



DOMAMID[®] 6G65HCE

Polyamide 6, 65% glass fiber reinforced, improved surface finish, for injection moulding.

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,77
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,1 - 0,3
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,2 - 0,4
RHEOLOGICAL				
Viscosity number		ISO 307	[ml/g]	125
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	24000
Tensile stress at break	5 mm/min	ISO 527	[MPa]	250
Tensile strain at break	5 mm/min	ISO 527	[%]	1,5
Flexural modulus	2 mm/min	ISO 178	[MPa]	20500
Flexural strength	2 mm/min	ISO 178	[MPa]	390
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	85
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	17
Izod impact unnotched	+23 °C	ISO 180/1A	[kJ/m ²]	80
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	18
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	222
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	220
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	210
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	210
ELECTRICAL				
Volume resistivity		IEC 93	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 93	[Ω]	10 ¹³
Comparative Tracking Index (CTI)	Solution A	IEC 112	[V]	500
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB
Glow Wire Flammability Index (GWFI)	1 - 3 mm	IEC 60695-2-12	[°C]	650
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for natural colored products

PROCESSING CONDITIONS:

Drying temperature/time	: 75-95°C / 2-4h
Recommended melt temperature	: 260-290 °C
Recommended mould temperature	: 90-100 °C