Nymax™ GMF 604 40 UV BLACK 28

Polyamide 6

Avient Corporation

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Technical Data

Product Description

The Nymax® 600 Series of mineral-reinforced nylon 6 compounds have been specifically developed to provide an excellent balance of physical property performance and durability, with improved surface appearance. These materials have been formulated to offer ease of processing in most standard thermoplastic processing equipment.

General

Material Status	• Commercial: Active
Literature [1]	• Technical Datasheet
Search for UL Yellow Card	• Avient Corporation • Nymax™
Availability	• Africa & Middle East • Asia Pacific • Europe • North America
Filler / Reinforcement	• Glass Fiber\Mineral, 40% Filler by Weight
Features	• UV Resistant
Appearance	• Black
Processing Method	• Injection Molding

Physical	Nominal Value	Unit	Test Method
Density / Specific Gravity	1.51	g/cm³	ASTM D792
Molding Shrinkage - Flow	0.20 to 0.50	%	ASTM D955

Mechanical	Nominal Value	Unit	Test Method
Tensile Strength [3]	135	MPa	ASTM D638
Flexural Modulus [4]	9650	MPa	ASTM D790
Flexural Strength [4]	220	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	64	J/m	ASTM D256

Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
1.8 MPa, Unannealed, 3.20 mm	190	°C	

Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+15	ohms	ASTM D257

Injection	Nominal Value	Unit
Drying Temperature	82	°C
Drying Time	4.0	hr
Suggested Max Moisture	0.10 to 0.20	%
Rear Temperature	260 to 277	°C
Middle Temperature	274 to 288	°C
Front Temperature	274 to 288	°C
Nozzle Temperature	274 to 288	°C
Mold Temperature	49 to 93	°C

Injection Notes

Injection Pressure: MED-HIGH
Hold Pressure: MED-HIGH
Screw Speed: MODERATE
Back Pressure: LOW

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Notes

[1] These links provide you with access to supplier literature. We work hard to keep them up to date; however you may find the most current literature from the supplier.

[2] Typical properties: these are not to be construed as specifications.

[3] 5.0 mm/min

[4] 1.3 mm/min

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