

PA6 GF30

Features Recycled raw material

Filler Glass fiber

Property	Value	Unit	Test method
PHYSICAL PROPERTIES			
Density	1,36	g/cm ³	ISO 1183
Viscosity	medium	Pas	--
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	8400	MPa	ISO 178
Maximum flexural strength	220	MPa	ISO 178
Maximum tensile strength	160	MPa	ISO 527-2
Elongation at break	--	%	ISO 527-2
IMPACT PROPERTIES			
Notched Charpy at +23°C	9	kJ/m ²	ISO 179
Notched Charpy at -20°C	6	kJ/m ²	ISO 179
Unnotched Charpy at +23°C	--	kJ/m ²	ISO 179
Unnotched Charpy at -20°C	--	kJ/m ²	ISO 179
THERMAL PROPERTIES			
HDT 120°C/h at 455kPa (B)	215	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	200	°C	ISO 75/1
Vicat 50°C/h at 9,81N (A)	--	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	190	°C	ISO 306
FLAMMABILITY PROPERTIES			
GWFI at 2 mm	--	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB	--	UL94
ADDITIONAL INFORMATION			
Filler content	30	±2%	ISO 3451
Mould shrinkage (with flow)	0,2-0,4	%	Polykemi
Mould shrinkage (across flow)	0,7-1,0	%	Polykemi
PROCESS INSTRUCTIONS			
Drying time	2-8	h	--
Drying temperature	75	°C	--
Melt temperature	250-280	°C	--
Mould temperature	60-80	°C	--
Peripheral screw speed	250-450	mm/s	--
Back pressure	60-100	bar	--

Further material information is available upon request

Stated values in this datasheet are approximate. The values originate, if nothing else is stated, from standardized test specimens in natural color. All information, recommendations and advice, written or verbal, given by an individual company within, or agent affiliated with, The Polykemi Group are according to our knowledge to the date of this edition, correct and given in good faith. It is the responsibility of the customer to test and evaluate if the material suits the application and the environment in which it is intended to be used. Companies within, or agent affiliated with, The Polykemi Group can not be held responsible or liable for any loss incurred through incorrect or faulty use of the products. When producing details in flame retardant material, corrosion protected steel is to recommend for the mould. We takes no responsibility for any printing errors.

Values within (): 23°C, 50% RH, 24h

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