

# Technical Datasheet

<b>Material Type</b>	<b>PA6</b>	<b>Trademark</b>	<b>Wellamid®</b>	<b>Grade Name</b>	<b>GF1685-WBK1</b>
Feature	<ul style="list-style-type: none"> <li>Glass Fiber Reinforced Nylon Resin (PA6)</li> </ul>				
Material Standard	<ul style="list-style-type: none"> <li>XXXXXX</li> </ul>				
Availability	<ul style="list-style-type: none"> <li>Asian-Pacific, America</li> </ul>				
Processing method	<ul style="list-style-type: none"> <li>Injection Molding</li> </ul>				
Appearance	<ul style="list-style-type: none"> <li>Color is Optional</li> </ul>				
Applications	<ul style="list-style-type: none"> <li>Automotive and Engineering parts</li> </ul>				

## General Properties

No.	Properties	Unit	Typical Value	Method	Test condition
1	Filler Content	%	20	ISO 3451-1, -4	
2	Density	g/mL	1.28	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	6,300	ISO 178	2 mm/mm
8	Izod Impact	kJ/m <sup>2</sup>	6.0	ISO 180	23 °C
9	Heat Deflection Temperature	°C	205	ISO 75	1.8 MPa
10	Material Shrinkage	%	0.5/0.9 (flow/cross)	ISO 294	23 °C, 48h

## Processing Conditions

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.