



**Product Data Sheet &
General Processing Conditions**

**ZOVGOV® M20G4
Nylon 6/6 (PA)
Glass Fiber
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

| PERMANENCE | | STANDARD |
|---------------------------|------------------------|-----------------|
| Primary Additive | 20 % | |
| Density | 1.30 g/cm ³ | ISO 1183 |
| Shrinkage, 4 mm Thickness | | |
| Flow direction | 0.10 - 0.40 % | ISO 294-4 |
| MECHANICAL | | |
| Impact Strength, Izod | | |
| Notched, 4 mm thickness | 8 kJ/m ² | ISO 180/1A |
| Unnotched, 4 mm thickness | 55 kJ/m ² | ISO 180/1U |
| Tensile Strength | 150 MPa | ISO 527 |
| Tensile Elongation | 3.0 - 4.0 % | ISO 527 |
| Tensile Modulus | 7500 MPa | ISO 527 |
| Flexural Strength | 225 MPa | ISO 178 |
| Flexural Modulus | 7000 MPa | ISO 178 |

THERMAL

| | | |
|---|--------|--------|
| Heat Deflection Temperature @ 1.80 MPa | 245 °C | ISO 75 |
|---|--------|--------|

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.
Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

GENERAL PROCESSING FOR INJECTION MOLDING

| | |
|--------------------|----------------|
| Injection Pressure | 70 - 125 MPa |
| Injection Pressure | 680 - 1240 bar |
| Melt Temperature | 275 - 300 °C |
| Mold Temperature | 65 - 105 °C |
| Drying | 4 hrs @ 80 °C |
| Moisture Content | 0.20 % |
| Dew Point | -25 °C |

PROCESSING NOTES

Desiccant Type Dryer Required.