

## Technical Data Sheet



### ALTECH PA6 A 2015/310 GF15 IM

Base Polymer	Polyamide 6
Filler/Additive System	15 % glass fibres
Colour	black,natural color,white
Special Features	impact modified,heat stabilised,injection moulding grade,nucleated,processing stabilised
Market Segment	Machinery,electrical and electronic,Automotive
Application Area	power tools,injection moulded parts,interior decoration / finishing,exterior parts
Typical Applications	housings,operating elements,impact protection / shock absorber,functional components

Pre-Drying Conditions      80 °C in a dry air (desiccant) 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
<b>Mechanical Properties</b>			
Flexural Modulus	3800 / -	MPa	ISO 178
Flexural Strength	130 / -	MPa	ISO 178
Tensile Modulus	4600 / -	MPa	ISO 527
Tensile Strength at Break	84 / -	MPa	ISO 527
Tensile Elongation at Break	4.5 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	65 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Impact Strength (Charpy, -40°C)	80 / -	kJ/m <sup>2</sup>	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	20 / -	kJ/m <sup>2</sup>	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	8.5 / -	kJ/m <sup>2</sup>	ISO 179/1eA
<b>Thermal Properties</b>			
HDT / A (1,8 MPa)	190 / *	°C	ISO 75-1/-2
DSC (Melt Point)	221 / *	°C	ISO 11357
<b>Rheological Properties</b>			
Shrinkage (lengthwise, 24h)	0.3 - 0.5	%	ISO 294-4
Shrinkage (lateral, 24h)	0.7 - 0.9	%	ISO 294-4
<b>Physical Properties</b>			
Density	1190 / -	kg/m <sup>3</sup>	ISO 1183