Chemlon® 60MGF6

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60MGF6 is a 15% glass fibre, 15% mineral filled Nylon 6 that offers good rigidity and strength, coupled with low distortion characteristics.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 15% filler by weight Mineral filler, 15% filler by weight		
Features	Good strength Medium hardness		
Processing Method	Injection molding		
Physical	**Nominal Value**	**Unit**	**Test Method**
Density	1.37	g/cm³	ISO 1183
Molding Shrinkage [1]	1.0 - 1.5	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.1	%	ISO 62
Mechanical	**Nominal Value**	**Unit**	**Test Method**
Tensile Modulus	6000	MPa	ISO 527-2
Tensile Stress	130	MPa	ISO 527-2
Tensile Strain (Break)	5.0	%	ISO 527-2
Flexural Modulus	5000	MPa	ISO 178
Flexural Stress	170	MPa	ISO 178
Impact	**Nominal Value**	**Unit**	**Test Method**
Charpy Notched Impact Strength	6.0	kJ/m²	ISO 179/1eA
Charpy Unnotched Impact Strength	45	kJ/m²	ISO 179/1eU
Thermal	**Nominal Value**	**Unit**	**Test Method**
Heat Deflection Temperature			
0.45 MPa, not annealed	200	°C	ISO 75-2/B
1.8 MPa, not annealed	190	°C	ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Comparative Tracking Index	500	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Oxygen Index	24	%	ISO 4589-2
Injection	**Nominal Value**	**Unit**	
Drying Temperature	80.0	°C	
Drying Time	20	hr	
Rear Temperature	250 - 280	°C	

Middle Temperature	250 - 280	°C
Front Temperature	250 - 280	°C
Processing (Melt) Temp	250 - 290	°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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