

## DOMAMID® 6G15IK1 202 NC

Polyamide 6, 15% glass fiber reinforced, low temperature impact modified, for injection moulding, natural color

19.09.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
<b>PRODUCT IDENTIFICATION</b>				
ISO 1043 abbreviation		ISO 1043		PA6-I-GF15
<b>PHYSICAL</b>				
Density		ISO 1183	[g/cm <sup>3</sup> ]	1,20
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,60 - 0,80
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,95 - 1,15
<b>RHEOLOGICAL</b>				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm <sup>3</sup> /10 min]	40
<b>MECHANICAL</b>				
				dam / cond.*
Tensile modulus	1 mm/min	ISO 527	[MPa]	5200 / 3100
Tensile stress at break	5 mm/min	ISO 527	[MPa]	110 / 70
Tensile strain at break	5 mm/min	ISO 527	[%]	3,5 / 14
Flexural modulus	5 mm/min	ISO 178	[MPa]	4700 / 2500
Flexural strength	5 mm/min	ISO 178	[MPa]	175 / 100
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m <sup>2</sup> ]	80 / -
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m <sup>2</sup> ]	16 / -
<b>THERMAL</b>				
Melting point		ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	215
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	190
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	210
<b>ELECTRICAL</b>				
Volume resistivity		IEC 60093	[Ω·cm]	10 <sup>15</sup>
Surface resistivity		IEC 60093	[Ω]	10 <sup>13</sup>
<b>BURNING BEHAVIOUR</b>				
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

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

\*: conditioned according to ISO 1110

### 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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