

Technical Data Sheet

**ALTECH PA6 A 2335/510 GF20 GB15 IM**

Base Polymer	Polyamide 6
Filler/Additive System	glass fibres / glass beads
Special Features	heat stabilised, impact modified, easy release (demoulding), injection moulding grade
Market Segment	various
Application Area	various, injection moulded parts, bezels, housings

Pre-Drying Conditions in a dry air (dessiccant) dryer 80-100 °C
for 2-3 h
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	6600 / -	MPa	ISO 178
Flexural Strength	190 / -	MPa	ISO 178
Tensile Modulus	7500 / -	MPa	ISO 527
Tensile Strength at Break	120 / -	MPa	ISO 527
Tensile Elongation at Break	3 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	70 / -	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	45 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	13 / -	kJ/m ²	ISO 179/1eA
Notched Impact Strength (Charpy, -40°C)	6.5 / -	kJ/m ²	ISO 179/1eA
Thermal Properties			
HDT / A (1,8 MPa)	205 / *	°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)	0.7 - 0.9	%	ISO 294-4
Physical Properties			
Density	1380 / -	kg/m ³	ISO 1183