Technical Datasheet

Material Type PA66/6	**Trademark** Wellamid®	**Grade Name** GF60-66/6 XE-NBK1

Feature	• Glass Fiber Reinforced, Engineering Grade Nylon Resin (PA66/6)
Material Standard	• XXXXXX
Availability	• Asian-Pacific, America
Processing method	• Injection Molding
Appearance	• Color is Optional
Applications	• Automotive and Engineering parts

General Properties

No.	Properties	Unit	Typical Value	Method	Test condition
1	Filler Content	%	60	ISO 3451-1, -4	
2	Density	g/mL	1.70	ISO 1183	23 ℃
3	Melt Point	℃	260	ISO 3146	DSC
4	Tensile Strength	MPa	215	ISO 527	5 mm/mm
5	Tensile Elongation	%	2	ISO 527	5 mm/mm
6	Flexural Strength	MPa	335	ISO 178	2 mm/mm
7	Flexural Modulus	MPa	18,000	ISO 178	2 mm/mm
8	Izod Impact	kJ/m^2	17	ISO 180	23 ℃
9	Heat Deflection Temperature	℃	230	ISO 75	1.8 MPa
10	Material Shrinkage	%	0.4/0.7 (flow/cross)	ISO 294	23 ℃, 48h

Processing Conditions

Drying condition	80 ℃, 2-4 h
Molding Temp.	260 - 290 ℃ (F)， 260 - 290 ℃ (M)，270 - 290 ℃ (B)
Melt Temp.	270 - 290 ℃
Mold Temp.	70 - 90 ℃
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.

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