

Velocity® LGF60 - PA6

PA6-GF60

PlastiComp, Inc.

Product Texts

long fiber reinforced

Mechanical properties

	Value	Unit	Test Standard
ASTM Data			
Tensile Modulus	19990	MPa	ASTM D 638
Tensile Strength	255	MPa	ASTM D 638
Elongation at Yield	1.5	%	ASTM D 638
Flexural Modulus	17240	MPa	ASTM D 790
Flexural Strength	407	MPa	ASTM D 790
Izod Impact notched, 1/8 in	320	J/m	ASTM D 256
Izod Impact unnotched, 1/8 in	1280	J/m	ASTM D 256

Thermal properties

	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	221	°C	ASTM D 648

Other properties

	Value	Unit	Test Standard
Density	1690	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding

	Value	Unit	Test Standard
Pre-drying - Temperature	85	°C	-
Pre-drying - Time	4	h	-
Processing humidity	≤0.18	%	-
Melt temperature	271 - 288	°C	-
Mold temperature	93	°C	-
Zone 1	260 - 277	°C	-
Zone 2	266 - 282	°C	-
Zone 3	271 - 288	°C	-
Nozzle temperature	271 - 288	°C	-
Screw speed	30 - 50	rpm	-
Injection speed	51 - 76	mm/s	-
Back pressure	0.17 - 0.35	MPa	-

Characteristics**Processing**

Injection Molding

Regional Availability

North America, Europe, Asia Pacific

Features

Long fiber reinforced