

Technical Data Sheet



ALTECH PA6 A 2035/509 GF35

Base Polymer	Polyamide 6
Filler/Additive System	35 % glass fibres,heat stabilised
Colour	black,blue,red
Special Features	easy release (demoulding),good flow,improved surface appearance
Typical Applications	injection moulded parts

Pre-Drying Conditions	80 °C in a dry air (dessiccant) 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
Mechanical Properties			
Flexural Modulus	9500 / 0	MPa	ISO 178
Flexural Strength	265 / 0	MPa	ISO 178
Tensile Modulus	10500 / 0	MPa	ISO 527
Tensile Strength at Break	170 / 0	MPa	ISO 527
Tensile Elongation at Break	3 / 0	%	ISO 527
Impact Strength (Charpy, 23°C)	80 / 0	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	60 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	12 / 0	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	9 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	210 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.2 - 0.4	%	ISO 294-4
Shrinkage (lateral, 24h)	0.6 - 0.8	%	ISO 294-4
Physical Properties			
Density	1400 / -	kg/m ³	ISO 1183