

Technical Data Sheet



ALTECH PA6 A 3230/120 GB20 GF10

MOCOM

Base Polymer	Polyamide 6
Filler/Additive System	20 % glass beads, 10 % glass fibres
Colour	black
Special Features	heat stabilised, easy flow, easy release (demoulding), fast solidifying
Market Segment	Automotive
Application Area	injection moulded parts, clothing / fasteners, interior decoration / finishing
Typical Applications	racking / shelving, housings, functional components

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h dependant on moisture content 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
Mechanical Properties			
Flexural Modulus	4800 / 2500	MPa	ISO 178
Flexural Strength	150 / 75	MPa	ISO 178
Tensile Modulus	5600 / 2800	MPa	ISO 527
Tensile Strength at Break	95 / 55	MPa	ISO 527
Tensile Elongation at Break	2.8 / 15	%	ISO 527
Impact Strength (Charpy, 23°C)	35 / 100	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	30 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	3.5 / 8.5	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	3 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	195 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.4 - 0.6	%	ISO 294-4
Shrinkage (lateral, 24h)	0.7 - 0.9	%	ISO 294-4
Physical Properties			
Density	1360 / -	kg/m ³	ISO 1183