



InStruc® PA6I6TGF30

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

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

PHYSICAL	NOMINAL VALUE	UNIT	TEST METHOD
Density / Specific Gravity	1.31	g/cm ³	ASTM D792
Molding Shrinkage - Flow	0.30 to 0.50	%	ASTM D955
Water Absorption (24 hr)	1.5	%	ASTM D570
MECHANICAL	NOMINAL VALUE	UNIT	TEST METHOD
Tensile Strength ² (Yield)	117	MPa	ASTM D638
Tensile Elongation ² (Yield)	5.0	%	ASTM D638
Flexural Modulus	6890	MPa	ASTM D790
Flexural Strength (Yield)	138	MPa	ASTM D790
IMPACT	NOMINAL VALUE	UNIT	TEST METHOD
Notched Izod Impact	110	J/m	ASTM D256
INJECTION	NOMINAL VALUE	UNIT	
Drying Temperature	79	°C	
Drying Time	4.0 to 12	hr	
Suggested Shot Size	30 to 60	%	
Rear Temperature	232 to 260	°C	
Middle Temperature	238 to 260	°C	
Front Temperature	243 to 271	°C	
Nozzle Temperature	232 to 260	°C	
Processing (Melt) Temp	232 to 282	°C	
Mold Temperature	38 to 66	°C	
Back Pressure	0.345 to 0.689	MPa	



INJECTION	NOMINAL VALUE	UNIT
Screw Speed	60 to 120	rpm
Vent Depth	0.038 to 0.076	mm

NOTES

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

² 51 mm/min

