

Chemlon® 60GS3

Polyamide 6

Teknor Apex Company (Chem Polymer)

Message:

60GS3 is a 15% glass sphere filled nylon 6.

General Information				
Filler / Reinforcement	Glass beads, 15% filler by weight			
Processing Method	Injection molding			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.24	--	g/cm ³	ISO 1183
Molding Shrinkage ¹	1.2 - 1.6	--	%	Internal method
Water Absorption (Equilibrium, 23°C, 50% RH)	2.5	--	%	ISO 62
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3000	1600	MPa	ISO 527-2
Tensile Stress	70.0	40.0	MPa	ISO 527-2
Tensile Strain (Break)	10	--	%	ISO 527-2
Flexural Modulus	2200	700	MPa	ISO 178
Flexural Stress	90.0	45.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength	7.0	16	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength	50 kJ/m ²	No Break		ISO 179/1eU
Notched Izod Impact	5.0	--	kJ/m ²	ISO 180/A
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, not annealed	190	--	°C	ISO 75-2/B
1.8 MPa, not annealed	60.0	--	°C	ISO 75-2/A
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+14	1.0E+11	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Dielectric Strength (3.00 mm)	10	8.0	kV/mm	IEC 60243-1
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flame Rating (1.50 mm, Teknor Apex test result)	HB	--		UL 94
Injection	Dry	Unit		

Drying Temperature	80.0	°C
Drying Time	20	hr
Rear Temperature	230 - 280	°C
Middle Temperature	230 - 280	°C
Front Temperature	230 - 280	°C
Processing (Melt) Temp	240 - 270	°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).

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519
 Phone: +86 13424755533
 Email: sales@su-jiao.com
 No. 215, Lianhe North Road, Fengxian District, Shanghai, China

