

# Wellamid® GF30-60 42LH-NBK1

Polyamide 6

Wellman Engineering Resins

## Message:

Wellamid® GF30-60 42LH-NBK1 is a Polyamide 6 (Nylon 6) material filled with 30% glass fiber. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding.

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.37	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	0.80 to 1.2	%	
Flow : 23°C	0.20 to 0.60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	160	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.0	%	ISO 527-2
Flexural Modulus (23°C)	8800	MPa	ISO 178
Flexural Stress (23°C)	230	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	8.0	kJ/m <sup>2</sup>	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	205	°C	ISO 75-2/A
Melting Temperature (DSC)	220	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	260 to 282	°C	
Middle Temperature	254 to 277	°C	
Front Temperature	249 to 271	°C	
Nozzle Temperature	249 to 271	°C	
Processing (Melt) Temp	254 to 282	°C	
Mold Temperature	71.1 to 93.3	°C	
Injection Pressure	34.5 to 138	MPa	
Back Pressure	0.345	MPa	
Screw Speed	30 to 120	rpm	

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### Recommended distributors for this material

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