WEROMID® PA6 GF30 NW NAT

WEROMID®
Engineering compounds

Polyamide 6
with glass fibers, natural color

Physical properties		Test method	Specimen	Units	Typical value
Specific gravity		ISO 1183-3		g/cm³	1,35
Water absorption	23°C / 24h	ISO 62	MPTS ISO 3167 A	%	<1,3
Linear mould shrinkage		DIN 16742	MPTS ISO 3167 A	%	0,2-0,7
Mechanical properties at 23°C / 50% rh					
Tensile strength	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	MPa	160
Elongation at maximum force	dry, @50 mm/min	ISO 527	MPTS ISO 3167 A	%	3,3
Modulus of elasticity	dry, @1 mm/min	ISO 527	MPTS ISO 3167 A	GPa	9,3
Charpy impact strength	dry	ISO 179 1eU	80x10x4mm	kJ/m²	80
Charpy impact strength	dry		80x10x4mm	kJ/m²	80
Charpy impact strength, notched	dry	ISO 179 1eA	80x10x4mm	kJ/m²	12
Thermal properties					
Melting temperature	DSC	ISO 11357	molded sample	°C	220

Main features

Strong, stiff parts.

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Recommended processing parameters

Predrying		
It is advisable to predry the granulate with a suitable dryer immediately before processing. The granulate may absorb moisture from the environment.		
Dryer type	Temperature °C	Drying time in h
Dehumidifying dryer	75	10 - 16
or	105	4 - 6
Processing		
Zone 1	°C	250 - 270
Zone 2	°C	270 - 290
Zone 3	°C	280 - 300
Nozzle	°C	270 - 280
Mold	°C	70 - 110
Melt temperature	°C	270

In general this product can be processed on conventional injection moulding machines while observing the usual technical guidelines. Any added fibrous materials or fillers may have an abrasive effect. In this case the cylinder and screw should be protected against wear as is usual in the processing of reinforced thermoplastic materials. Lengthy dwell times for the melts in the cylinder should be avoided. Lower the temperatures during interruptions!

Delivery form & storage

Unless indicated otherwise, the material is delivered as 3mm long pellets in sealed bags on pallets. Preferably storage should be effected in dry and normally temperatured rooms.

Additional information

During processing the moisture level should not exceed 0.05%, otherwise molecular degradation and surface defects (e.g. smearing) may occur. Excessively high predrying temperatures may cause discoloration. The processing notes provided merely represent a recommendation for general use. Due to the large variety of machines, geometries and volumes of parts, etc., it may be necessary to employ different settings according to the specific application. Please contact us for further information.

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