


TECHNICAL DATA SHEET [TDS]
PA6 Dinalon
REFERENCE: B2X25 G20DI-4115
PRODUCT DESCRIPTION

PA6 Dinalon, 20% Glass fibre, Dry impact, Black

PROPERTIES	UNITS	METHOD	VALUE D.A.M
Physical			
Relative density	g/cm ³	ISO 1183	1.21
Humidity	%	ISO 15512-B	< 0.25
Mould shrinkage, parallel	%	ISO 294-4	0.6
Mould shrinkage, normal	%	ISO 294-4	0.8
Mechanical			
Tensile modulus (1 mm/min)	MPa	ISO 527	5000
Stress at break (5 mm/min)	MPa	ISO 527	82
Strain at break (5 mm/min)	%	ISO 527	2.8
Flexural modulus (2 mm/min)	MPa	ISO 178	4500
Flexural strength (2 mm/min)	MPa	ISO 178	130
Charpy notched impact strength (23°C)	kJ/m ²	ISO 179/1eA	16
Charpy unnotched impact strength (23°C)	kJ/m ²	ISO 179/1eU	55
Charpy unnotched impact strength (-30°C)	kJ/m ²	ISO 179/1eU	50
Tensile Stress at yield (5mm/min)	Mpa	ISO 527	85
Thermal			
Heat deflection temperature HDT (1.80 MPa)	°C	ISO 75-A	180

UPDATE DATE

nov.-2017

The data submitted here are, to the best of Grupo Repol's knowledge, representative of the range of properties for the listed products, but should not be used to establish process limits or used as the direct basis of design. Colorants or other additives may alter these properties. The data are given for natural grade unless otherwise specified.




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PROPERTIES	UNITS	METHOD	VALUE D.A.M
Processing			
Melt temperature range	°C	-	240-270
Recommended mould temperature	°C	-	60-90
Drying temperature	°C	-	80
Drying time	h	-	2 - 4

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