

Technical Datasheet

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|----------------------|--|------------------|------------------|-------------------|------------------------|
| Material Type | PA6 | Trademark | Wellamid® | Grade Name | GF25-60 XE-NBK1 |
| Feature | <ul style="list-style-type: none"> Glass Fiber Reinforced Nylon Resin (PA6) | | | | |
| Material Standard | <ul style="list-style-type: none"> XXXXXX | | | | |
| Availability | <ul style="list-style-type: none"> Asian-Pacific, America | | | | |
| Processing method | <ul style="list-style-type: none"> Injection Molding | | | | |
| Appearance | <ul style="list-style-type: none"> Color is Optional | | | | |
| Applications | <ul style="list-style-type: none"> Automotive and Engineering parts | | | | |

General Properties

| No. | Properties | Unit | Typical Value | Method | Test condition |
|-----|-----------------------------|-------------------|-------------------------|----------------|----------------|
| 1 | Filler Content | % | 25 | ISO 3451-1, -4 | |
| 2 | Density | g/mL | 1.32 | ISO 1183 | 23 °C |
| 3 | Melt Point | °C | 220 | ISO 3146 | DSC |
| 4 | Tensile Strength | MPa | 145 | ISO 527 | 5 mm/mm |
| 5 | Tensile Elongation | % | 3.0 | ISO 527 | 5 mm/mm |
| 6 | Flexural Strength | MPa | 205 | ISO 178 | 2 mm/mm |
| 7 | Flexural Modulus | MPa | ,7,300 | ISO 178 | 2 mm/mm |
| 8 | Izod Impact | kJ/m ² | 7.0 | ISO 180 | 23 °C |
| 9 | Heat Deflection Temperature | °C | 205 | ISO 75 | 1.8 MPa |
| 10 | Material Shrinkage | % | 0.4/1.0 (flow/cross) | ISO 294 | 23 °C, 48h |

Processing Conditions

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|--------------------|--|
| Drying condition | 80 °C, 2-4 h |
| Molding Temp. | 250 - 290 °C (F), 250 - 290 °C (M), 260 - 290 °C (B) |
| Melt Temp. | 260 – 290 °C |
| Mold Temp. | 70 - 90 °C |
| Screw Speed | 30 - 120 rpm |
| Injection Pressure | 30 - 140 MPa |
| Back Pressure | 0.30 – 1.40 MPa |

Notes: This technical data in the product brochures are typical test results for reference, and should not be defined as minimum value.