

InStruc® PA6I6TGF30

Americhem - Polyamide 6I/6T Copolymer

General Information

Product Description

30% glass fiber reinforced injection molding grade of amorphous partially aromatic nylon 6I/6T with high strength and toughness.

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East • Asia Pacific	• Europe • Latin America	• North America
Filler / Reinforcement	• Glass Fiber, 30% Filler by Weight		
Features	• Filled • Good Dimensional Stability	• High Stiffness • High Strength	
Uses	• Automotive Applications • Closures • Consumer Applications • Electrical/Electronic Applications	• Engineering Parts • Household Goods • Industrial Applications • Industrial Parts	• Office Automation Equipment • Outdoor Applications • Window & Door Components
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.31		ASTM D792
Molding Shrinkage - Flow	3.0E-3 to 5.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ² (Yield)	17000	psi	ASTM D638
Tensile Elongation ² (Yield)	5.0	%	ASTM D638
Flexural Modulus	1.00E+6	psi	ASTM D790
Flexural Strength (Yield)	20000	psi	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact	2.0	ft-lb/in	ASTM D256

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	175	°F
Drying Time	4.0 to 12	hr
Suggested Shot Size	30 to 60	%
Rear Temperature	450 to 500	°F
Middle Temperature	460 to 500	°F
Front Temperature	470 to 520	°F
Nozzle Temperature	450 to 500	°F
Processing (Melt) Temp	450 to 540	°F
Mold Temperature	100 to 150	°F
Back Pressure	50.0 to 100	psi
Screw Speed	60 to 120	rpm
Vent Depth	1.5E-3 to 3.0E-3	in

Notes

¹ Typical properties: these are not to be construed as specifications.

² 2.0 in/min

