

Vydyne® PF004

 Ascend Performance Materials Operations LLC - *Polyamide 6*
General Information
Product Description

Vydyne PF004 is a 20% glass filled PA6 for injection molded applications.

General

Material Status	• Commercial: Active
Availability	• Europe • North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
Additive	• Mold Release
Features	• Good Stiffness • Good Strength
Agency Ratings	• ISO 1043 PA6 GF20
Appearance	• Natural Color
Forms	• Pellets
Processing Method	• Injection Molding
Resin ID	• PA6-GF20

Properties ¹

Physical	Nominal Value	Unit	Test Method
Density	1.27	g/cm ³	ISO 1183
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus (73°F)	899000	psi	ISO 527-1
Tensile Stress (Yield, 73°F)	15400	psi	ISO 527-2
Tensile Strain (Yield, 73°F)	3.0	%	ISO 527-2
Flexural Modulus (73°F)	667000	psi	ISO 178
Flexural Stress (73°F)	22900	psi	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength (73°F)	3.3	ft·lb/in ²	ISO 180/1A
Unnotched Izod Impact Strength (73°F)	19	ft·lb/in ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (264 psi, Unannealed)	329	°F	ISO 75-2/A

Processing Information

Injection	Nominal Value	Unit
Drying Temperature	176	°F
Drying Time	4.0	hr
Suggested Max Moisture	0.20	%
Rear Temperature	446 to 464	°F
Middle Temperature	464 to 482	°F
Front Temperature	464 to 518	°F
Processing (Melt) Temp	464 to 518	°F
Mold Temperature	140 to 176	°F

