

SCANAMID 6

B12 ^ F30

Features: Medium flow

Fillers: Glass fiber

Feature	Value	Unit	Testmethod
PHYSICAL PROPERTIES			
Density	1,36	g/cm ³	ISO 1183
Viscosity	--	Pas	--
MECHANICAL PROPERTIES			
Flexural modulus at +23°C	8800 (5600)	MPa	ISO 178
Maximum flexural strength	240 (150)	MPa	ISO 178
Maximum tensile strength	170 (125)	MPa	ISO 527-2
Elongation at break	3 (5)	%	ISO 527-2
Elongation at yield	--	%	ISO 527-2
IMPACT PROPERTIES			
Impact strength	--	--	--
Notched Charpy at +23°C	10 (14)	kJ/m ²	ISO 179
Notched Charpy at -20°C	8	kJ/m ²	ISO 179
Unnotched Charpy at +23°C	65 (70)	kJ/m ²	ISO 179
Unnotched Charpy at -20°C	--	kJ/m ²	ISO 179
THERMAL PROPERTIES			
Heat Distortion Temperature	--	--	--
HDT 120°C/h at 455kPa (B)	215	°C	ISO 75/1
HDT 120°C/h at 1820kPa (A)	205	°C	ISO 75/1
Softening temperature	--	--	--
Vicat 50°C/h at 9,81N (A)	--	°C	ISO 306
Vicat 50°C/h at 49,05N (B)	>200	°C	ISO 306
FLAMMABILITY PROPERTIES			
Flammability	--	--	--
GWFI at 2 mm	650	°C	IEC 60695-2-12
UL94 at 1.6 mm	HB	--	UL94
HARDNESS			
Hardness Shore D (15 s)	80	Shore D	ISO 7619-1
ADDITIONAL INFORMATION			
"^" = additive# 0-9, no effect on material prop.	--	--	--
Filler content	30	±2%	ISO 3451
Mould shrinkage (with flow)	0,3	%	Polykemi
Mould shrinkage (across flow)	0,9	%	Polykemi

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Feature	Value	Unit	Testmethod
PROCESS INSTRUCTIONS			
Drying time	2-8	h	--
Drying temperature	75	°C	--
Maximal moisture content	< 0,1	%	--
Melt temperature	260-290	°C	--
Mould temperature	70-100	°C	--
Peripheral screw speed	250-450	mm/s	--
Back pressure	60-100	bar	--

Values within (): 23°C, 50% RH, 24h

Further material information is available upon request

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