

Technical Data Sheet



ALTECH PA6 A 3230/100 GF10 GB20

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, processing stabilised
Market Segment	Automotive, building and construction
Application Area	exterior parts, injection moulded parts
Typical Applications	functional components, housings, air duct

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 / -	MPa	ISO 178
Flexural Strength	155 / -	MPa	ISO 178
Tensile Modulus	5800 / -	MPa	ISO 527
Tensile Strength at Break	95 / -	MPa	ISO 527
Tensile Elongation at Break	2.8 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	30 / -	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	25 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	4 / -	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)	190 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.3 - 0.5	%	ISO 294-4
Shrinkage (lateral, 24h)	0.6 - 0.8	%	ISO 294-4
Physical Properties			
Density	1350 / -	kg/m ³	ISO 1183