

Technical Data Sheet



ALCOM PA6 900/8.4 GF10 MR20 BK0002-00

Base Polymer	Polyamide 6
Filler/Additive System	10 % glass fibres, 20 % mineral
Special Features	heat stabilised, easy flow
Typical Applications	housings, functional components

Pre-Drying Conditions	80 °C in a dry air (dessiccant) dryer for 2-12 h dependant on moisture content
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	7400 / 5800	MPa	ISO 178
Flexural Strength	170 / 120	MPa	ISO 178
Tensile Modulus	8200 / 5500	MPa	ISO 527
Tensile Strength at Break	110 / 65	MPa	ISO 527
Tensile Elongation at Break	2.6 / 6.5	%	ISO 527
Impact Strength (Charpy, 23°C)	45 / 40	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	40 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	5 / 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)	200 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Melt Index (MVR)	55 / *	cm ³ /10min	ISO 1133
MVR temperature	275 / *	°C	-
MVR load	5 / *	kg	-
Shrinkage (lengthwise, 24h)	0.2 - 0.4	%	ISO 294-4
Shrinkage (lateral, 24h)	0.6 - 0.8	%	ISO 294-4
Physical Properties			
Density	1370 / -	kg/m ³	ISO 1183
Flammability			
Flammability (1.5 mm)	HB / *	class	UL 94