

RTP VLF 80211 A

Polyamide 6

RTP Company

Message:

Long Glass Fiber

General Information			
Filler / Reinforcement	Long glass fiber, 60% filler by weight		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.69	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	0.10 - 0.20	%	ASTM D955
Moisture Content	0.20	%	
Primary Additive	60	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	21400	MPa	ASTM D638
Tensile Strength	228	MPa	ASTM D638
Tensile Elongation (Yield)	1.5 - 2.5	%	ASTM D638
Flexural Modulus	20700	MPa	ASTM D790
Flexural Strength	352	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (3.20 mm)	320	J/m	ASTM D256
Unnotched Izod Impact (3.20 mm)	1300	J/m	ASTM D4812
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm, ** Values per RTP Company testing.)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	82.2	°C	
Drying Time	2.0	hr	
Dew Point	-28.9	°C	
Processing (Melt) Temp	243 - 271	°C	
Mold Temperature	54.4 - 93.3	°C	
Injection Pressure	68.9 - 124	MPa	
Injection instructions			

Use a reverse barrel profile. To maximize fiber length, the following injection barrel, screw, and tip designs should be followed. L/D ratio 16/1 - 22/1, Compression ratio 2:1, Flight depth 0.200 in (5 mm) minimum, in feed section, Screw diameter 0.65 - 0Desiccant Type Dryer Required.

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