

InStruc® PA6GF15HS

Americhem - Polyamide 6

General Information
Product Description

15% GLASS FIBER REINFORCED, HEAT STABILIZED NYLON 6

General

Material Status	• Commercial: Active		
Availability	• Africa & Middle East	• Europe	• North America
	• Asia Pacific	• Latin America	
Filler / Reinforcement	• Glass Fiber, 15% Filler by Weight		
Additive	• Heat Stabilizer		
Features	• Filled	• Heat Stabilized	• High Strength
	• Good Dimensional Stability	• High Stiffness	
Uses	• Automotive Applications	• Engineering Parts	• Office Automation Equipment
	• Closures	• Household Goods	• Outdoor Applications
	• Consumer Applications	• Industrial Applications	• Window & Door Components
	• Electrical/Electronic Applications	• Industrial Parts	
Forms	• Pellets		
Processing Method	• Injection Molding		

Properties ¹

	Nominal Value	Unit	Test Method
Physical			
Density / Specific Gravity	1.24		ASTM D792
Molding Shrinkage - Flow	5.0E-3 to 8.0E-3	in/in	ASTM D955
Water Absorption (24 hr)	1.1	%	ASTM D570
Mechanical			
Tensile Modulus	950000	psi	ASTM D638
Tensile Strength	17800	psi	ASTM D638
Tensile Elongation (Yield)	3.0 to 4.0	%	ASTM D638
Flexural Modulus	800000	psi	ASTM D790
Flexural Strength	24000	psi	ASTM D790
Impact			
Notched Izod Impact (0.125 in)	1.2	ft·lb/in	ASTM D256
Thermal			
Deflection Temperature Under Load (264 psi, Unannealed)	390	°F	ASTM D648

Processing Information

	Nominal Value	Unit
Injection		
Drying Temperature	175	°F
Drying Time	3.0 to 4.0	hr
Suggested Max Moisture	0.20	%
Processing (Melt) Temp	480 to 540	°F
Mold Temperature	200	°F
Back Pressure	50.0 to 100	psi
Screw Speed	40 to 70	rpm

