

# Rhelon F1020H-01

Polyamide 6

RheTech, Inc.

## Message:

Rhelon F1020H-01 is a Polyamide 6 (Nylon 6) product filled with glass\mineral. It can be processed by injection molding and is available in North America. Primary characteristic: heat stabilizer.

| General Information                                      |                   |                   |             |
|--|-------------------|-------------------|-------------|
| Filler / Reinforcement                                   | Glass\Mineral     |                   |             |
| Additive   | Heat Stabilizer   |                   |             |
| Features   | Heat Stabilized   |                   |             |
| Appearance   | Black             |                   |             |
| Processing Method  | Injection Molding |                   |             |
| Physical   | Nominal Value     | Unit              | Test Method |
| Specific Gravity   | 1.26              | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow                                 | 0.20 to 0.40      | %                 | ASTM D955   |
| Mechanical   | Nominal Value     | Unit              | Test Method |
| Tensile Strength   | 93.8              | MPa               | ASTM D638   |
| Tensile Elongation                                       |                   |                   | ASTM D638   |
| Yield  | 2.5               | %                 |             |
| Break  | 2.5               | %                 |             |
| Flexural Modulus   | 5050              | MPa               | ASTM D790   |
| Flexural Strength  | 152               | MPa               | ASTM D790   |
| Impact   | Nominal Value     | Unit              | Test Method |
| Notched Izod Impact (23°C)                               | 37                | J/m               | ASTM D256   |
| Thermal  | Nominal Value     | Unit              | Test Method |
| Deflection Temperature Under Load (0.45 MPa, Unannealed) | 179               | °C                | ASTM D648   |
| Peak Melting Temperature                                 | 216               | °C                | ASTM D789   |
| Injection  | Nominal Value     | Unit              |             |
| Drying Temperature                                       | 79.4              | °C                |             |
| Suggested Max Moisture                                   | 0.20              | %                 |             |
| Suggested Max Regrind                                    | 25                | %                 |             |
| Rear Temperature   | 218 to 235        | °C                |             |
| Middle Temperature                                       | 246 to 257        | °C                |             |
| Front Temperature  | 246 to 268        | °C                |             |
| Nozzle Temperature                                       | 246 to 268        | °C                |             |
| Processing (Melt) Temp                                   | 249 to 266        | °C                |             |

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