

SAXAMID™ 136F4Q32

Polyamide 6

SAX Polymers

Message:

SAXAMID 136F4Q32 is a high impact-modified polyamide 6 injection-molding-grade reinforced with 20% glass fibres.

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Additive	Impact Modifier		
Features	High Impact Resistance		
	Impact Modified		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.19	g/cm ³	ISO 1183
Viscosity Number (H2SO4 (Sulphuric Acid))	150	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4800	MPa	ISO 527-2/1
Tensile Stress (Break)	80.0	MPa	ISO 527-2/5
Tensile Strain (Break)	3.3	%	ISO 527-2/5
Flexural Modulus ¹	3700	MPa	ISO 178
Flexural Stress ²	132	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	14	kJ/m ²	
23°C	18	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	76	kJ/m ²	
23°C	75	kJ/m ²	
Notched Izod Impact Strength			ISO 180/1A
-30°C	13	kJ/m ²	
23°C	17	kJ/m ²	
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	79	kJ/m ²	
23°C	78	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature ³ (1.8 MPa, Unannealed, 60.0 mm Span)	178	°C	ISO 75-2/A
Vicat Softening Temperature	185	°C	ISO 306/B120

Injection	Nominal Value	Unit
Drying Temperature	80.0	°C
Drying Time	2.0 to 6.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	260 to 290	°C
Mold Temperature	70.0 to 90.0	°C

NOTE

1. 2.0 mm/min
2. 2.0 mm/min
3. 80*10*4mm

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Recommended distributors for this material

Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China

