



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
Density / 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 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 to 90 °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)