

DOMAMID® 6LVG50 300 BK

(DOMAMID A1-111-V50-B)

Polyamide 6, low viscosity, injection moulding grade, 50% glass fiber reinforced, high flow, black

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,56
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,25 - 45
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,90 - 1,10
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm ³ /10 min]	30
Viscosity number	96% H2SO4	ISO 307	[ml/g]	125
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	16700
Tensile stress at break	5 mm/min	ISO 527	[MPa]	220
Tensile strain at break	5 mm/min	ISO 527	[%]	2,2
Flexural modulus	5 mm/min	ISO 178	[MPa]	13000
Flexural strength	5 mm/min	ISO 178	[MPa]	330
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	100
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	15
THERMAL				
Melting point		ISO 11357-1	[°C]	221

Test run at 23°C if not differently specified, DAM state (dry as moulded).

PROCESSING CONDITIONS:

Drying temperature/time : 75-85°C / 2-4h (with dew point of dried air < -30 °C)
 Recommended melt temperature : 250-290 °C
 Recommended mould temperature : 80-100 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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