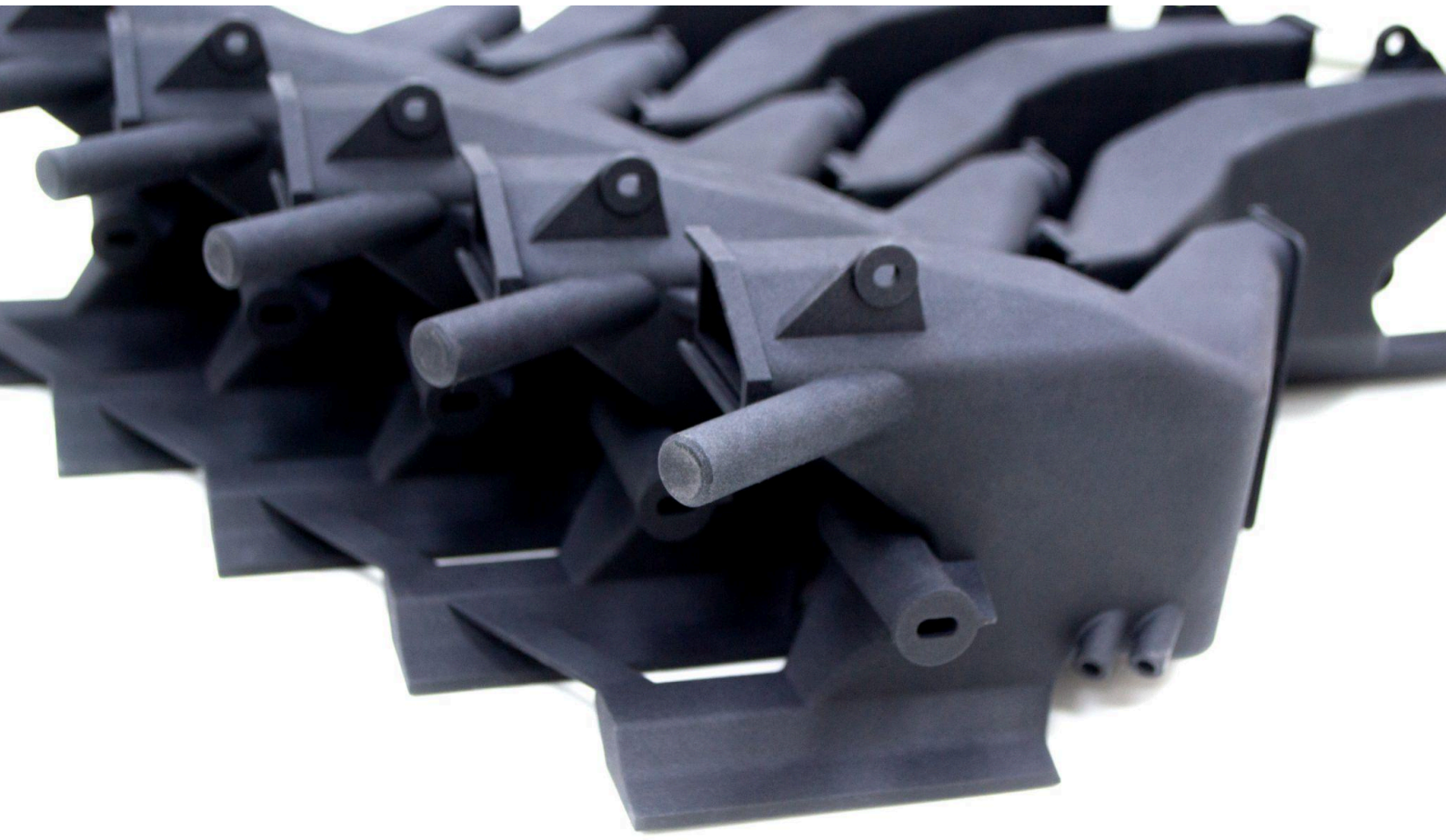
MATERIAL WIZARD TM

MAGIC SOLUTIONS REAL RESULTS

Examid® PA6 GF30

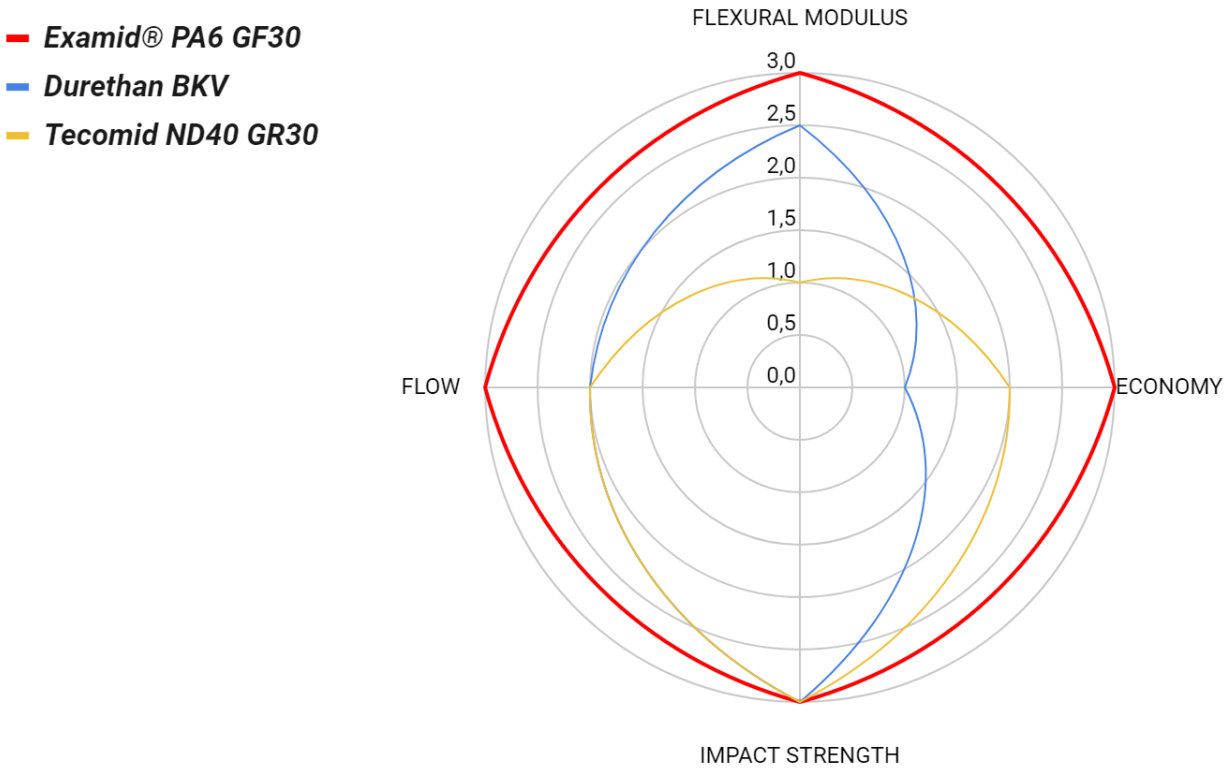
Technical DataSheet | Supplied by Material Wizard



Examid® PA6 GF30 by Material Wizard is an E-glass fiber-reinforced, heat-stabilized polyamide 6 grade. It provides excellent mechanical properties and optimal flow. It allows fast and efficient mold filling and easy mold release. It shows an excellent balance of rigidity and impact resistance. PA6 GF30 is a versatile material, suitable for a wide range of components requiring load stress resistance and higher heat performance.

Product Type	PA (Polyamide, Nylon) > PA 6 (Nylon 6) > PA 6 glass fiber filled
Applications/ Recommended for	Injection Molding - thermoplastics > high-stress mechanical parts
Colour	Black / Natural / Coloured to Order
Key Features	Good Flow Excellent Impact Resistance Heat Stabilized Good Mechanical Properties

Comparative Material Analysis



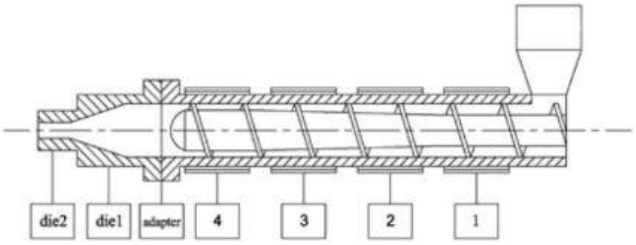
Examid® PA6 GF30 Typical Properties

Physical	Value & Unit	Test Condition	Test Method
Density	1.36 g/cm^3	At 23°C	ISO 1183
Glass Fiber Content	30%		internal
Melt Mass-Flow Rate, MFR	51 g/10min	At 275°C, 5kg	ISO 1133
Viscosity Number	medium viscosity		internal
Linear Mold Shrinkage, Flow	0.2 - 0.4 %		internal
Linear Mold Shrinkage, Transverse	0.8 - 0.9 %		internal
Mechanical	Value & Unit	Test Condition	Test Method
Stress at Break	176 MPa	50mm/min	ISO 527
Elongation at Break	12%	50mm/min	ISO 527-1/-2
