

PA6GF20**¥ 1****Heat de i lection temperature**

Product Description		Applications
20%	PA6 20% glass fiber reinforced PA6	Injection molding
Good mechanical properties balance		

Properties	Test Method	Test Condition	Unit	Typical Values(dry)
Physical properties				
Specific Gravity	ISO 1183	23	g/cm ³	1.280
Ash	ISO 3451	800 ,30min	%	20
Mechanical properties				
Tensile Strength	ISO 527	5mm/min	MPa	135
Tensile Modulus	ISO 527	1mm/min	MPa	6500
Elongation at Break	ISO 527	5mm/min	%	3
Flexural Strength	ISO 178	2mm/min	MPa	215
Flexural Modulus	ISO 178	2mm/min	MPa	6000
Unnotched Charpy Impact Strength	ISO 179-1/1eU	23	kJ/m ²	45
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m ²	8
	ISO 75	1.80MPa		195
Melt Temperature	ISO 11357	DSC		220
Other properties				
		flow direction	%	0.20-0.30
		cross flow direction	%	0.90-1.10
Flammability	ISO 3795	—	mm/min	34

Note: The data above is typical value for reference, not guarantee value. The data will vary with tool design such as gate type , gate location, gate number, injection molding process and part thickness. The data will vary with different color as well. Prior to use the material, please consult with Sunway polymer.

Processing Conditions		Range
Melt Temperature		230-260
Barrel Temperature	, Rear	220--230
	, Center	230--240
	, Front	240--250
Mold Temperature		70-100
Pre-Dry needed		110-120 , 4h-6h dehumidified dryer

Note: The above process condition is only for reference. The actual process should be adjusted according to different type of machine, mold design and product design.

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