

Wellamid® GF1398 BK12

Polyamide 66
Wellman Engineering Resins

Message:

Wellamid® GF1398 BK12 is a Polyamide 66 (Nylon 66) material filled with 30% glass fiber. It is available in Asia Pacific, Europe, Latin America, or North America for injection molding.
Typical application of Wellamid® GF1398 BK12: Automotive

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.36	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow : 23°C	0.80 to 1.2	%	
Flow : 23°C	0.30 to 0.70	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield, 23°C)	180	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3.0	%	ISO 527-2
Flexural Modulus (23°C)	8500	MPa	ISO 178
Flexural Stress (23°C)	260	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (23°C)	9.1	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature (1.8 MPa, Unannealed)	250	°C	ISO 75-2/A
Melting Temperature (DSC)	260	°C	ISO 3146
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 to 4.0	hr	
Suggested Max Moisture	0.20	%	
Rear Temperature	282 to 310	°C	
Middle Temperature	277 to 304	°C	
Front Temperature	271 to 299	°C	
Nozzle Temperature	271 to 304	°C	
Processing (Melt) Temp	271 to 304	°C	
Mold Temperature	65.6 to 93.3	°C	
Injection Pressure	34.5 to 138	MPa	
Back Pressure	0.345	MPa	
Screw Speed	30 to 120	rpm	

The information and data on this page are provided by manufacturers and document providers. SHANGHAI SUSHENG assumes no legal liability. It is strongly recommended to verify all technical data with material suppliers before final material selection. All rights belong to the original authors. If any infringement occurs, please contact us immediately.

Recommended distributors for this material

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

