

Chemlon® 60GSF6

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60GSF6 is a 30% mixed glass sphere and fibre filled nylon 6 that offers a good compromise between strength, dimensional stability and surface aspect.

General Information				
Filler / Reinforcement		Glass Beads \Glass Fiber, 30% Filler by Weight		
Processing Method		Injection molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.36	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.0 - 1.6	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.1	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	4800	2500	MPa	ISO 527-2
Tensile Stress	110	70.0	MPa	ISO 527-2
Tensile Strain (Break)	5.0	--	%	ISO 527-2
Flexural Modulus	5500	2800	MPa	ISO 178
Flexural Stress	155	60.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	6.0	12	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	38 kJ/m ²	No Break		ISO 179/1eU
Notched Izod Impact	4.0	--	kJ/m ²	ISO 180/A
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	200	--	°C	ISO 75-2/B
1.8 MPa, not annealed	190	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+11	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
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm, Teknor Apex test result)	HB	--		UL 94
Oxygen Index	24	--	%	ISO 4589-2

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	20	hr
Rear Temperature	240 - 280	°C
Middle Temperature	240 - 280	°C
Front Temperature	240 - 280	°C
Processing (Melt) Temp	250 - 275	°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

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).

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