GM	WORLDWIDE ENGINEERING STANDARDS	Material Specification	GMW16864

Polyamide High Heat Resistant – Glass Fiber Reinforced, Heat Stabilized, Flame Retardant

1 Scope

1.1 Material Description. This standard covers the properties of a glass fiber reinforced, heat stabilized, flame retardant, high temperature capable polyamide, which is used in injected form for molded components.

1.2 Symbols. The material abbreviations according to ISO 11469 are shown in Table 1.

1.3 Applicability. Typical applications include engine covers.

1.4 Remarks. The classification into groups is according to the different ranges of glass fiber content. Additional glass ranges will be added as they become necessary.

2 References

Note: Only the latest approved standards are applicable unless otherwise specified.

2.1 External Standards/Specifications.

ASTM D3801	ISO 188	ISO 527-2	ISO 11469
ASTM D6869	ISO 294	ISO 1183	ISO 15512
ISO 75	ISO 527	ISO 1874-2	UL 94
ISO 179/1eA	ISO 527-1	ISO 3451	

2.2 GM Standards/Specifications.

GMW3013	GMW3221	GMW14335
GMW3059	GMW14270	

3 Requirements

3.1 Requirements on Test Specimens. Reference GMW3221.

3.2 Requirements on Delivery. Important physical, mechanical and thermal properties that characterize the material are summarized in charts. The color shall be specified on drawings, in material specifications and otherwise.

Unless otherwise specified, injection molding of test specimens shall be accomplished per ISO 294 with the conditions for injection molding from ISO 1874-2.

All values indicated herein are based on material considered to be in the dry-as-molded state with moisture content of 0.2% maximum (ASTM D6869, ISO 15512, Method A, Method B, or GMW14335). Immediately after molding, specimens shall be sealed in moisture-proof containers and stored at +23 °C ± 2 °C for at least 24 h prior to test as specified in ISO 1874-2. All tests shall be performed on unannealed specimens immediately after their removal from the containers in a controlled atmosphere per GMW3221, Code A, unless otherwise specified. In addition, tests specified at temperatures below or above 23 °C ± 2 °C shall be conducted at the specified temperature using specimens conditioned at the specified temperature for 4 h minimum.

The minimum values specified in the property tables must be met by test specimens in natural, black, or in a standard sampled color if natural or black are not available.

3.2.1 Compound Properties (Natural, Black and Integrally Colored). See Table 1. The following are also required for full standard approval. The minimum number of lots per test required is one (1) in natural:

- Poisson's Ratio
- Coefficient of Linear Thermal Expansion (CLTE)

© Copyright 2017 General Motors Company All Rights Reserved

Documents
Document Sharing Hub

Copyright General Motors Company
Provided by IHS Markit under license with General Motors Company
Reproduction, distribution or publication of these standards is expressly prohib
Licensee=/, User=,
Not for Resale,
Full document details: GMW GMW16864 2017

- Mold Shrinkage
- Stress Strain Curve at multiple temperatures (e.g., -30 °C, +23 °C, +85 °C, +100 °C, +125 °C, +150 °C, +175 °C), Shear Modulus Curve

See GMW3013 for the test procedures.

3.3 Performance Requirements. Performance requirements shall be specified on part drawings or in component specifications.

3.4 All materials supplied to this standard must comply with GMW3059, **Restricted and Reportable Substances**, including the requirement to submit a full material composition disclosure to GM via the International Material Data System (IMDS) or via a completed GMW3059 report form.

Table 1: Compound Properties (Natural and Black)

			Glass Fiber Reinforcement Percentage
			15%
Property	**Standard**	**Units**	**Value**
ISO Symbol	ISO 11469		>PA-(GF15+MXX)<
Ash Note 1	ISO 3451	%	13 to 35
Density Note 2	ISO 1183	g/cm^3	Target Range 1.40 to 1.60
Moisture Content	ISO 15512 Method A, Method B, or GMW14335	%	≤ 0.2
Tensile Modulus	ISO 527-1, ISO 527-2	MPa	5000 to 8500
Tensile Stress at Break	ISO 527-1, ISO 527-2	MPa	≥ 90
Tensile Stress at Break after Heat Aging Note 3	ISO 188 ISO 527	% Retention	≥ 65
Tensile Strain at Break	ISO 527-1, ISO 527-2	%	≥ 2.0
Notched Charpy Impact Strength At +23 °C At -30 °C	ISO 179/1eA	kJ/m^2	≥ 3.0 ≥ 3.0
Notched Charpy Impact after Heat Aging Note 4	ISO 188 ISO 179/1eA	% Retention	≥ 65
Heat Deflection Temperature under Load 1.8 MPa	ISO 75	°C	≥ 170
Flammability Rating (0.8 mm)	UL 94 ASTM D3801	Rating	V0
Flammability Rating after (0.8 mm) Heat Aging A Note 5 Heat Aging B Note 5	UL 94 ASTM D3801	Rating	V0 V0

© Copyright 2017 General Motors Company All Rights Reserved

Documents
Document Sharing Hub
Copyright General Motors Company
Provided by IHS Markit under license with General Motors Company
Reproduction, distribution or publication of these standards is expressly prohib
Licensee=/, User=,
Not for Resale,
Full document details: GMW GMW16864 2017