TECHNICAL DATA SHEET

Witcom PA6/6G+MC, based on Polyamide 6 (PA6)

30% glass & carbon fibres, conductive

Properties	Test methods	Units	PA6/6G+MC
Physical properties			
Specific gravity	ISO 1183	g/cm^3	1,32
Water absorption at saturation, 23 °C	ISO 62	%	6,5
Humidity absorption, 23 °C/50 % r.h.	ISO 62	%	2,1
Mould shrinkage (flow direction, 3 mm)	ISO 2577	%	0,2 - 0,4
Mechanical properties			
Tensile strength (max.)	ISO 527	MPa	145
Elongation at break	ISO 527	%	2 - 4
Flexural strength	ISO 178	MPa	225
Flexural modulus	ISO 178	GPa	11,0
IZOD impact strength, notched	ISO 180/1eA	kJ/m^2	8,0
IZOD impact strength, unnotched	ISO 180/1eU	kJ/m^2	70
Thermal properties			
Heat distortion temperature (1,81 MPa)	ISO 75	°C	200
Relative temperature index, 3 mm, with impact	UL 746B	°C	95
Coefficient of linear thermal expansion	ISO 11359	$K\text{-}1 \cdot 10^{-5}$	2,9
Flammability			
Burning behaviour	ISO 1210	-	HB @ 3,0 mm
UL recognition	UL94	-	-
Electrical properties			
Surface resistivity	ASTM D257	Ω/sq	10^4 - 10^6
Comparative tracking index	IEC 60112	V	-
Glow wire rating, 1,6 mm	IEC 695-2-1	°C	750

Processing conditions (injection moulding)

Drying conditions (dehumidifying drier)	:	3 - 5 Hours @ 80 °C
Maximum allowable moisture content	:	0,10 %
Melt temperature	:	250 - 270 °C
Mould temperature	:	40 - 80 °C
Screw speed	:	0,1 - 0,2 m/s
Back pressure	:	0 - 1,0 MPa
Injection pressure	:	Keep to a minimum
Injection speed	:	Fast ram speed
Hold pressure	:	Keep to a minimum

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