Chemlon® 60MGS6IM

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60MGS6IM is a 30% mineral & glass sphere filled, impact modified, easy flowing grade of nylon 6. It offers improved toughness at low ambient service temperatures.

General Information	
Filler / Reinforcement	Micro glass bead \mineral, 30% filler by weight
Additive	Impact modifier
Features	Impact modification Low Temperature Flexibility Good liquidity Good toughness Medium hardness

Processing Method	Injection molding			
Physical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Density	1.31	--	g/cm³	ISO 1183
Molding Shrinkage [1]	0.60 - 1.4	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	1.9	--	%	ISO 62
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Stress	76.0	--	MPa	ISO 527-2
Tensile Strain (Break)	11	--	%	ISO 527-2
Flexural Modulus	3700	1350	MPa	ISO 178
Flexural Stress	125	68.0	MPa	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Notched Izod Impact	6.0	--	kJ/m²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				
0.45 MPa, not annealed	205	185	°C	ISO 75-2/B
1.8 MPa, not annealed	66.0	62.0	°C	ISO 75-2/A
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	11	8.0	kV/mm	IEC 60243-1
Relative Permittivity	3.80	4.20		IEC 60250
Comparative Tracking Index	600	--	V	IEC 60112

Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm, Teknor Apex test result)	HB	--		UL 94
Oxygen Index	22	--	%	ISO 4589-2

Injection	Dry	Unit
Drying Temperature	80.0	°C
Drying Time	20	hr
Rear Temperature	240 - 280	°C
Middle Temperature	240 - 280	°C
Front Temperature	240 - 280	°C
Processing (Melt) Temp	250 - 275	°C
Mold Temperature	60.0 - 80.0	°C
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection instructions
No drying is necessary unless the material has been exposed to air for longer than three hours. The appearance of splash marks on the surface of mouldings indicates excessive moisture is present.

NOTE	
1.	Mould shrinkage is significantly influenced by many factors including wall thickness, gating, moulding shape and processing conditions. The range values given are determined from specimen bar mouldings of 1.5mm to 4mm wall thickness. They are provided as a guide for comparison purposes only and no guarantee should be inferred from their inclusion. (Specimens measured in the dry state, 24 hours after moulding).

Recommended distributors for this material

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