



Kimia Baspar Golpa

PA6MF40

PA6+Mineral Filler

General Information

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

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
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Mechanical Property

Notched Izod impact	ASTM D256	23°C, 3.2mm	KJ/m2	6
Rock well hardness	ASTM D-785	R-Scal	R-Scal	80
Tensile Strength at yield	ASTM D638	23°C, 50 mm/min	Mpa	90
Elongation at break			%	8
Flexural modulus	ASTM D790	23°C 10mm/min	Mpa	5000
Flexural strength			Mpa	76

Flammability

Flammability	UL94	1/8 inch (3.2 mm)	HB (<76mm/min)	HB
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Thermal Property

HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	105
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Polymer property

Melting Point	DSC Method		°C	230
Density	ASTM D792	23°C	g/cm3	1.46
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.9~1.3
Water Absorption	ASTM D570	23°C, water, 24h	%	1.7

Electrical

Dielectric Strength	ASTM D149		Kv/mm	35
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%..

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Processing guid (Injection molding condition)			
Processing parameters		unit	value
Drying Temprature		°C	90~110
Drying Time		hrs	2~4
Moisture content		%	<0.1
Melt Temprature		°C	220
Cylinder Tempratre	Reare	°C	220~230
	Middle	°C	220~230
	Front	°C	220~230
Nozzel Temprature		°C	230~240
Mold Temprature		°C	60~80
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.

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