Vydyne® PF004XXP

Ascend Performance Materials Operations LLC - *Polyamide 6*

General Information

Product Description	
Vydyne PF004XXP is a 20% glass fiber reinforced PA6 for injection molded applications.	
General	
Material Status	• Commercial: Active
Availability	• Europe • North America
Filler / Reinforcement	• Glass Fiber, 20% Filler by Weight
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/cm³	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/in²	ISO 180/1A
Thermal	**Nominal Value**	**Unit**	**Test Method**
Deflection Temperature Under Load (264 psi, Unannealed)	329	°F	ISO 75-2/A
Electrical	**Nominal Value**	**Unit**	**Test Method**
Comparative Tracking Index (0.118 in)	500	V	IEC 60112
Flammability	**Nominal Value**	**Unit**	**Test Method**
Glow Wire Flammability Index (0.06 in)	1200	°F	IEC 60695-2-12

Processing Information

Injection	**Nominal Value**	**Unit**
Drying Temperature	167 to 185	°F
Drying Time	4.0 to 6.0	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