

**WITCOM**

A member of Wittenburg Group

Your partner in speciality engineering plastics compounds

Preliminary Data Sheet Witcom PA6/6G-MTD

30% glass fibres, metal detectable

Latest revision: Jan. 2013

Properties	Test methods	Units	Witcom PA6/6G-MTD
Physical properties			
Specific gravity	ISO 1183	g/cm ³	1,97
Water absorption at saturation, 23 °C	ISO 62	%	6,0
Humidity absorption, 23 °C/50 % r.h.	ISO 62	%	1,8
Mould shrinkage (flow direction, 3 mm)	ISO 2577	%	0,2 - 0,4
Mechanical properties			
Tensile strength (max.)	ISO 527	MPa	205
Elongation at break	ISO 527	%	2 - 3
Flexural strength	ISO 178	MPa	305
Flexural modulus	ISO 178	GPa	15,0
IZOD impact strength, notched	ISO 180/1eA	kJ/m ²	15,0
IZOD impact strength, unnotched	ISO 180/1eU	kJ/m ²	80
Thermal properties			
Heat distortion temperature (1,81 MPa)	ISO 75	°C	200
Relative temperature index, 3 mm, with impact	UL 746B	°C	95
Coefficient of linear thermal expansion	ISO 11359	K-1·10 ⁻⁵	-
Flammability			
Burning behaviour	IEC 60695-11-10	-	HB @ 3,2 mm
UL recognition	UL94	-	-
Electrical properties			
Surface resistivity	ASTM D257	Ω/sq	-
Comparative tracking index	IEC 60112	V	-
Glow wire rating, 1,6 mm	IEC 695-2-1	°C	-
Processing conditions (injection moulding)			
Drying conditions (dehumidifying drier)	: 3 - 5 Hours @ 80 °C		
Maximum allowable moisture content	: 0,10 %		
Melt temperature	: 250 - 270 °C		
Mould temperature	: 60 - 95 °C		
Screw speed	: 0,1 - 0,2 m/s		
Back pressure	: 0 - 1,0 MPa		
Injection pressure	: Keep to a minimum		
Injection speed	: Fast ram speed		
Hold pressure	: Keep to a minimum		
Witcom Engineering Plastics BV Penningweg 52 4879 AG Etten-Leur The Netherlands			Tel.: + 31-(0) 76 - 504 30 80 Fax: + 31-(0) 76 - 504 30 81 Email: info@witcombv.nl Website: www.witcombv.nl

This information is based on our experience to date and we believe it to be reliable. It is intended as a guide for use at your discretion and risk. We cannot guarantee favourable results and assume no liability in connection with the use of the product described. None of this information is to be taken as a license to operate under, or a recommendation to infringe, any patents.