Flexural Modulus	7500 MPa	10mm/min	ISO 178
Flexural Strength	261 MPa	10mm/min	ISO 178
Impact Strength, Notched Izod	16,5 kJ/m^2	(23°C;50%RH)	ISO 180/1A

Impact Strength, Notched Izod	11,2 kJ/m^2	(-30°C;50%RH)	ISO 180/1A
Tensile strength	178 MPa	50mm/min	ISO 527
Thermophysical	Value & Unit	Test Condition	Test Method
Temp. of deflection under load (HDT)	217°C	0.45 MPa	ISO 75-1/-2
Temp. of deflection under load (HDT)	200°C	1.8 MPa	ISO 75-1/-2
Burning behavior at 1.5 mm nominal thickness	HB	1,5 mm	UL94
Melting point	220°C	10°C/min	ISO 11357-1/-3
Vicat softening point	208°C		ISO 306
Electrical	Value & Unit	Test Condition	Test Method
Volume resistivity	10^15 Ohm*m		IEC 62631-3-1
Surface resistivity	10^13 Ohm		IEC 60093

Processing Recommendations

Processing Conditions > Injection Molding:



	Zone1	Zone2	Zone3	Zone4	Adaptor	Die1	Die2
°C	245	250	255	260	265	270	275

Mold temperature:

80–100°C (for optimal crystallization and dimensional stability)

Molding pressure:

80–130 MPa

Injection speed:

medium to high

Recycling:

up to 25% allowed without significant loss of properties, depending on processing conditions

Drying:

Our materials are supplied pre-dried in moisture-proof bags. However, dry materials quickly absorb moisture from the air. Drying time and temperature (only necessary for bags open for more than 1 hour): 4-8 hours at 90°C to 0.02% moisture

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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