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PA6GF50**B109GH****SUNPOLY**

Product Description			Applications	
50%	PA6	50% 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	1.560
Ash	ISO 3451	800 ,30min	%	50
Mechanical properties				
Tensile Strength	ISO 527	5mm/min	MPa	210
Tensile Modulus	ISO 527	1mm/min	MPa	15000
Elongation at Break	ISO 527	5mm/min	%	2
Flexural Strength	ISO 178	2mm/min	MPa	350
Flexural Modulus	ISO 178	2mm/min	MPa	14000
Unnotched Charpy Impact Strength	ISO 179-1/1eU	23	kJ/m ²	100
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m ²	17
Thermal properties				
Heat Deflection Temperature	ISO 75	1.80MPa		215
Melting Point	ISO 11375	DSC		220
Other properties				
Mold Shrinkage	internal test method	flow direction	%	0.10-0.20
		cross flow direction	%	0.60-0.80
Flammability	ISO 3795	—	mm/min	30

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.

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Processing Conditions		Range
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

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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