

PA66GF60**A110GH**

Product Description		Applications		
60%	PA66 60% glass fiber reinforced PA66	Injection molding		
	Good mechanical properties balance	Excellent heat stability		
Properties	Test Method	Test Condition	Unit	() Typical Values (dry)
Physical properties				
Specific Gravity	ISO 1183	23	g/cm ³	1.69
Ash	ISO 3451	800 ,30min	%	60
Mechanical properties				
Tensile Modulus	ISO 527	1mm/min	MPa	21000
Tensile Strength	ISO 527	5mm/min	MPa	250
Elongation at Break	ISO 527	5mm/min	%	2
Flexural Strength	ISO 178	2mm/min	MPa	380
Flexural Modulus	ISO 178	2mm/min	MPa	19000
Unnotched Charpy Impact Strength	ISO 179-1/1eU	23	kJ/m ²	98
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m ²	16
Thermal properties				
Heat Deflection Temp	ISO 75	1.8MPa		252
Melting Point	ISO 11357	DSC		262
Other properties				
Mold Shrinkage	internal test method	flow direction	%	0.1-0.2
		cross flow direction	%	0.5-0.8
Flammability	ISO 3795	—	mm/min	24

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		280-300
Barrel Temperature	, Rear	280-290
	, Center	285-295
	, Front	290-300
Mold Temperature		80-100
Pre-Dry needed		100-110 ,4-6h

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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