

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 (dessiccant) dryer for 2-12 h dependant on moisture content max. moisture content <0,15 %
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Processing Injection Moulding	melt temperature 270-290 °C mould temperature 80-100 °C
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Storage	dry, protected from light
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Properties	dry/cond.	Dimension	Test Norm
Mechanical Properties			
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 ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	80 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	20 / -	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	8.5 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	190 / *	°C	ISO 75-1/-2
DSC (Melt Point)	221 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.3 - 0.5	%	ISO 294-4
Shrinkage (lateral, 24h)	0.7 - 0.9	%	ISO 294-4
Physical Properties			
Density	1190 / -	kg/m ³	ISO 1183