

FORMPOLY N6GF25LT

(25%Glass Fibre Reinforced Nylon6)

GENERAL

FPL offers a range of Nylon6 grades from unfilled, glass fibre reinforced, mineral reinforced to flame retardant including **FORMPOLY N6GF25LT**, which is heat stabilized, lubricated Glass Fibre Reinforced Nylon 6 with excellent mechanical / thermal properties and reduced shrinkage.

FORMPOLY N6GF25LT

- Increased Toughness
- Lubricated and heat stabilized
- High mechanical properties
- Excellent dimensional stability
- Low water absorption

PRE-DRYING

FPL grades can normally be taken for direct processing. However, in case the material is exposed to atmosphere, it is advisable to pre-dry the material at 100°C for 2 to 3 hours for good surface finish.

PACKING

FORMPOLY N6GF25LT is supplied in 25 Kg. dry, ready to mould, in sealed bags to prevent the uptake of moisture.

APPLICATION

- Drive pulley
- Switch assembly
- Housing for power tool
- Radiator fans
- Instrument Housing

Property	ASTM Method	Unit	Value
Tensile Stress	D638	MPa.	155
Elongation at Break	D638	%	4
Flexural Stress	D790	MPa.	240
Flexural Modulus	D790	MPa.	7500
Izod Impact Strength Notched	D256	Kg Cm/ Cm	12
Heat Deflection Temp			
- at 4.6 Kg / Cm ² load	D646	°C	220
- at 18.5 Kg / Cm ² load			220
Specific Gravity	D792	-	1.30
Shrinkage	D955	%	0.15-0.3
Volume Resistivity	D-257	Ohms-cm	10E15
Surface Resistivity	D-257	Ohms	10E14

Conditioned test specimen. All results are measured under Dry-as-moulded natural test specimen
 Coloured grades would record slightly lower mechanical properties as permitted by ASTM D-4066

The information present here is for general guidance. It is given in good faith but no warrant is attached

FORMULATED POLYMERS LIMITED

Manufacturers of Engineering Plastics Compounds

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A ISO/TS 16949, ISO 9001 & ISO 14001 certified Firm

PROCESSING PARAMETER

FORMPOLY N6GF25LT	
INJECTION MOLDING PARAMETERS	
Drying Temperature	100-120°C
Drying Time	2-4Hrs
Rear Temperature	200 -220°C
Middle Temperature	225 -245°C
Front Temperature	240 -260°C
Nozzle Temperature	235 -250°C
Processing (Melt) Temp	220 to 250°C
Mold Temperature	80 to 100°C
Injection Pressure	1000-1250 Kg/sq.cm

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