179	35
Charpy notched impact strength 23°C	kJ/m <sup>2</sup>	STN EN ISO 179	3
Charpy notched impact strength -20°C	kJ/m <sup>2</sup>	STN EN ISO 179	2
<b>Thermal</b>			
Heat deflection temperature	°C	STN EN ISO 75-2 (A)	210
Vicat softening point B	°C	STN EN ISO 306	210
<b>Flammability</b>			
Flammability	°flam.	UL - 94	HB
Glow wire test	°C	STN EN 60695-2-12	650 (3mm)

Electrical			
Comparative tracking index CTI, A	V	STN EN 60112	450
Volume resistivity	Ohm.m	STN 34 6460	1x10 <sup>13</sup>
Surface resistivity	Ohm	STN 34 6460	1x10 <sup>14</sup>
Electric strength	kV/mm	STN EN 60243-2	25

### Features

PA 6 for injection moulding reinforced with 10 % glass fibre and 20% talc, heat stabilised. Good anisotropy of the manufacturing shrinkage. Application for flat products in disc form - low warpage after cooling off and for thick-walled products. Delivered in natural mode and in the full RAL colour scale.

### Packaging, transportation, storage

The product is packed either in hermetically closed thick-walled 25 kg PE bags placed on a 1.000 kg palette coated by a stretch film, or in PE bag inserted in bigbag placed on a 1.000 kg palette or in PE bag inserted in paper octabin placed on a 1.000 kg palette or in other packaging according to customer requirements. The transport is provided in closed-up vehicles where the material is protected against movement and mechanical damage. The product requires stocking in closed-up, dry places protected against sun and thermal radiation.

### NOTE:

Data and values are average measured values, they are intended for technical service advices and can be changed without prior notice.

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