

VENYL SG409 - 1199

Polyamide 6

AD majoris

Message:

VENYL SG409 - 1199 is a 40% glass fibre reinforced polyamide 6 intended for Injection moulding.

APPLICATIONS

VENYL SG409 - 1199 has been developed especially for very demanding applications in automotive industry and electrical parts.

Products requiring excellent combination between thermal and mechanical properties.

General Information			
Filler / Reinforcement	Glass Fiber,40% Filler by Weight		
Features	Recyclable Material		
Uses	Automotive Applications		
	Electrical Parts		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.51	g/cm ³	ISO 1183
Molding Shrinkage	0.10 to 0.50	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	11200	MPa	ISO 527-2
Tensile Stress (Break)	172	MPa	ISO 527-2
Tensile Strain (Break)	2.5	%	ISO 527-2
Flexural Modulus	11000	MPa	ISO 178
Flexural Stress	270	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength			ISO 179
-20°C	12	kJ/m ²	
23°C	20	kJ/m ²	
Charpy Unnotched Impact Strength			ISO 179
-20°C	58	kJ/m ²	
23°C	73	kJ/m ²	
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	225	°C	ISO 75-2/B
1.8 MPa, Unannealed	214	°C	ISO 75-2/A
Injection	Nominal Value	Unit	
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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