



Nymax™ GMF600 40 NATURAL

Polyamide 6

Key Characteristics

Product Description

Glass fiber and mineral reinforced PA6 compound.

General

| | |
|---------------------------|---------------------------------------|
| Material Status | • Commercial: Active |
| Regional Availability | • Asia Pacific |
| Filler / Reinforcement | • Glass\Mineral, 40% Filler by Weight |
| Automotive Specifications | • GM GMP.PA6.001 Color: Natural |
| Appearance | • Natural Color |
| Processing Method | • Injection Molding |

Technical Properties ¹

| Physical | Typical Value (English) | Typical Value (SI) | Test Method |
|---|-------------------------|--------------------|-------------|
| Specific Gravity | 1.46 | 1.46 | ASTM D792 |
| Molding Shrinkage | 0.20 to 0.50 % | 0.20 to 0.50 % | ASTM D955 |
| Mechanical | Typical Value (English) | Typical Value (SI) | Test Method |
| Tensile Strength ² | 17400 psi | 120 MPa | ASTM D638 |
| Flexural Modulus ³ | 1.13E+6 psi | 7800 MPa | ASTM D790 |
| Flexural Strength ³ | 33400 psi | 230 MPa | ASTM D790 |
| Impact | Typical Value (English) | Typical Value (SI) | Test Method |
| Notched Izod Impact | | | ASTM D256 |
| 73°F (23°C), 0.126 in (3.20 mm) | 1.3 ft-lb/in | 70 J/m | |
| Thermal | Typical Value (English) | Typical Value (SI) | Test Method |
| Deflection Temperature Under Load | | | ASTM D648 |
| 264 psi (1.8 MPa), Unannealed, 0.126 in (3.20 mm) | 365 °F | 185 °C | |
| Electrical | Typical Value (English) | Typical Value (SI) | Test Method |
| Surface Resistivity | 1.0E+15 ohms | 1.0E+15 ohms | ASTM D257 |
| Flammability | Typical Value (English) | Typical Value (SI) | Test Method |
| Flame Rating (0.06 in (1.6 mm)) | HB | HB | UL 94 |

Processing Information

| Injection | Typical Value (English) | Typical Value (SI) |
|--------------------|-------------------------|--------------------|
| Drying Temperature | 176 to 212 °F | 80.0 to 100 °C |
| Drying Time | 2.0 to 4.0 hr | 2.0 to 4.0 hr |
| Rear Temperature | 464 to 536 °F | 240 to 280 °C |
| Middle Temperature | 464 to 536 °F | 240 to 280 °C |
| Front Temperature | 464 to 536 °F | 240 to 280 °C |
| Mold Temperature | 158 to 194 °F | 70.0 to 90.0 °C |

Injection Notes

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

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Notes¹ Typical values are not to be construed as specifications.² 0.20 in/min (5.0 mm/min)³ 0.051 in/min (1.3 mm/min)**CONTACT INFORMATION****Americas**United States - Avon Lake
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