

TUFNYL® RGF 15 NATURAL

15% fiberglass

Polyamide 66

SRF Ltd.

Description of materials:

Polyamide 66, 15% Glass fiber reinforced material for injection molding

| Main Information               |                                  |                     |                 |
|--------------------------------|----------------------------------|---------------------|-----------------|
| Filler/reinforcement           | Fiberglass, 15% filler by weight |                     |                 |
| Appearance                     | Natural color                    |                     |                 |
| Processing method              | Die casting                      |                     |                 |
| Physical                       | Nominal value                    | Unit of measurement | Test method     |
| Specific gravity               | 1.24                             | g/cm³               | ASTM D792       |
| Molding Shrinkage-Flow         | 0.20 to 0.50                     | %                   | Internal Method |
| Water absorption (Equilibrium) | 0.80                             | %                   | ASTM D570       |
| Hardness                       | Nominal value                    | Unit of measurement | Test method     |
| Rockwell hardness              | ASTM D785                        |                     |                 |
| M-Scale                        | 88                               |                     |                 |
| R-Scale                        | 118                              |                     |                 |
| Mechanical                     | Nominal value                    | Unit of measurement | Test method     |
| Tensile Stress (Yield)         | 110                              | MPa                 | ISO 527-2       |
| Tensile stress (Break)         | 3.5                              | %                   | ISO 527-2       |
| Flexor module                  | 4000                             | MPa                 | ISO 178         |
| Flexor stress                  | 150                              | MPa                 | ISO 178         |
| Impact                         | Nominal value                    | Unit of measurement | Test method     |
| Impact strength                | 58.8                             | J/m                 | ISO 180         |
| Thermal                        | Nominal value                    | Unit of measurement | Test method     |
| Heat Deflection Temperature    |                                  |                     |                 |
| 0.45 MPa, Unannealed           | 210                              | °C                  | ISO 75-2/B      |
| 1.8 MPa, Unannealed            | 170                              | °C                  | ISO 75-2/A      |
| Melting point                  | 260                              | °C                  | DSC             |
| Electric                       | Nominal value                    | Unit of measurement | Test method     |
| Surface resistivity            | 1.0E+14                          | ohms                | ASTM D257       |
| Volume resistance              | 1.0E+15                          | ohms·cm             | ASTM D257       |
| Dielectric strength            | 22                               | kV/mm               | ASTM D149       |
| Injection                      | Nominal value                    | Unit of measurement |                 |
| Drying temperature             | 80.0                             | °C                  |                 |
| Drying time                    | 2.0 to 4.0                       | hr                  |                 |

|                               |              |     |
|-------------------------------|--------------|-----|
| Recommended maximum humidity  | 0.20         | %   |
| Processing temperature (melt) | 280 to 300   | °C  |
| Mold temperature              | 40.0 to 80.0 | °C  |
| Injection pressure            | 3.50 to 12.5 | MPa |
| Injection speed               | Fast         |     |

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