

DOMAMID® 6G25VOEF

Polyamide 6, 25% glass fibre reinforced, flame retardant, halogen and red phosphorous free, for injection moulding.

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,34
Mold shrinkage parallel		ISO 2577	[%]	0,2 ÷ 0,4
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	8500
Tensile stress at break	5 mm/min	ISO 527	[MPa]	125
Tensile strain at break	5 mm/min	ISO 527	[%]	2,5
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	8
Hardness Rockwell		ISO 2039/2	[ScaleR]	120
THERMAL				
Melting point		ISO 11357-1	[°C]	220 ± 2
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	210
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	190
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	210
ELECTRICAL				
Volume resistivity		IEC 93	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 93	[Ω]	10 ¹³
Comparative Tracking Index (CTI)	Solution A	IEC 112	[V]	600
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	V0
Glow Wire Flammability Index (GWFI)	1 ÷ 3 mm	IEC 60695-2-12	[°C]	960
Burning rate (FMVSS)		FMVSS 302	[mm/min]	< 100

Test run at 23°C if not differently specified, DAM state (dry as moulded), valid for natural colored products

PROCESSING CONDITIONS:

Drying temperature/time	: 75÷85°C/4÷6h
Recommended melt temperature	: 240÷270 °C
Recommended mould temperature	: 90 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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