



**MATERIAL
WIZARD TM**

MAGIC SOLUTIONS REAL RESULTS

Examid® PA6 GF20/CF10

Technical DataSheet | Supplied by Material Wizard



Technical DataSheet

Examid GF20/CF10 is a dry blend of impact-modified glass-filled polyamide and high-modulus carbon fiber masterbatch. Material has a unique combination of rigidity, impact resistance and outperforms carbon-fiber compounds in multi-stress applications.

Product Type

PA (Polyamide, Nylon) > PA 6 (Nylon 6) > PA 6+GF+CF

Applications/ Recommended for

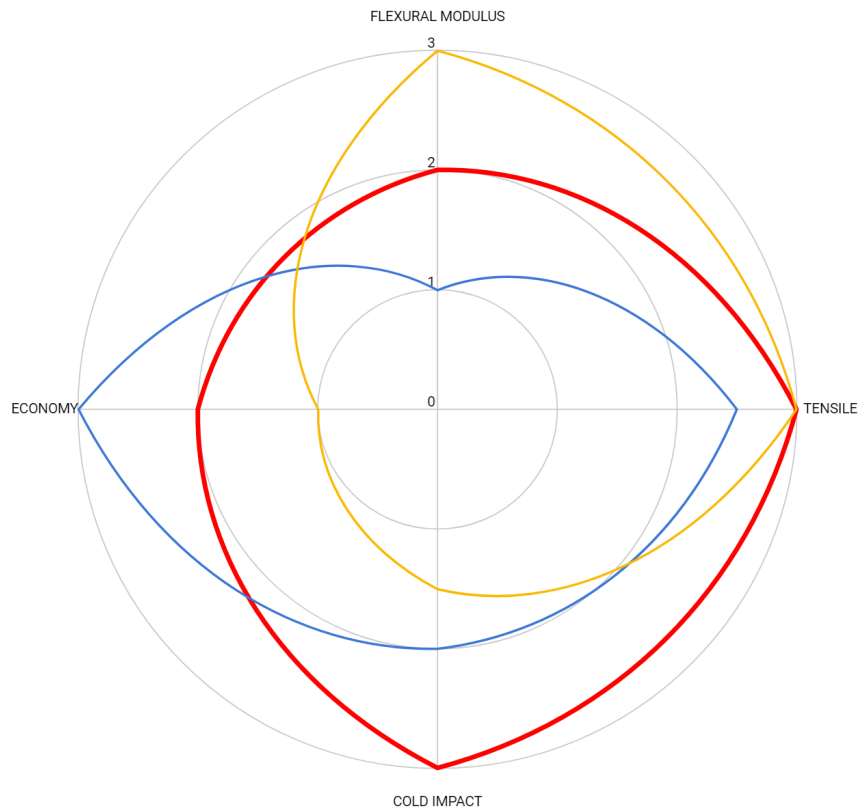
Injection Molding - thermoplastics > high-stress mechanical parts

Key Features

Frost resistance
High mechanical strength and rigidity
Excellent impact resistance
Dimensional stability

Comparative Material Analysis

- Examid® PA6 GF20/CF10
- PA6 GF30
- PA6 CF30



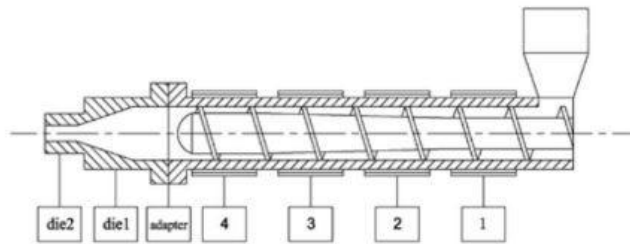
Examid® PA6 GF20/CF10 Typical Properties

Physical	Value & Unit	Test Condition	Test Method
Density	1.3 g/cm ³	At 23°C	ISO 1183
Glass fiber content	20%		internal
Carbon fiber content	10%		internal
Moisture absorption	2	23 °C / 50% r.h.	ISO 62
Water absorption	5,9	23 °C	ISO 62
Melt Volume rate (MVR)	35 cm ³ /10 min	275°C/5 kg	ISO 1133
Linear Mold Shrinkage, Flow	0.3 - 0.35 %		
Linear Mold Shrinkage, Transverse	0.4 - 0.45 %		
Mechanical	Value & Unit	Test Condition	Test Method
Elongation at Break	2%		ISO 527-1/-2
Flexural Modulus	12000 MPa	At 23°C, 2 mm/min	ISO 178
Flexural Strength	250 MPa	At 23°C, 2 mm/min	ISO 178

Impact Strength, Unnotched Charpy	80 kJ/m ²	At 23°C	ISO 179/1eU
Impact Strength, Unnotched Charpy	80 kJ/m ²	At -30°C	ISO 179/1eU
Impact Strength, Notched Charpy	15 kJ/m ²	At 23°C	ISO 179/1eA
Impact Strength, Notched Charpy	10 kJ/m ²	At -30°C	ISO 179/1eA

Processing Recommendations

Processing Conditions > Injection Molding:



	Zone1	Zone2	Zone3	Zone4	Adaptor	Die1	Die2
°C	240	250	260	270	280	285	290

Processing Recommendations > Drying:

Our materials are supplied pre-dried in moisture-guarded bags. However, dry materials will rapidly absorb moisture when exposed to the atmosphere. For recyclable products, it must be dried before processing. Drying time and temperature (only necessary for bags opened for more than two hours) : 4-6 hours at <80°C

Disclaimer

Standard Disclaimer

The manner in which you use and the purpose to which you put and utilize our products, technical assistance and information (whether verbal, written or by way of production evaluations), including any suggested formulations and recommendations, are beyond our control. Therefore, it is imperative that you test our products, technical assistance and information to determine to your own satisfaction whether they are suitable for your intended uses and applications. This application-specific analysis must at least include testing to determine suitability from a technical as well as health, safety and environmental standpoint. Such testing has not necessarily been done by us. Unless we otherwise agree in writing, all products are sold strictly pursuant to the terms of our standard conditions of sale. All information and technical assistance is given without warranty or guarantee and are subject to change without notice. It is expressly understood and agreed that you assume and hereby release us from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance and information. Any statement or recommendation not contained herein is unauthorized and shall not bind us. Nothing herein shall be construed as a recommendation to use any product in conflict with patents covering any material or its use. No license is implied or in fact granted under the claims of any patent. Typical Properties data is provided as general information only. Property values are approximate and are not part of the product specifications.

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