

Durethan[®] ECOBG60XXF

PA6—(GF+GB)60

Injection Molding, 60% Glass Fiber/Glass Beads, Heat Stabilized, Improved flow, Low Warpage, Recycled Content

Print Date: 2024-09-17

Sustainability

Mass balanced
 Recycled based

| PROPERTIES | TYPICAL DATA | UNIT | TEST METHOD |
|---|-------------------|-------------------|----------------|
| RHEOLOGICAL PROPERTIES | | | |
| | DRY / COND | | |
| Molding shrinkage (parallel) | 0.35 / * | % | ISO 294-4 |
| Molding shrinkage (normal) | 0.4 / * | % | ISO 294-4 |
| MECHANICAL PROPERTIES | | | |
| | DRY / COND | | |
| Tensile modulus | 19000 / 12300 | MPa | ISO 527-1/-2 |
| Stress at break | 210 / 135 | MPa | ISO 527-1/-2 |
| Strain at break | 2.2 / 3.3 | % | ISO 527-1/-2 |
| Flexural modulus | 18000 / 12000 | MPa | ISO 178 |
| Flexural strength | 340 / 210 | MPa | ISO 178 |
| Charpy impact strength (+23°C) | 85 / 75 | kJ/m ² | ISO 179/1eU |
| Charpy impact strength (-30°C) | 75 / 70 | kJ/m ² | ISO 179/1eU |
| Charpy notched impact strength (+23°C) | 15 / 20 | kJ/m ² | ISO 179/1eA |
| Charpy notched impact strength (-30°C) | 15 / 15 | kJ/m ² | ISO 179/1eA |
| Izod notched impact strength (+23°C) | 15 / 20 | kJ/m ² | ISO 180/1A |
| THERMAL PROPERTIES | | | |
| | DRY / COND | | |
| Melting temperature (10°C/min) | 221 / * | °C | ISO 11357-1/-3 |
| Temp. of deflection under load (1.80 MPa) | 210 / * | °C | ISO 75-1/-2 |
| Temp. of deflection under load (0.45 MPa) | 218 / * | °C | ISO 75-1/-2 |

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Property Data

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| <i>PROPERTIES</i> | <i>TYPICAL DATA</i> | <i>UNIT</i> | <i>TEST METHOD</i> |
|--|--------------------------|-------------|----------------------|
| Coeff. of linear therm. expansion (parallel) | 0.11 / * | E-4/°C | ISO 11359-1/-2 |
| Coeff. of linear therm. expansion (normal) | 0.85 / * | E-4/°C | ISO 11359-1/-2 |
| <i>OTHER PROPERTIES</i> | <i>DRY / COND</i> | | |
| Density | 1680 / - | kg/m³ | ISO 1183 |
| <i>PROCESSING RECOMMENDATIONS</i> | <i>VALUE</i> | | |
| Drying temperature dry air dryer | 80 | °C | |
| Drying time dry air dryer | 2-6 | h | |
| Residual moisture content | 0.05-0.15 | % | acc. to Karl Fischer |
| Melt temperature (Tmin – Tmax) | 270-290 | °C | |
| Mold temperature | 80-120 | °C | |

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