

Technical Data Sheet



ALCOM PA6 900/1 GF5 GB25

Base Polymer	Polyamide 6
Filler/Additive System	5 % glass fibres, 25 % glass beads
Special Features	heat stabilised, low warpage
Market Segment	Automotive, Machinery
Application Area	injection moulded parts
Typical Applications	housings

Pre-Drying Conditions	in a dry air (dessiccant) dryer <80 °C 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	4600 / 2000	MPa	ISO 178
Flexural Strength	135 / 65	MPa	ISO 178
Tensile Modulus	4900 / 2000	MPa	ISO 527
Tensile Strength at Break	85 / 40	MPa	ISO 527
Tensile Elongation at Break	2.6 / 12	%	ISO 527
Impact Strength (Charpy, 23°C)	27 / 70	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	24 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	3.5 / 7.5	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)	165 / *	°C	ISO 75-1/-2
DSC (Melt Point)	221 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.8 - 1	%	ISO 294-4
Shrinkage (lateral, 24h)	0.9 - 1.1	%	ISO 294-4
Physical Properties			
Density	1350 / -	kg/m ³	ISO 1183