

PPR PA603

Polyamide 6
Premier Plastic Resins, Inc.

Message:
Reprocessed Nylon 6 13% Glass Fiber Reinforced

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 13% filler by weight		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.22	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.60	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Yield)	82.8	MPa	ASTM D638
Tensile Elongation (Break)	3.0	%	ASTM D638
Flexural Modulus - Tangent	3790	MPa	ASTM D790
Flexural Strength	124	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, not annealed	213	°C	ASTM D648
1.8 MPa, not annealed	193	°C	ASTM D648
Injection	Nominal Value	Unit	
Drying Temperature	71.0 - 82.0	°C	
Drying Time	2.0 - 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	238 - 282	°C	
Middle Temperature	249 - 293	°C	
Front Temperature	249 - 293	°C	
Nozzle Temperature	243 - 288	°C	
Processing (Melt) Temp	254 - 299	°C	
Mold Temperature	66.0 - 93.0	°C	
Injection Pressure	14.0 - 103	MPa	
Injection Rate	Moderate-Fast		
Holding Pressure	10.0 - 83.0	MPa	
Back Pressure	0.00 - 1.00	MPa	
Cushion	6.35 - 12.7	mm	
Injection instructions			

Screw Speed: Slow-ModerateDecompression: 3.81 to 7.6 mm

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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

