+135-3858-6433 (GuangDong)
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TEKNOR APEX

Chemlon® 60GF3

Teknor Apex Company (Chem Polymer) - Polyamide 6

General Information

Product Description

60GF3 is a 15% glass fibre reinforced nylon 6 that offers good mechanical performance and is suitable for general purpose injection moulding applications.

General	
Material Status	• Commercial: Active
Availability	• Europe
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight
Features	• General Purpose
Uses	• General Purpose
Processing Method	• Injection Molding

ASTM & ISO Properties [1]

Physical	Dry	Conditioned	Unit	Test Method
Density	1.25	--	g/cm³	ISO 1183
Molding Shrinkage [2]	1.0 to 1.6	--	%	Internal Method
Water Absorption				ISO 62
Equilibrium, 73°F, 50% RH	2.5	--	%	
Mechanical	**Dry**	**Conditioned**	**Unit**	**Test Method**
Tensile Modulus	798000	--	psi	ISO 527-2
Tensile Stress	15200	10200	psi	ISO 527-2
Tensile Strain (Break)	3.0	--	%	ISO 527-2
Flexural Modulus	725000	363000	psi	ISO 178
Flexural Stress	23900	12300	psi	ISO 178
Impact	**Dry**	**Conditioned**	**Unit**	**Test Method**
Charpy Notched Impact Strength	3.3	10	ft·lb/in²	ISO 179/1eA
Charpy Unnotched Impact Strength	12	--	ft·lb/in²	ISO 179/1eU
Notched Izod Impact Strength	2.6	--	ft·lb/in²	ISO 180/A
Thermal	**Dry**	**Conditioned**	**Unit**	**Test Method**
Heat Deflection Temperature				ISO 75-2/B
66 psi, Unannealed	> 374	--	°F	
Heat Deflection Temperature				ISO 75-2/A
264 psi, Unannealed	347	--	°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	500	--	V	IEC 60112

Processing Information

Injection	Dry	Unit
Drying Temperature	176	°F
Drying Time	20	hr
Rear Temperature	446 to 536	°F
Middle Temperature	446 to 536	°F
Front Temperature	446 to 536	°F
Processing (Melt) Temp	464 to 518	°F

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Injection	Dry	Unit
Mold Temperature	140 to 176	°F
Injection Rate	Fast	
Back Pressure	Low	
Screw Speed	Moderate	

Injection Notes

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.

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, 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).