

## Technical Data Sheet



### ALTECH PA6 A 2335/510 GF20 GB15 IM

|                        |                                                                                       |
|------------------------|---------------------------------------------------------------------------------------|
| Base Polymer           | Polyamide 6                                                                           |
| Filler/Additive System | glass fibres / glass beads                                                            |
| Special Features       | heat stabilised, impact modified, easy release (demoulding), injection moulding grade |
| Market Segment         | various                                                                               |
| Application Area       | various, injection moulded parts, bezels, housings                                    |

Pre-Drying Conditions      in a dry air (dessiccant) dryer 80-100 °C  
for 2-3 h  
max. moisture content <0,15 %

Processing Injection Moulding      melt temperature 270-290 °C  
mould temperature 80-100 °C

Storage      dry, protected from light

| Properties                              | dry/cond. | Dimension         | Test Norm   |
|-----------------------------------------|-----------|-------------------|-------------|
| <b>Mechanical Properties</b>            |           |                   |             |
| Flexural Modulus                        | 6600 / -  | MPa               | ISO 178     |
| Flexural Strength                       | 190 / -   | MPa               | ISO 178     |
| Tensile Modulus                         | 7500 / -  | MPa               | ISO 527     |
| Tensile Strength at Break               | 120 / -   | MPa               | ISO 527     |
| Tensile Elongation at Break             | 3 / -     | %                 | ISO 527     |
| Impact Strength (Charpy, 23°C)          | 70 / -    | kJ/m <sup>2</sup> | ISO 179/1eU |
| Impact Strength (Charpy, -40°C)         | 45 / -    | kJ/m <sup>2</sup> | ISO 179/1eU |
| Notched Impact Strength (Charpy, 23°C)  | 13 / -    | kJ/m <sup>2</sup> | ISO 179/1eA |
| Notched Impact Strength (Charpy, -40°C) | 6.5 / -   | kJ/m <sup>2</sup> | ISO 179/1eA |
| <b>Thermal Properties</b>               |           |                   |             |
| HDT / A (1,8 MPa)                       | 205 / *   | °C                | ISO 75-1/-2 |
| DSC (Melt Point)                        | 220 / *   | °C                | ISO 11357   |
| <b>Rheological Properties</b>           |           |                   |             |
| Shrinkage (lengthwise, 24h)             | 0.2 - 0.4 | %                 | ISO 294-4   |
| Shrinkage (lateral, 24h)                | 0.7 - 0.9 | %                 | ISO 294-4   |
| <b>Physical Properties</b>              |           |                   |             |
| Density                                 | 1380 / -  | kg/m <sup>3</sup> | ISO 1183    |