

# SAXAMID™ 136F6Q32

Polyamide 6

SAX Polymers

## Message:

SAXAMID 136F6Q32 is a high-impact-modified polyamide 6 injection-molding-grade reinforced with 30 % glass fibres . Beside the extraordinary high impact strength at low temperatures this grade shows very good processability.

| General Information                       |                                   |                    |             |
|-------------------------------------------|-----------------------------------|--------------------|-------------|
| Filler / Reinforcement                    | Glass Fiber,30% Filler by Weight  |                    |             |
| Additive                                  | Impact Modifier                   |                    |             |
| Features                                  | Good Processability               |                    |             |
|                                           | Impact Modified                   |                    |             |
|                                           | Low Temperature Impact Resistance |                    |             |
|                                           | Ultra High Impact Resistance      |                    |             |
| RoHS Compliance                           | RoHS Compliant                    |                    |             |
| Processing Method                         | Injection Molding                 |                    |             |
| Physical                                  | Nominal Value                     | Unit               | Test Method |
| Density                                   | 1.25                              | g/cm <sup>3</sup>  | ISO 1183    |
| Viscosity Number (H2SO4 (Sulphuric Acid)) | 150                               | cm <sup>3</sup> /g | ISO 307     |
| Mechanical                                | Nominal Value                     | Unit               | Test Method |
| Tensile Modulus                           | 6800                              | MPa                | ISO 527-2/1 |
| Tensile Stress (Break)                    | 96.0                              | MPa                | ISO 527-2/5 |
| Tensile Strain (Break)                    | 4.0                               | %                  | ISO 527-2/5 |
| Flexural Modulus <sup>1</sup>             | 4800                              | MPa                | ISO 178     |
| Flexural Stress <sup>2</sup>              | 145                               | MPa                | ISO 178     |
| Impact                                    | Nominal Value                     | Unit               | Test Method |
| Charpy Notched Impact Strength            |                                   |                    | ISO 179/1eA |
| -30°C                                     | 17                                | kJ/m <sup>2</sup>  |             |
| 23°C                                      | 20                                | kJ/m <sup>2</sup>  |             |
| Charpy Unnotched Impact Strength          |                                   |                    | ISO 179/1eU |
| -30°C                                     | 85                                | kJ/m <sup>2</sup>  |             |
| 23°C                                      | 93                                | kJ/m <sup>2</sup>  |             |
| Notched Izod Impact Strength              |                                   |                    | ISO 180/1A  |
| -30°C                                     | 18                                | kJ/m <sup>2</sup>  |             |
| 23°C                                      | 21                                | kJ/m <sup>2</sup>  |             |
| Unnotched Izod Impact Strength            |                                   |                    | ISO 180/1U  |
| -30°C                                     | 78                                | kJ/m <sup>2</sup>  |             |
| 23°C                                      | 90                                | kJ/m <sup>2</sup>  |             |
| Thermal                                   | Nominal Value                     | Unit               | Test Method |

| Heat Deflection Temperature <sup>3</sup> (1.8 MPa, Unannealed, 60.0 mm Span) | 186           | °C   | ISO 75-2/A   |
|------------------------------------------------------------------------------|---------------|------|--------------|
| Vicat Softening Temperature                                                  | 187           | °C   | ISO 306/B120 |
| Injection                                                                    | Nominal Value | Unit |              |
| Drying Temperature                                                           | 80.0          | °C   |              |
| Drying Time                                                                  | 2.0 to 6.0    | hr   |              |
| Suggested Max Moisture                                                       | 0.20          | %    |              |
| Processing (Melt) Temp                                                       | 260 to 290    | °C   |              |
| Mold Temperature                                                             | 70.0 to 90.0  | °C   |              |
| NOTE                                                                         |               |      |              |
| 1.                                                                           | 2.0 mm/min    |      |              |
| 2.                                                                           | 2.0 mm/min    |      |              |
| 3.                                                                           | 80*10*4mm     |      |              |

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