

Product Description

Polyamide 6 – Glass Reinforced, 30%

Product Applications

Automotive: Handle, Grab Handle, Roof handle, Sleeve, Inverter Parts
Electrical & Electronic: MCB, RCCB, Switch Parts, Terminal Block, Relay

General

Material Status	• Commercial : Active
Filler/Reinforcement	• Glass Reinforced, 30%
Forms	• Pellets
Additive	• Mold Release
Feature	• ROHS compliance
Appearance/Color	• Black
Processing Method	• Injection molding

	Typical Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Melt Flow Index at 235 ^o C/2.16kg	6	gm/10 min	ISO 1133

Mechanical	Typical Value	Unit	Test Method
Tensile Stress at Break	160	MPa	ISO 527
Tensile Strain at Break	4	%	ISO 527
Tensile Modulus	10200	MPa	ISO 527
Flexural Strength	245	MPa	ISO 178
Flexural Modulus	8100	MPa	ISO 178
IZOD Impact Strength (23 ^o C)			
Notch	10	KJ/M ²	ISO 180
Unnotch	85		

Thermal	Typical Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa Unannealed	215	°C	ISO 75
1.8 MPa Unannealed	200		

Electrical	Typical Value	Unit	Test Method
Volume Resistivity	10 ¹⁴	Ohm cm	IEC 60093
Surface Resistivity, ROA	10 ¹³	Ohm	IEC 60093

Injection Molding – XU230BB11**Drying Conditions**

Drying Time(hour)	Temperature	Remarks
3-4	85-90°C	Temperature should not be more than 90°C to avoid discoloration Moisture content after drying should be <0.2% Avoid sudden cooling of dry pellet

Injection Molding Temperatures (°C)

Mold	Melt	Nozzle	Centre	Feed zone
55 – 80	240 – 265	235 -255	235 -250	230-250

Physical form and storage

ESTOPLAST XU is supplied in pellet form. It should be pre-dried as per the guideline mentioned above prior to molding. Standard packing size is 25kg. In order to prevent moisture pick up and contamination, supplied packaging should be kept closed and undamaged.

Product Safety

ESTOPLAST XU is thermally stable up to 350°C and does not give rise to hazardous material due to degradation or evolution of gases and vapors. ESTOPLAST XU decomposes above 400°C and gives carbon dioxide and water on charring.

For more information on safety, refer individual product MSDS. Available on request.

Note

All information supplied in this publication is based on our current knowledge and experience. The data provided fall within the normal range of product properties and relate only to the specific material designed. The data provided should not be used to establish specification limits or used alone as the basis of design. ESTER assumes no liability and makes no warranties of any kind, expressed or implied, whatsoever in respect of application, processing or use made of aforementioned information or product.