

SAXAMID™ 136F3Q32

Polyamide 6

SAX Polymers

Message:

SAXAMID 136F3Q32 is a high-impact-modified polyamide 6 injection-molding-grade reinforced with 15 % glass fibres with very high impact properties. Beside the extraordinary high impact strength at low temperatures this grade shows very good processability.

General Information			
Filler / Reinforcement	Glass Fiber,15% Filler by Weight		
Additive	Impact Modifier		
Features	Good Processability		
	High Impact Resistance		
	Impact Modified		
	Low Temperature Impact Resistance		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.17	g/cm ³	ISO 1183
Viscosity Number (H2SO4 (Sulphuric Acid))	150	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	5000	MPa	ISO 527-2/1
Tensile Stress (Break)	65.0	MPa	ISO 527-2/50
Tensile Strain (Break)	5.0	%	ISO 527-2/50
Flexural Modulus ¹	3300	MPa	ISO 178
Flexural Stress ²	120	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179/1eA
-30°C	14	kJ/m ²	
23°C	16	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179/1eU
-30°C	65	kJ/m ²	
23°C	75	kJ/m ²	
Notched Izod Impact Strength			ISO 180/1A
-30°C	13	kJ/m ²	
23°C	17	kJ/m ²	
Unnotched Izod Impact Strength			ISO 180/1U
-30°C	61	kJ/m ²	
23°C	69	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method

Heat Deflection Temperature ³ (1.8 MPa, Unannealed, 60.0 mm Span)	173	°C	ISO 75-2/A
Vicat Softening Temperature	185	°C	ISO 306/B120
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	2.0 to 6.0	hr	
Suggested Max Moisture	0.20	%	
Processing (Melt) Temp	260 to 290	°C	
Mold Temperature	70.0 to 90.0	°C	
NOTE			
1.	2.0 mm/min		
2.	2.0 mm/min		
3.	80*10*4mm		

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