



QR-9046-GF15

Nylon 4/6

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features	High Heat Resistance Heat Stabilized Good Strength/Stiffness Oil Resistant, Chemical Resistant
Filler/Additive	15% Glass

Property	Method	Value	Unit
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.3	
Mold Shrink, Linear Flow	ASTM D955	6-9	mil/in
Melting Point		580	°F
<i>-Mechanical</i>			
Flex Modulus	ASTM D790	798,000	psi
Flex Strength @ Break	ASTM D790	31,900	psi
Notched Izod Impact, 73°F	ASTM D256	1.6	ft.lbs/in
Tensile Modulus	ASTM D638	841,000	psi
Tensile Strength @ Break	ASTM D638	21,800	psi
Tensile Elongation @ Break	ASTM D638	3	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	490	°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	185	°F
Cylinder		
Rear	540-560	°F
Middle	560-590	°F
Front	570-590	°F
Nozzle	580	°F
Mold		
Maximum	300	°F
Minimum	180	°F
Processing Temp	580-595	°F
Maximum Moisture Content	0.05	%

ISO9001:2000 Registered



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.