

ISSUED: 25/11/2020

ISO 9001 CERTIFIED

Promyde B300 P2 G30 U0 H is a High Flow, Heat Stabilized Polyamide 6 with 30% Glass Fibre reinforce. Its flame-retardant system enhances its flame behaviour to V0-UL94 rated category, 960°C GWFI and GWIT up to 825°C.

PROPERTIES	CONDITIONS	TEST METHOD	UNITS	VALUES
<b>PHYSICAL PROPERTIES</b>				
Density	23 °C	ISO 1183	g/cm <sup>3</sup>	1,60
Moisture absorption	23 °C	ISO 62	%	1,5
Water absorption	23 °C	ISO 62	%	4,5
<b>FLAMMABILITY</b>				
Flammability	0,8 mm	UL-94	Class	V-0
	1,5 mm			V-0
	3 mm			V-0
Glow wire flammability index	1,5 mm	IEC 60695-2-12,13	°C	960
Glow wire ignitability temperature	1,5 mm	IEC 60695-2-12,13	°C	825
<b>PROCESSING CONDITIONS</b>				
Melt temperature, injection moulding			°C	250 - 280
Mould temperature			°C	40 - 80
Moulding Shrinkage	longitudinal		%	0,2 - 0,4
	transversal		%	0,7 - 0,9
<b>MECHANICAL PROPERTIES (dry/cond.)*</b>				
Tensile modulus	23 °C, 1 mm/min	ISO 527-1/-2	MPa	10.300 / 6.800
Tensile strength	23 °C, 50 mm/min	ISO 527-1/-2	MPa	155 / 105
Elongation at break	23 °C, 50 mm/min	ISO 527-1/-2	%	2,5 / 5,5
Flexural modulus	23 °C, 2 mm/min	ISO 178	MPa	8.800 / -
Flexural strength	23 °C, 2 mm/min	ISO 178	MPa	210 / -
Charpy unnotched impact strength	23°C	ISO 179/1eU	kJ/m <sup>2</sup>	70 / 95
Charpy notched impact strength	23°C	ISO 179/1eA	kJ/m <sup>2</sup>	10 / 13
<b>THERMAL PROPERTIES</b>				
Melting temperature (DSC)	10°C/min	ISO 3146	°C	222
Heat Deflection Temperature (HDT)	1,8 MPa	ISO 75-2	°C	180
Thermal coefficient of linear expansion	23-80°C long.	ISO 11359-1/-2	10 <sup>-4</sup> /K	0,2
	23-80°C transv.			0,6
<b>ELECTRICAL PROPERTIES (dry/cond.)*</b>				
Dielectric constant	1MHz	IEC 60250	-	3,5 / 10,0
Dissipation factor	1 MHz	IEC 60250	10 <sup>-4</sup>	120 / 750
Volume resistivity		IEC 60093	Ω.m	10 <sup>13</sup> / 10 <sup>10</sup>
Surface resistivity		IEC 60093	Ω	10 <sup>13</sup> / 10 <sup>10</sup>
Comparative tracking index		IEC 60112		325

\* dry = dry as moulded / cond.= conditioned according to ISO 1110

### CHARACTERISTICS

**Promyde B300 P2 G30 U0 H** is a High Flow Polyamide 6 with 30% Glass Fibre, high mechanical strength, heat stabilized and lubricated for **injection moulding**. Its **flame-retardant** system enhances its flame behavior to **V0-UL94 rated category, 960°C GWFI and GWIT up to 825°C**.

### APPLICATIONS

**Promyde B300 P2 G30 U0 H** allows a **fast and efficient mould filling, and an easy mould release**, that combined with its **excellent mechanical properties**, and its **flame-retardant** properties make it suitable for components specially used in electrical and electronics industries.

### FORMAT AND STORAGE

**Promyde B300 P2 G30 U0 H** is supplied in moisture-proof packaging. Typical formats are Big Bag, octabin, and 25kg bags. All containers are perfectly sealed. The product should be stored in a dry place and opened just before processing.

### PROCESSING GUIDELINES

#### Drying

Material is supplied ready to process with low moisture content. When moisture absorption is prevented, drying is not required. When drying is necessary, conditions are:

Drying temperature  $\leq 80$  °C

Drying time: 4-6 hours

#### Injection moulding

The recommended processing parameters for injection moulding are:

Melt temperature: 250-280°C

Mould temperature: 40-80 °C

Injection speed: medium to high

Back pressure: moderate

#### Shrinkage

The shrinkage of a moulded part is influenced by wall thickness, mould gating, and moulding conditions.

#### Moisture

A particular characteristic of unreinforced polyamide 6 is its combination of moderate tensile and flexural strength with rigidity, good impact strength, and friction resistance. However, when a moulded part absorbs moisture, tensile and flexural strength decrease and toughness increases.

### NOTE

All recommendations are based on knowledge and experience; The values have been established on standardized tests. The figures should be regarded as guide values and not as binding minimum values. As many factors may affect processing or applications, we recommend that customers make their own tests to determine the suitability of a product for its particular use.