

Technical Data Sheet



ALTECH PA6 A 3230/100 GF10 GB20

Base Polymer	Polyamide 6
Filler/Additive System	20 % glass beads,10 % glass fibres
Colour	black
Special Features	heat stabilised,easy flow,easy release (demoulding),fast solidifying,processing stabilised
Market Segment	Automotive,building and construction
Application Area	exterior parts,injection moulded parts
Typical Applications	functional components,housings,air duct

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	4800 / -	MPa	ISO 178
Flexural Strength	155 / -	MPa	ISO 178
Tensile Modulus	5800 / -	MPa	ISO 527
Tensile Strength at Break	95 / -	MPa	ISO 527
Tensile Elongation at Break	2.8 / -	%	ISO 527
Impact Strength (Charpy, 23°C)	30 / -	kJ/m ²	ISO 179/1eU
Impact Strength (Charpy, -40°C)	25 / -	kJ/m ²	ISO 179/1eU
Notched Impact Strength (Charpy, 23°C)	4 / -	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)	190 / *	°C	ISO 75-1/-2
DSC (Melt Point)	220 / *	°C	ISO 11357
Rheological Properties			
Shrinkage (lengthwise, 24h)	0.3 - 0.5	%	ISO 294-4
Shrinkage (lateral, 24h)	0.6 - 0.8	%	ISO 294-4
Physical Properties			
Density	1350 / -	kg/m ³	ISO 1183