Chemlon® 60GF3

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60GF3 is a 15% glass fibre reinforced nylon 6 that offers good mechanical performance and is suitable for general purpose injection moulding applications.

General Information				
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight			
Features	General			
Uses	General			
Processing Method	Injection molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.25	--	g/cm³	ISO 1183
Molding Shrinkage [1]	1.0 - 1.6	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.5	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	5500	--	MPa	ISO 527-2
Tensile Stress	105	70.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	--	%	ISO 527-2
Flexural Modulus	5000	2500	MPa	ISO 178
Flexural Stress	165	85.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	7.0	22	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	25	--	kJ/m²	ISO 179/1eU
Notched Izod Impact	5.5	--	kJ/m²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	> 190	--	°C	ISO 75-2/B
1.8 MPa, not annealed	175	--	°C	ISO 75-2/A
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	11	8.0	kV/mm	IEC 60243-1
Comparative Tracking Index	500	--	V	IEC 60112
Injection	**Dry**	**Unit**		

Drying Temperature	80.0	°C
Drying Time	20	hr
Rear Temperature	230 - 280	°C
Middle Temperature	230 - 280	°C
Front Temperature	230 - 280	°C
Processing (Melt) Temp	240 - 270	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection instructions

No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.

NOTE

1.	Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

Recommended distributors for this material

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