

**PA6-GF15**

15% glass fiber reinforced

Mechanical properties	Typical data (dry)	Unit	Test method
Stress at break	130	MPa	ISO 527
Strain at break	3,5	%	ISO 527
Flexural strength	177	MPa	ISO 178
Flexural modulus	5200	MPa	ISO 178
Charpy Impact strength (+23°C)	50	kJ/m ²	ISO 179
Charpy notched Impact strength (+23°C)	8	kJ/m ²	ISO 179

Thermal properties	Typical data	Unit	Test method
Melting temperature, 10°C/min	220	°C	ISO 11357
Temp. of deflection under load (1.80 MPa)	195	°C	ISO 75

Other	Typical data	Unit	Test method
Humidity absorption	2.3	%	ISO 62
Surface resistivity	10 ¹²	Ω	IEC 60093
Mold shrinkage	0.3/0.9	%	ISO 294-4
Density	1240	kg/cm ³	ISO 1183

Recommendations for Injection molding

Injection molding temperature	245-275	°C
Mold temperature	50-80	°C
Drying temperature	80	°C
Drying time	4-8	H
Moisture content before processing	<0,15	%

Characteristics

Designed for the production of injection molding of various products and parts in the automotive, machinery, household appliances and other industries

Disclaimer: Unless specified to the contrary, the value given have been established on standardized test specimens at room temperature. The figures should be regarded as guide values only and not as binding minimum value. Kindly note that, under certain conditions, the properties can be affected to a considerable extent by the design of the mold/die, the processing conditions and the coloring.