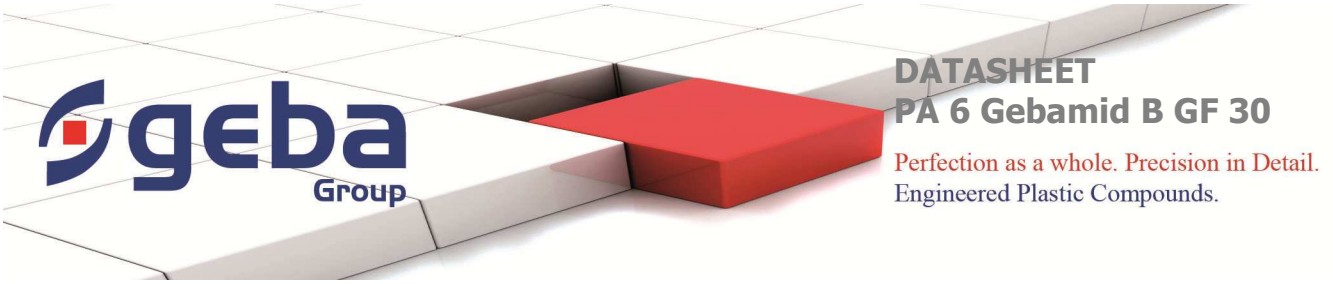


Polyamide 6 GF 30

Application: Technical injection molded parts

Typical values	Condition	Unit	Test method	Values
Mechanical properties				
Charpy unnotched impact strength	23 °C	kJ/m²	ISO 179/1eU	60
Charpy notched impact strength	23 °C	kJ/m²	ISO 179/1eA	10
Tensile modulus	1 mm / min	MPa	ISO 527-1	7.500
Tensile Stress Yield	50 mm / min	MPa	ISO 527-1	150
Tensile Strain Yield	50 mm / min	%	ISO 527-1	3
Flexural Modulus	1 mm / min	MPa	ISO 178	7.300
Properties				
Density	23 °C	g/cm³	ISO 1183	1,36
Water absorption	23 °C; 50% r. F.	%	ISO 62	2,1

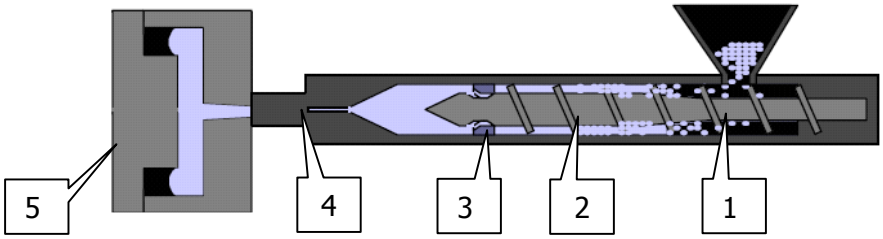
Processing recommendations:

Drying

Drying temperature in °C	Drying time (h) Dry air dryer
80 – 100	**2 - 4**

- Residual moisture content max 0,03 – 0,1 %
- When downtime of 4 hours, we recommend lowering the temperature of the dryer by 40 ° C.

Processing recommendations



Melt temperature	5. Mold	4. Nozzle	3. Zone	2. Zone	1. Zone
(°C)	(°C)	(°C)	(°C)	(°C)	(°C)
260 – 290	80 – 100	250 – 280	250 – 280	250 – 270	240 - 260

- **Shrinkage according to Literature: 0,25 to 1% (depending on the part geometry and the process)**
- **The values given are to be understood in recompounds as a guide and may in particular, depending on the color vary or filler.**

Recommended values. The temperatures can vary depending on part design and injection molding machine

Test Values
The stated values were – if not otherwise stated – taken on standardised test specimen at room ambient temperature. The specifications have to be regarded as guidance values, but not as binding minimum values. Please note that the properties can be considerably influenced by mould design, processing parameters and colouring.

Processing Instructions
When processing on the basis of the recommended processing parameters, small quantities of dissociation products can emit. According to the safety data sheet, the workplace exposure limit has to be kept by means of adequate exhaustion and ventilation, in order not to affect the machine operators' health and well-being. The compulsory processing temperatures must not be considerably exceeded, in order to avoid a stronger partial decomposition of the polymers and dissociation of volatile decomposition products.