

DATASHEET PA 6 Gebamid B GF 30

Perfection as a whole. Precision in Detail.
Engineered Plastic Compounds.

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/m ² | ISO 179/1eU | 60 |
| Charpy notched impact strength | 23 °C | kJ/m ² | 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/cm ³ | ISO 1183 | 1,36 |
| Water absorption | 23 °C; 50% r. F. | % | ISO 62 | 2,1 |

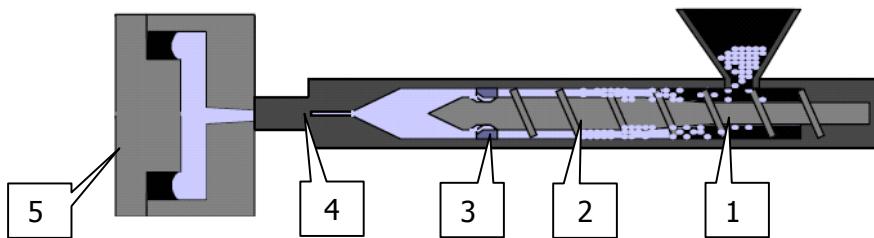
Processing recommendations:

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 (°C) | 5. Mold (°C) | 4. Nozzle (°C) | 3. Zone (°C) | 2. Zone (°C) | 1. Zone (°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.

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