+135-3858-6433 (GuangDong)
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TEKNOR APEX

Chemlon® 60GF2

Teknor Apex Company (Chem Polymer) - Polyamide 6

General Information

Product Description

60GF2 is a 10% glass fibre reinforced nylon 6 that offers good mechanical performance.

General

Material Status	• Commercial: Active	
Availability	• Europe	• North America
Filler / Reinforcement	• Glass Fiber, 10% Filler by Weight	
Processing Method	• Injection Molding	

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.20	--	g/cm³	ISO 1183
Molding Shrinkage [2]	1.0 to 1.8	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	2.7	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	580000	--	psi	ISO 527-2
Tensile Stress (Break)	13100	8700	psi	ISO 527-2
Tensile Strain (Break)	4.5	--	%	ISO 527-2
Flexural Modulus	580000	363000	psi	ISO 178
Flexural Stress [3]	15200	10900	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	2.9	8.6	ft·lb/in²	ISO 179
Charpy Unnotched Impact Strength	12	--	ft·lb/in²	ISO 179
Notched Izod Impact Strength	2.1	--	ft·lb/in²	ISO 180
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	356	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	212	--	°F	
Electrical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Surface Resistivity	1.0E+14	1.0E+12	ohms	IEC 60093
Volume Resistivity	1.0E+16	1.0E+14	ohms·cm	IEC 60093
Electric Strength (0.118 in)	280	200	V/mil	IEC 60243-1
Comparative Tracking Index	600	500	V	IEC 60112
Flammability	**Dry**	**Conditioned**	**Unit**	**Test Method**
Flame Rating				UL 94
0.06 in, Teknor Apex test result	HB	--		

Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Drying Time	2.0	hr
Rear Temperature	446 to 536	°F
Middle Temperature	446 to 536	°F
Front Temperature	446 to 536	°F
Processing (Melt) Temp	< 572	°F

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Injection	Dry	Unit
Mold Temperature	140 to 176	°F
Injection Rate	Fast	
Screw Speed	50 to 200	rpm

Injection Notes

Back pressure: Low
Injection pressure: High

No drying is necessary unless the materials has been exposed to air for longer than three hours.

Notes

[1] Typical properties: these are not to be construed as specifications.

[2] Mould shrinkage is significantly influenced by many factors including wall thickness, gating, component shape and moulding conditions. The range values stated were 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).

[3] At Break