Nymax™ GMF600 40 NC013

Polyamide 6

Key Characteristics

Product Description	
Glass fiber reinforced PA6 compound	
General	
Material Status	• Commercial: Active
Regional Availability	• Asia Pacific
Filler / Reinforcement	• Glass Fiber, 40% Filler by Weight
Appearance	• Natural Color
Processing Method	• Injection Molding

Technical Properties [1]

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Specific Gravity	1.48	1.48	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]	1.23E+6 psi	8500 MPa	ASTM D790
Flexural Strength [3]	31900 psi	220 MPa	ASTM D790
Impact	**Typical Value (English)**	**Typical Value (SI)**	**Test Method**
Charpy Notched Impact Strength	3.3 ft·lb/in²	7.0 kJ/m²	ISO 179
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)	410 °F	210 °C	
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 (0.13 in (3.2 mm))	HB	HB	Internal Method

Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	176 to 194 °F	80.0 to 90.0 °C
Drying Time	2.0 to 4.0 hr	2.0 to 4.0 hr
Processing (Melt) Temp	464 to 536 °F	240 to 280 °C
Mold Temperature	149 to 185 °F	65.0 to 85.0 °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.

[2] 0.20 in/min (5.0 mm/min)

[3] 0.051 in/min (1.3 mm/min)

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