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PA6HIG130 PA6+Glass Fiber

General Information

●Characteristic:Injection grade,Medium Impact,Dimension Stability, Rigidity Mechanical Strength ,High Temprature Resistance

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23ºC,3.2mm	KJ/m2	12
Rock well hardness	ASTM D-785	R-Scal	R-Scal	….
Tensile Strength at yield	ASTM D638	23ºc , 50 mm/min	Mpa	165
Elongation at break			%	5
Flexural modulus	ASTM D790	23ºc 10mm/min	Mpa	7000
Flexural strength			Mpa	220
Flammability				
Flammability	UL94	⅛ inch (3.2 mm)	HB (<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temp)	ASTM D648	unannealed0.46MPa	°C	216
HDT(Heat Deflection Temp)	ASTM D648	unannealed1.8MPa	°C	210
Polymer property				
Melting Point	DSC Method	…..	°C	220
Density	ASTMD792	23ºc	g/cm3	1/36
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.4~0.8
Water Absorption	ASTM D570	23ºc,water,24h	%	1/25
Electrical				
Dielectric Strength	ASTM D149	….	Kv/mm	22
Volume Resistivity	ASTM D257	….	Ω.cm	10^{13}~10^{15}
Dielectric Constant	ASTM D150	….	10^{6}HZ	4

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

2-all propertes ,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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Processing guid (Injection molding condition)

Processing parameters		unit	value
Drying Temprature		℃	90~110
Drying Time		hrs	2~4
Moisture content		%	<0.1
Melt Temprature		℃	220
Cylinder Tempratre	Reare	℃	230~240
	Middle	℃	230~240
	Front	℃	230~240
Nozzel Temprature		℃	240~250
Mold Temprature		℃	70~90
Injection Pressure		kg/cm2	60~150
Screw Speed		rpm	30~60

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