



# Kimia Baspar Golpa

**PA6HIM115**

**High Impact Polyamide**

## General Information

● **Characteristic:** Injection grade, High Impact, good strength, Good stiffness and toughness, chemical and abrasion resistance, Weather Resistance, High scratch resistance

● **Application:** Interior parts – door handle part.

## Physical Property

Property	Test method	Test condition	Unit	Nominal Values
<b>Mechanical Property</b>				
Notched Izod impact	ASTM D256	23°C, 3.2mm	KJ/m <sup>2</sup>	30
Rock well hardness	ASTM D-785	R-Scal	R-Scal	105
Tensile Strength at yield	ASTM D638	23°C, 50 mm/min	Mpa	50
Elongation at break			%	>200
Flexural modulus	ASTM D790	23°C 10mm/min	Mpa	1400
Flexural strength			Mpa	60
<b>Flammability</b>				
Flammability	UL94	¼ inch (3.2 mm)	HB (<76mm/min)	HB
<b>Thermal Property</b>				
HDT(Heat Deflection Temp)	ASTM D648	unannealed 0.46MPa	°C	110
HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	51
<b>Polymer property</b>				
Melting Point	DSC Method	....	°C	220
Density	ASTM D792	23°C	g/cm <sup>3</sup>	1/06
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.8~2.4
Water Absorption	ASTM D570	23°C, water, 24h	%	1/2
<b>Electrical</b>				
Dielectric Strength	ASTM D149	....	Kv/mm	19
Volume Resistivity	ASTM D257	....	Ω.cm	3*10 <sup>13</sup>
Dielectric Constant	ASTM D150	....	10 <sup>6</sup> HZ	3

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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**PA6HIM115****High Impact Polyamide****Processing guid (Injection molding condition)**

Processing parameters	unit	value
Drying Temperature	°C	90~110
Drying Time	hrs	2~4
Moisture content	%	<0.1
Melt Temperature	°C	220
Cylinder Temperature	Reare	°C 220~230
	Middle	°C 220~220
	Front	°C 220~230
Nozzel Temperature	°C	230~240
Mold Temperature	°C	60~80
Injection Pressure	kg/cm <sup>2</sup>	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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