



·30%	PA6	30% glass fiber reinforced PA6	· Injection molding	
· Good mechanical properties balance			· Godd surface	
Specific Gravity	ISO 1183	23	g/cm³	1.350
Ash	ISO 3451	800 ,30min	%	30
Tensile Strength	ISO 527	5mm/min	MPa	180
Tensile Modulus	ISO 527	1mm/min	MPa	9500
Elongation at Break	ISO 527	5mm/min	%	3
Flexural Strength	ISO 178	2mm/min	MPa	250
Flexural Modulus	ISO 178	2mm/min	MPa	8600
Unnotched Charpy Impact Strength	ISO 179-1/1eU	23	kJ/m²	80
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m²	13
Heat deflection temperature	ISO 75	1.80MPa		205
Melt Temperature	ISO 11357	DSC		220
Mold Shrinkage	internal test method	flow direction	%	0.10-0.30
		cross flow direction		0.80-1.00
Flammability	ISO 3795		mm/min	32

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.

Melt Temperature		240-270
Barrel Temperature	, Rear	240--250
	, Center	250--260
	, Front	260--270
Mold Temperature		70-100
Pre-Dry needed		110-120 , 4h-6h

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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