

# Nymax™ GMF 604 40 UV BLACK 28

Polyamide 6

PolyOne Corporation

## Message:

The Nymax® 600 Series of mineral-reinforced nylon 6 compounds have been specifically developed to provide an excellent balance of physical property performance and durability, with improved surface appearance. These materials have been formulated to offer ease of processing in most standard thermoplastic processing equipment.

General Information			
Filler / Reinforcement	Glass fiber reinforced material, 40% filler by weight		
Features	Good UV resistance		
Appearance	Black		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.51	g/cm <sup>3</sup>	ASTM D792
Molding Shrinkage - Flow	0.20 - 0.50	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength <sup>1</sup>	135	MPa	ASTM D638
Flexural Modulus <sup>2</sup>	9650	MPa	ASTM D790
Flexural Strength <sup>3</sup>	220	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	64	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed, 3.20 mm)	190	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	2.0 - 4.0	hr	
Rear Temperature	240 - 280	°C	
Middle Temperature	240 - 280	°C	
Front Temperature	240 - 280	°C	
Mold Temperature	70.0 - 90.0	°C	
Injection instructions			
Injection Pressure: MED-HIGHHold Pressure: MED-HIGHScrew Speed: MODERATEBack Pressure: LOW			
NOTE			
1.	5.0 mm/min		
2.	1.3 mm/min		
3.	1.3 mm/min		

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