FCMID®

FCM

FCMID DATA SHEET

PA6I/6T+60%GF　牌号:FCMID HT3G-6 FWA BK9225

ISO：6I/6T,ASTM:PPA

FCMID HT3G-6 FWA BK9907 is a 60% glass fibre reinforced engineering thermoplastic material based on a combination of semi crystalline polyamide with partially aromatic polyamideand suitable for all engineering thermoplastic applications with the requirement of approvals in contact with food and/or drinking water ,Good surface finish and good chemical resistance for injection moulding, Black

General

Feature	High stiffness and Strength dimensional stability, Low warpage,,Good surface finish
Polymer type	> 6I/6T+ 60 % GF <
Processing technology	Injection molding
Certification	RoHS REACH

Product identification

ISO 1043 abbreviation	> 6I/6T+ 60 % GF <
ISO 16396 designation	FCMID HT3G-6 FWA BK9225

Physical properties	Condition	Standard	Unit	Value
Density		ISO1183	g/cm³	1.72
Water absorption	23°C/sat.	ISO 62	%	1.3
Molding shrinkage, parallel		ISO294-4（2mm）	%	0.05-0.10
Molding shrinkage, normal		ISO294-4（2mm）	%	0.30-0.50

Mechanical properties				dam / cond.*
Tensile E-Modulus	1.0mm/min	ISO527	MPa	21500/21000
Stress at break	50mm/min	ISO527	MPa	260/235
Strain at break	50mm/min	ISO527	%	2.0/2.5
Flexural modulus, ISO 178	2.0 mm/min	ISO178	MPa	19000/17500
Flexural strength, ISO 178	2.0 mm/min	ISO178	MPa	375/365
Charpy impact strength, +23°C	+23°C	ISO179	kJ/m²	80/80
Charpy notched impact strength, +23°C	+23°C	ISO179	kJ/m²	15/16

	Condition	Standard	Unit	Value
Thermal properties				
Melting temperature, 10 °C/min		ISO11357	°C	260
Temp. of deflection under load, 1.80 MPa		ISO75	°C	235
Electrical properties				
Comparative tracking index		IEC60112	V	600
Burning behaviour				
Burning rate, FMVSS, Thickness 0.75mm		UL94		HB
Burning rate, FMVSS, Thickness 1.5mm		UL94		HB
Burning rate, FMVSS, Thickness 3.0mm		UL94		HB

Test run at 23°C if not differently specified, DAM state (dry as moulded).

*: conditioned according to ISO 1110

Processing conditions

Drying temperature/ time	120°C /4 h
Recommended melt temperature	280-300°C
Recommended mould temperature	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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