

# VENYL SWGT400H

Polyamide 6

AD majoris

## Message:

VENYL SWGT400H is a Polyamide 6 (Nylon 6) product filled with 40% glass bead\glass fiber. It can be processed by injection molding and is available in Europe.

Characteristics include:

Flame Rated

Eco-Friendly/Green

General Information				
Filler / Reinforcement		Glass Bead\Glass Fiber,40% Filler by Weight		
Features		Recyclable Material		
Forms		Pellets		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.50	--	g/cm <sup>3</sup>	ISO 1183
Molding Shrinkage	0.30 to 0.50	--	%	
Water Absorption				
Saturation, 23°C	6.0	--	%	
Equilibrium, 23°C, 50% RH	2.5	--	%	
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Stress (Break)	90.0	70.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0	3.5	%	ISO 527-2
Flexural Modulus	7800	3200	MPa	ISO 178
Flexural Stress	195	105	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	6.0	10	kJ/m <sup>2</sup>	ISO 179
Charpy Unnotched Impact Strength	40	75	kJ/m <sup>2</sup>	ISO 179
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	200	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	190	--	°C	ISO 75-2/A
Peak Melting Temperature	220	--	°C	ASTM D2117
Electrical	Dry	Conditioned	Unit	Test Method
Comparative Tracking Index	> 500	--	V	DIN 53480
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating				UL 94

1.59 mm	HB	--
3.18 mm	HB	--
Injection	Dry	Unit
Drying Temperature	100	°C
Drying Time	4.0	hr
Rear Temperature	245 to 265	°C
Middle Temperature	250 to 270	°C
Front Temperature	255 to 275	°C
Nozzle Temperature	255 to 275	°C
Mold Temperature	90.0 to 120	°C
Injection Pressure	85.0 to 110	MPa
Injection Rate	Fast	
Holding Pressure	50.0 to 70.0	MPa
Screw L/D Ratio	15.0:1.0 to 20.0:1.0	

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#### Recommended distributors for this material

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