PA6 MF (mineral filled)

General Properties	Test Method	Typical Values
Bulk Density / kg/m³	DIN EN ISO 60	600
Printed Part Density / kg/m³	DIN EN ISO 1183-1	1440
Mean particle size d50 / µm	Laser Diffraction	65-75
Melting Temperature / °C	ISO 11357 (20 K/min)	219
Crystallization Temperature / °C	ISO 11357 (20 K/min)	174
Melt Volume Flow Rate / cm³/10min	ISO 1133 (240 °C, 2.16 kg)	7

Thermal Properties	Test Method	Typical Values
HDT/A (1.8 MPa) / °C	ISO 75-2	121
HDT/B (0.45 MPa) / °C	ISO 75-2	209
Vicat/A (10 N) / °C	ISO 306	217
Vicat/B (50 N) / °C	ISO 306	210

Mechanical Properties	Test Method	Typical Values X-direction		Typical Values Z-direction	
		Dry[1]	Cond.[2]	Dry[1]	Cond.[2]
Tensile Strength / MPa	ISO 527-2	91	62	50	40
Tensile Modulus / MPa	ISO 527-2	6250	3300	5900	3100
Tensile Elongation at break / %	ISO 527-2	2.1	7.0	0.9	1.6
Flexural Modulus / MPa	DIN EN ISO 178	6000	2750	5400	2600
Charpy Impact Strength (notched) / kJ/m²	ISO 179-1	2.7	3.1	1.9	2.3
Charpy Impact Strength (unnotched) / kJ/m²	ISO 179-1	13.2	27.8	4.6	3.9
Izod Impact Strength (notched) / kJ/m²	ISO 180	4.2	4.4	2.8	3.6
Izod Impact Strength (unnotched) / kJ/m²	ISO 180	13.1	24.1	5.1	4.6