

TECHNICAL DATA SHEET



[POLYAMIDE 6 30% glass fiber reinforced pellets]

Product name: VEKTRAMID PA6 ANGF30i compound natural
Use of the product: injection molding (medium), extrusion
Company: POLIVEKTRIS, JSC
www.polivektris.lt

The compound is supplied dry and ready for use. Depending on the storage conditions between delivery and usage moisture levels can vary and have to take care of.

PROPERTIES	TEST CONDITION	UNITS	METHOD	RESULT
GENERAL PROPERTIES				
Form	-	-	-	granules/pellets
Color	-	-	-	natural
Density	23°	g/cm3	ISO 1183	~1,30
Mold Shrinkage (average)	60x60x2mm/MT 80°C	%	ISO 294	0,4-0,8
Melt Flow Rate (MFR)	-	g/10 min	ISO1133	5-10
Melting temperature	10°C/min	°C	ISO 11357-1,-3	225-245
Not cut through granules	-	%	-	<0,6
Moisture content	-	%	-	<0,4
Ash content	-	%	-	-
Filler content	-	%	ISO 3451-1	glass fiber 30%(+/-3) black masterbatch 0% Impact modifier 0% thermo stabilizer 0% lubricant <1%
PHISICAL-MECHANICAL PROPERTIES [dry/cond]				
Tensile modulus	1 mm/min	Mpa	ISO 527-2	7600/5900
Maximum tensile strength	20mm/min	Mpa	ISO 527-1,2	125/95
Elongation at break	20 mm/min	%	ISO 527-1,2	-
Charpy impact strength (UNNOTCHED)	23°	KJ/m2	ISO 179/1eU	60/45
Charpy impact strength (UNNOTCHED)	-30°	KJ/m2	ISO 179/1eU	-
Charpy impact strength (NOTCHED)	23°	KJ/m2	ISO 179/1eA	-
Izod notched impact strength	23°	KJ/m2	ISO 180-1A	-
Flexural modulus	20 mm/min	Mpa	ISO 178	6300/5600
Maximum flexural strength	20 mm/min	N (Mpa)	ISO 178	-
Rockwell hardness	-	N/mm2	ISO2039	-
THERMAL PROPERTIES				
Vicat softening temperature B	9,8N	°C	ISO 306	-
Heat deflection temperature	0,45 Mpa	°C	ISO 75-2	-
Heat deflection temperature	1,80 Mpa	°C	ISO 75-2	-
Heat resistance (ball test)	-	°C	IEC 60695-10-2	-
PROCESSING CONDITIONS				
Injection molding melt tem.	-	°C	ISO 294	-
Injection molding mold tem.	-	°C	ISO 294	70-90
Drying temperature	-	°C	-	80-100
Drying time dry air dryer	-	h	-	4

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