

Wellamid® GF1685-WBK1

Polyamide 6

Wellman Engineering Resins

Message:

Wellamid® GF1685-WBK1 is a Polyamide 6 (Nylon 6) material filled with 20% glass fiber. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding.

Typical application of Wellamid® GF1685-WBK1: Automotive

General Information			
Filler / Reinforcement	Glass Fiber,20% Filler by Weight		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.28	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	0.70 to 1.1	%	
Flow : 23°C	0.30 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	145	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.0	%	ISO 527-2
Flexural Modulus (23°C)	6300	MPa	ISO 178
Flexural Stress (23°C)	205	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	6.0	kJ/m ²	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	65.6 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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