

DOMAMID® 6G60HCE

Polyamide 6, 60% glass fiber reinforced, improved surface finish, for injection moulding.

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,66
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,1 ÷ 0,3
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,3 ÷ 0,5
RHEOLOGICAL				
Viscosity number		ISO 307	[ml/g]	125
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	22000
Tensile stress at break	5 mm/min	ISO 527	[MPa]	240
Tensile strain at break	5 mm/min	ISO 527	[%]	2
Flexural modulus	2 mm/min	ISO 178	[MPa]	18500
Flexural strength	2 mm/min	ISO 178	[MPa]	380
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	80
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	16
Izod impact unnotched	+23 °C	ISO 180/1A	[kJ/m ²]	75
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	17
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	222
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	220
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	210
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	210
ELECTRICAL				
Volume resistivity		IEC 93	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 93	[Ω]	10 ¹³
Comparative Tracking Index (CTI)	Solution A	IEC 112	[V]	500
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB
Glow Wire Flammability Index (GWFI)	1 ÷ 3 mm	IEC 60695-2-12	[°C]	650
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for natural colored products

PROCESSING CONDITIONS:

Drying temperature/time	: 75÷95°C / 2÷4h
Recommended melt temperature	: 260÷290 °C
Recommended mould temperature	: 90÷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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