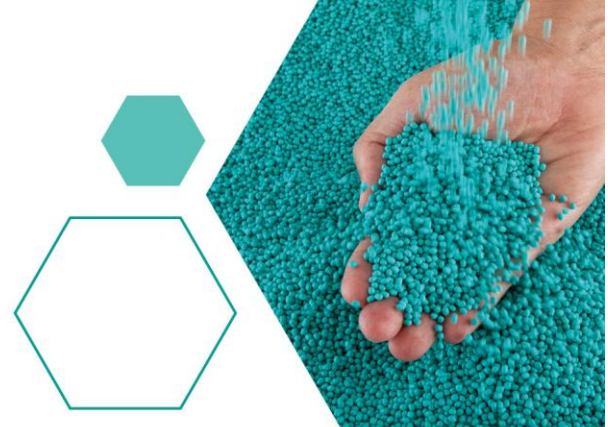


TECHNICAL DATASHEET

Argutec P 030 PA6 GF30 natur

Properties	Unit	Test method	Test conditions	Value
Rheological Properties				
Melt Flow Rate	cm ³ /10 min		270°C / 2,16 kg	17 - 25
Molding shrinkage	%	ISO 294-4	60×60×2 mm	0.5 – 0.7
Mechanical Properties				
Tensile strength	MPa	ISO 527	5 mm/min	170
Elongation at break	%	ISO 527	5 mm/min	5
Tensile modulus	MPa	ISO 527	1 mm/min	10100
Flexural stress	MPa	ISO 178	2 mm/min	275
Flexural modulus	MPa	ISO 178	2 mm/min	9700
Charpy impact strength	kJ/m ²	ISO 179/1eU	+23 °C ¹⁾	94
Charpy impact strength	kJ/m ²	ISO 179/1eU	– 30 °C	78
Charpy notched impact strength	kJ/m ²	ISO 179/1eA	+23 °C	15
Charpy notched impact strength	kJ/m ²	ISO 179/1eA	– 30 °C	12
Izod unnotched impact strength	kJ/m ²	ISO 180/1U	+23 °C ²⁾	80
Izod notched impact strength	kJ/m ²	ISO 180/1A	+23 °C	13
Thermal Properties				
Melting point	°C	ISO 3146	10 °C/ min	220
Temp. of deflection under load		ISO 75-1/-2		
0.45 MPa	°C			215
1.80 MPa	°C			213
Electrical Properties				
Dielectric strength	kV/mm	IEC 60243-1	thickness 1 mm	37
Volume resistivity	Ohm×m	IEC 60093		1012
Surface resistivity	Ohm	IEC 60093		1012
Other Properties				



TECHNICAL DATASHEET

Argutec P 030 PA6 GF30 natur

Water absorption,	%	Sim. to ISO 62	24h/23°C	1,5
Density	g/cm ³	ISO 1183		1,36
Abbreviated term	---	ISO 1043		PA6-GF33

¹⁾ – pendulum energy 4.0 J

²⁾ – pendulum energy 5.5 J

Characteristics:

Glass fiber reinforced virgin polyamide 6 injection molding compound. It has chemical resistance to hydrocarbons, mineral oils, concentrated and weak alkalis, weak acids, high electric strength.

Application:

The material is used for injection molding of different articles and parts for engineering and electrical insulation application, which are used in engineering, electrical and instrument-making industries, to operate in conditions of impact strength and vibrations.

Preprocessing:

Processing (injection molding) moisture content < 0.10 %.

If drying becomes necessary:

- drying in dehumidified dryer, drying temperature (80±5)°C,
- drying time is dependent on moisture level.

Processing:

Melt temperature 240 - 280 °C. To avoid degradation it is recommended to limit injection molding temperature to 290 °C.

Injection pressure 80 - 130 MPa, recommended 90 MPa.

Mold temperature 60 – 90 °C. A higher mold temperature leads to higher shrinkage.

Colour:

Natural (the material is not pigmented).

Recycling:

Clean milled post production wastes could be recycled after mixing with fresh plastics. The amount of milled plastic added to natural plastic is controlled depending on final product quality requirements. Attention shall be paid not to use milled scraps having more than 0.10 % water and without contamination.