



Edgetek™ PA-60GF/000 BK006

High Performance Polyamide

Key Characteristics

Product Description

Glass Fiber Reinforced PPA Compound

General

Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 60% Filler by Weight
Appearance	• Black
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.75	1.75	ISO 1183
Molding Shrinkage	0.10 to 0.50 %	0.10 to 0.50 %	ASTM D955
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Strength	33400 psi	230 MPa	ISO 527-2
Flexural Modulus	2.76E+6 psi	19000 MPa	ISO 178
Flexural Strength	56600 psi	390 MPa	ISO 178
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Charpy Notched Impact Strength	5.7 ft-lb/in ²	12 kJ/m ²	ISO 179
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm)	554 °F	290 °C	ASTM D648
Electrical	Typical Value (English)	Typical Value (SI)	Test Method
Surface Resistivity	> 1.0E+12 ohms	> 1.0E+12 ohms	ASTM D257
Flammability	Typical Value (English)	Typical Value (SI)	Test Method
Flame Rating (0.0630 in (1.60 mm))	HB	HB	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 248 °F	80.0 to 120 °C
Drying Time	4.0 to 6.0 hr	4.0 to 6.0 hr
Rear Temperature	608 to 644 °F	320 to 340 °C
Middle Temperature	608 to 644 °F	320 to 340 °C
Front Temperature	608 to 644 °F	320 to 340 °C
Mold Temperature	248 to 275 °F	120 to 135 °C

Injection Notes

Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

Notes

¹ Typical values are not to be construed as specifications.

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