



Kimia Baspar Golpa

PA6MIG115

PA6+Glass Fiber

General Information

● **Characteristic:** Injection grade, Medium Impact, good strength, chemical and abrasion resistance., Dimension Stability, High Rigidity, High Temperature Resistance

Physical Property

| Property | Test method | Test condition | Unit | Nominal Values |
|----------------------------|-------------|--------------------|--------------------|------------------------------------|
| Mechanical Property | | | | |
| Notched Izod impact | ASTM D256 | 23°C, 3.2mm | KJ/m2 | 8 |
| Rock well hardness | ASTM D-785 | R-Scal | R-Scal | 120 |
| Tensile Strength at yield | ASTM D638 | 23°C , 50 mm/min | Mpa | 125 |
| Elongation at break | | | % | 6 |
| Flexural modulus | ASTM D790 | 23°C 10mm/min | Mpa | 5000 |
| Flexural strength | | | Mpa | 170 |
| Flammability | | | | |
| Flammability | UL94 | ¼ inch (3.2 mm) | HB (<76mm/min) | HB |
| Thermal Property | | | | |
| HDT(Heat Deflection Temp) | ASTM D648 | unannealed 0.46MPa | °C | 200 |
| HDT(Heat Deflection Temp) | ASTM D648 | unannealed 1.8MPa | °C | 135 |
| Polymer property | | | | |
| Melting Point | DSC Method | | °C | 220 |
| Density | ASTMD792 | 23°C | g/cm3 | 1/23 |
| Mold shrinkage | ASTM D955 | 100*100*3.2 mm | % | 0.7~1.1 |
| Water Absorption | ASTM D570 | 23°C, water, 24h | % | 1/5 |
| 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 |

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%..

www.kbgco.ir

PA6MIG115**PA6+Glass Fiber****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 210~220 |
| | Middle | °C 220~230 |
| | Front | °C 220~230 |
| Nozzel Temperature | °C | 230~240 |
| Mold Temperature | °C | 60~80 |
| 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.

www.kbgco.ir