



Kimia Baspar Golpa

PA6FR300

PA6+Flame Retardant

General Information

● **Characteristic:** Injection grade, Medium Impact, Flame Retardant, Good Mold Release

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C, 3.2mm	KJ/m2	5
Rock well hardness	ASTM D-785	R-Scal	R-Scal	118
Tensile Strength at yield	ASTM D638	23°C, 50 mm/min	Mpa	72
Elongation at break			%	20
Flexural modulus	ASTM D790	23°C 10mm/min	Mpa	2800
Flexural strength			Mpa	108
Flammability				
Flammability	UL94	¼ inch (3.2 mm)	V-0 (<76mm/min)	V-0
Thermal Property				
HDT(Heat Deflection Temp)	ASTM D648	unannealed 0.46MPa	°C	130
HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	70
Polymer property				
Melting Point	DSC Method	°C	220
Density	ASTMD792	23°C	g/cm3	1.15
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.8~1.4
Water Absorption	ASTM D570	23°C, water, 24h	%	1.2
Electrical				
Dielectric Strength	ASTM D149	Kv/mm	20
Volume Resistivity	ASTM D257	Ω.cm	10 ¹³ ~10 ¹⁵
Dielectric Constant	ASTM D150	10 ⁶ HZ	3.8

1-typical values are not our specification and not be used for part or tool design.

2-all properties ,except Melt Flow Index are measured on injection molded specimens and after 48 hour storage at 23°C and in RH of 50%..

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PA6FR300 PA6+Flame Retardant**Processing guid (Injection molding condition)**

Processing parameters	unit	value
Drying Temperature	°C	70~80
Drying Time	hrs	2~4
Moisture content	%	<0.1
Melt Temperature	°C	220
Cylinder Temperature	Reare	°C 210~220
	Middle	°C 210~220
	Front	°C 210~220
Nozzel Temperature	°C	220~230
Mold Temperature	°C	70~80
Injection Pressure	kg/cm ²	60~150
Screw Speed	rpm	30~60

Note):Some modifications may be required depending on the specific molding equipment and part configuration.

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