Chemlon® E-6 GF15

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

Chemlon® E-6 GF15 is an economy range 15% glass fibre reinforced Nylon 6 compound.
It is available in natural or black versions.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight		
Appearance	Black Natural color		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.24	g/cm³	ISO 1183
Molding Shrinkage [1]	0.60 - 1.0	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.3	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	5500	MPa	ISO 527-2
Tensile Stress (Break)	105	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	5000	MPa	ISO 178
Flexural Stress [2]	150	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Notched Izod Impact	5.0	kJ/m²	ISO 180
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	> 190	°C	ISO 75-2/B
1.8 MPa, not annealed	175	°C	ISO 75-2/A
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0	°C	
Drying Time	2.0	hr	
Rear Temperature	230 - 260	°C	
Middle Temperature	230 - 260	°C	
Front Temperature	230 - 260	°C	
Processing (Melt) Temp	< 300	°C	
Mold Temperature	80.0 - 90.0	°C	
Injection Rate	Fast		
Screw Speed	50 - 200	rpm	
Injection instructions			

Back pressure: LowInjection pressure: HighThe material is supplied dry and ready to mould in sealed, moisture proof sacks. No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present. Should drying become necessary, two hours at 80°C in a dehumidifying drier is recommended. The use of air circulating driers is not generally recommended, as longer drying times are often required, with greater potential for product oxidation and yellowing. Drying temperatures should not exceed 80°C.

NOTE	
1.	Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions.The range values stated were determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).
2.	At Break

Recommended distributors for this material

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