



QR-9006-GF40

Nylon 6

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	Heat Stabilized (PO Specified) Good Strength/Stiffness
Filler/Additive	40% Glass

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.45	
Melting Point		420	°F
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	1,380,000	psi
Flex Strength @ Yield	ASTM D790	35,000	psi
Notched Izod Impact, 73°F	ASTM D256	2.2	ft.lbs/in
Tensile Modulus	ASTM D638	1,600,000	psi
Tensile Strength @ Yield	ASTM D638	22,000	psi
Tensile Elongation @ Break	ASTM D638	3.5	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	400	°F
Deflection Temp @ 66 psi	ASTM D648	N/A	°F

These test results are based on reliable procedures. Due to variable conditions and methods of processing, no guarantees or warranties are expressed or implied including the implied warranty of merchantability and fitness for particular use. The above information is not to be construed as a license or a recommendation to infringe on any patents.

-Injection Molding

Drying Conditions

Min 2 hours – Max 4 hours	175	°F
Cylinder		
Rear	450-550	°F
Middle	450-550	°F
Front	450-550	°F
Nozzle	450-550	°F
Mold		
Maximum	200	°F
Minimum	150	°F
Processing Temp	500-550	°F
Maximum Moisture Content	0.2	%

ISO9001:2000 Registered



QTR, Inc.

The guidelines listed above are based on specimens at various thicknesses typical in manufacturing. These values are not intended to be used for specification purposes. These are recommended starting parameters. The equipment part design and tooling will influence final process parameters. The percent recycle is dependent on part design, wall thickness, process, and final performance requests.