

Generic Nylon 610 - Glass Fiber

Polyamide 610

Generic

Message:

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This information is provided for comparative purposes only.

General Information			
Filler / Reinforcement	Glass fiber reinforced material		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
--	1.14 - 1.56	g/cm ³	ASTM D792
23°C	1.18 - 1.57	g/cm ³	ISO 1183
Molding Shrinkage			
Flow: 23°C	0.19 - 0.42	%	ASTM D955
Transverse flow: 23°C	0.70 - 1.0	%	ASTM D955
23°C	0.15 - 1.1	%	ISO 294-4
Water Absorption			
23°C, 24 hr	0.20 - 0.23	%	ASTM D570
Equilibrium, 23°C, 50% RH	0.29 - 0.61	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus			
23°C	8140 - 12500	MPa	ASTM D638
23°C	4740 - 14500	MPa	ISO 527-2
Tensile Strength			
Fracture, 23°C	82.7 - 179	MPa	ASTM D638
Fracture, 23°C	107 - 204	MPa	ISO 527-2
23°C	116 - 166	MPa	ASTM D638
Tensile Elongation			
Yield, 23°C	2.5 - 3.5	%	ASTM D638
Fracture, 23°C	2.0 - 4.3	%	ASTM D638
Fracture, 23°C	2.5 - 5.5	%	ISO 527-2
Flexural Modulus			
23°C	3930 - 10900	MPa	ASTM D790
23°C	7110 - 13800	MPa	ISO 178
Flexural Strength			
23°C	121 - 273	MPa	ASTM D790
23°C	195 - 311	MPa	ISO 178
Coefficient of Friction	0.18 - 0.71		ASTM D1894
Impact	Nominal Value	Unit	Test Method

Charpy Notched Impact Strength (23°C)	5.0 - 20	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	75 - 100	kJ/m ²	ISO 179
Notched Izod Impact			
23°C	46 - 360	J/m	ASTM D256
23°C	12 - 16	kJ/m ²	ISO 180
Unnotched Izod Impact			
23°C	370 - 1200	J/m	ASTM D256
23°C	65 - 74	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, not annealed	210 - 224	°C	ASTM D648
0.45 MPa, not annealed	210 - 220	°C	ISO 75-2/B
1.8 MPa, not annealed	210 - 218	°C	ASTM D648
1.8 MPa, not annealed	190 - 205	°C	ISO 75-2/A
Melting Temperature	220	°C	ISO 11357-3
Linear thermal expansion coefficient			
Flow	2.6E-5 - 4.0E-5	cm/cm/°C	ASTM D696
Flow	1.7E-5 - 6.7E-5	cm/cm/°C	ISO 11359-2
Lateral	4.0E-5 - 1.1E-4	cm/cm/°C	ISO 11359-2
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity (23°C)	4.6E+2 - 2.5E+14	ohms · cm	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	78.8 - 82.5	°C	
Drying Time	2.0 - 4.1	hr	
Suggested Max Moisture	0.16 - 0.20	%	
Rear Temperature	254 - 275	°C	
Middle Temperature	265 - 275	°C	
Front Temperature	274 - 277	°C	
Processing (Melt) Temp	256 - 288	°C	
Mold Temperature	58.6 - 93.3	°C	
Injection Pressure	96.5 - 103	MPa	
Back Pressure	0.258 - 0.517	MPa	
Screw Speed	45 - 55	rpm	
Injection instructions			

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