

GLAMIDE™ TY-391GVE2

TOYOBO MC Corporation - Polyamide 6

General Information

Product Description

GF Reinforced, Flame Retardant

General

Material Status	• Commercial: Active
Filler / Reinforcement	• Glass Fiber, 50% Filler by Weight
Features	• Flame Retardant • Pleasing Surface Appearance
Uses	• Automotive Applications • General Purpose • Automotive Exterior Parts • Industrial Applications
Forms	• Pellets
Processing Method	• Injection Molding
Part Marking Code (ISO 11469)	• >PA6-GF50FR<
Revision Date	• 9/10/2025

ASTM & ISO Properties

Physical	Nominal Value	Unit	Test Method
Density	1.65	g/cm ³	ISO 1183
Molding Shrinkage			Internal Method
Flow	0.20	%	
Across Flow	0.40	%	
Water Absorption (24 hr, 23°C)	0.50	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	180	MPa	ISO 527
Tensile Elongation (Break)	1.8	%	ISO 527
Flexural Modulus	17400	MPa	ISO 178
Flexural Strength	270	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	9.2	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
0.45 MPa, Unannealed	215	°C	ISO 75-2/B
1.8 MPa, Unannealed	195	°C	ISO 75-2/A
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+15	ohms·cm	IEC 60250



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Processing Information		
Injection		Unit
Drying Temperature	100 to 120	°C
Drying Time	3.0 to 5.0	hr
Hopper Temperature	240 to 260	°C
Middle Temperature	260 to 290	°C
Front Temperature	260 to 290	°C
Nozzle Temperature	260 to 290	°C
Mold Temperature	80 to 100	°C

