

Technical Datasheet

Material Type	PA6	Trademark	Wellamid®	Grade Name: GF30-60 XE-NBK1
Feature	33% Glass Fiber Reinforced, Nylon Resin (PA6),			
Availability	Asia-Pacific, America			
Processing method	Injection Molding			
Appearance	Black Colored Pellets			
Applications	Automotive and Engineering Parts			

General Properties

No.	Properties	Unit	Typical Value	Method	Test condition
1	Filler Content	%	33	ISO 3451-1, -4	650°C
2	Density	g/mL	1.38	ISO 1183	23 °C
3	Melt Point	°C	220	ISO 11357-3	10 °C/min
4	Tensile Strength	MPa	165	ISO 527	5 mm/mm
5	Elongation at Break	%	3	ISO 527	5 mm/mm
6	Flexural Strength	MPa	235	ISO 178	2 mm/mm
7	Flexural Modulus	MPa	9,200	ISO 178	2 mm/mm
8	Notched Izod Impact	kJ/m ²	10.0	ISO 180	23 °C
9	Heat Deflection Temperature	°C	210	ISO 75	1.8 MPa
10	Material Shrinkage	%	0.3/0.9 (flow/cross)	ISO 294	23 °C, 48h

Processing Conditions

Drying condition	80 - 100°C, 2-4 h
Molding Temp.	230 - 260°C (F), 250 - 280°C (M), 220 - 245°C (B)
Mold Temp.	70 - 90°C
Moisture Control	< 0.1%

Note 1: This technical data in the product brochures are typical test results for reference, and should not be defined as minimum value.

Note 2: The provided processing conditions are only for reference. Please adjust them appropriately according to the product's structure and requirements, the machine model, and the injection environment.

Note 3: The preferred dryer is a dehumidifying dryer with a dew point maintained between -30 and -40°C. Non-dehumidified dryers can be operated until 120°C, but care must be taken with natural/light colors as color changes may occur after drying depending on time/temperature of exposure. For more information, please contact your PRET representative.