

DOMAMID® HCE 6LVM40

(SAMPLE SBR086)

Polyamide 6, 40% mineral filler, improved surface finish and flowability, for injection moulding.

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-MD40
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,46
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,8 - 1,0
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	0,8 - 1,0
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	6000
Tensile stress at break	5 mm/min	ISO 527	[MPa]	95
Tensile strain at break	5 mm/min	ISO 527	[%]	8
Flexural modulus	2 mm/min	ISO 178	[MPa]	5900
Flexural strength	2 mm/min	ISO 178	[MPa]	150
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	100
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	5,5
Izod impact unnotched	+23 °C	ISO 180/1U	[kJ/m ²]	95
Izod impact notched	+23 °C	ISO 180/1A	[kJ/m ²]	4,5
THERMAL				
Melting point	DSC	ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-B)	0,45 MPa	ISO 75	[°C]	195
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	100
VICAT softening temperature	50°C/h - 50N	ISO 306	[°C]	205
ELECTRICAL				
Volume resistivity		IEC 60093	[Ω·cm]	10 ¹⁵
Surface resistivity		IEC 60093	[Ω]	10 ¹³
BURNING BEHAVIOUR				
Flammability	0,8 mm	UL 94	[Class]	HB
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 / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	: 240-280 °C
Recommended mould temperature	: 90-120 °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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