

PA6GF10M20

B304GM



Product Description		Applications		
10% glass fiber reinforced	20% mineral filled PA6	Injection molding		
Excellent heat stability		Good mechanical properties balance		
Properties	Test Method	Test Condition	Unit	Typical Values(dry)
Physical properties				
Specific Gravity	ISO 1183	23	g/cm ³	1.35
Ash	ISO 3451	600 ,30min	%	30
Mechanical properties				
Tensile Strength	ISO 527	5mm/min	MPa	110
Elongation at break	ISO 527	5mm/min	MPa	3.5
Tensile Modulus	ISO 527	1mm/min	MPa	5800
Flexural Strength	ISO 178	2mm/min	MPa	160
Flexural Modulus	ISO 178	2mm/min	MPa	5300
Charpy Notched Impact Strength	ISO 179-1eA	23	kJ/m ²	5
Charpy Unnotched Impact Strength	ISO 179-1eU	23	kJ/m ²	35
Thermal properties				
Heat Deflection Temperature	ISO 75	1.8MPa		190
Melting Point	ISO 11357	DSC		220
Other properties				
Mold Shrinkage	internal test method	flow direction	%	0.1-0.4
		cross flow direction	%	0.6-1.0
Flammability	ISO 3795	—	mm/min	15

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		240-270
Barrel Temperature	, Rear	240--250
	, Center	255--265
	, Front	260--270
Mold Temperature		60-90
Pre-Dry needed		110-120 , 4-8h

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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