



Nymax™ GF 604 35 HS Black 13

Polyamide 6

Key Characteristics

Product Description

The Nymax® GF 600 Series of glass fiber-reinforced nylon 6 compounds have been specifically engineered for applications requiring high stiffness, tensile strength, and toughness, while providing enhanced surface appearance versus nylon 6/6 compounds. These materials are available in a broad range of reinforcement levels depending upon stiffness characteristics desired and have been formulated to offer ease of processing in most standard thermoplastic processing equipment.

General

Material Status	• Commercial: Active
Regional Availability	• Latin America • North America
Filler / Reinforcement	• Glass Fiber, 35% Filler by Weight
Additive	• Heat Stabilizer
Features	• General Purpose • Heat Stabilized
Uses	• Automotive Applications • Consumer Applications • Industrial Applications • Construction Applications • General Purpose
Appearance	• Black
Forms	• Pellets
Processing Method	• Injection Molding

Technical Properties ¹

Physical	Typical Value (English)	Typical Value (SI)	Test Method
Density / Specific Gravity	1.39	1.39	ASTM D792
Molding Shrinkage - Flow	2.0E-3 to 4.0E-3 in/in	0.20 to 0.40 %	ASTM D955
Water Absorption (24 hr)	1.0 %	1.0 %	ASTM D570
Mechanical	Typical Value (English)	Typical Value (SI)	Test Method
Tensile Modulus	1.30E+6 psi	8960 MPa	ASTM D638
Tensile Strength ² (Yield)	22000 psi	152 MPa	ASTM D638
Tensile Strength ² (Break)	25000 psi	172 MPa	ASTM D638
Tensile Elongation ² (Yield)	3.0 %	3.0 %	ASTM D638
Flexural Modulus	1.30E+6 psi	8960 MPa	ASTM D790
Flexural Strength	31000 psi	214 MPa	ASTM D790
Impact	Typical Value (English)	Typical Value (SI)	Test Method
Notched Izod Impact			ASTM D256A
73°F (23°C), 0.125 in (3.18 mm), Injection Molded	2.0 ft-lb/in	110 J/m	
Thermal	Typical Value (English)	Typical Value (SI)	Test Method
Deflection Temperature Under Load			ASTM D648
264 psi (1.8 MPa), Annealed, 0.125 in (3.18 mm)	393 °F	201 °C	
Additional Information			
Molded Test Bars: Dry as Molded			

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Processing Information

Injection	Typical Value (English)	Typical Value (SI)
Drying Temperature	180 °F	82 °C
Drying Time	4.0 hr	4.0 hr
Suggested Max Moisture	0.060 to 0.12 %	0.060 to 0.12 %
Rear Temperature	480 to 530 °F	249 to 277 °C
Middle Temperature	500 to 550 °F	260 to 288 °C
Front Temperature	520 to 570 °F	271 to 299 °C
Nozzle Temperature	515 to 565 °F	268 to 296 °C
Mold Temperature	150 to 230 °F	66 to 110 °C

Notes

¹ Typical values are not to be construed as specifications.

² Type I, 0.20 in/min (5.1 mm/min)

CONTACT INFORMATION

Americas

United States - Avon Lake
+1 440 930 1000

United States - McHenry
+1 815 385 8500

Asia

China - Guangzhou
+86 20 8732 7260

China - Shenzhen
+86 755 2969 2888

China - Suzhou
+86 512 6823 24 38

China - Suzhou
+86 512 6265 2600

Hong Kong -
+852 2690 5332

Taiwan - Yonghe City,
+886 9396 99740, +886 2929 1849

Europe

Germany - Gaggenau
+49 7225 6802 0

Spain - Barbastro (Huesca)
+34 974 310 314



Beyond Polymers.

Better Business Solutions. SM

www.polyone.com

PolyOne Americas

33587 Walker Road
Avon Lake, Ohio 44012
United States
+1 440 930 1000
+1 866 POLYONE

PolyOne Asia

No. 88 Guoshoujing Road
Z.J Hi-tech Park, Pudong
Shanghai, 201203, China
+86 21 5080 1188

PolyOne Europe

6 Giällewee
+352 269 050 35

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