



Kimia Baspar Golpa

PA6MIG120

PA6+Glass Fiber

General Information

● **Characteristic:** Injection grade, Medium Impact, Dimension Stability, Rigidity Mechanical Strength, 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/m ²	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	210
HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	200
Polymer property				
Melting Point	DSC Method	°C	220
Density	ASTM D792	23°C	g/cm ³	1/23
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	0.6~0.8
Water Absorption	ASTM D570	23°C, water, 24h	%	1/4
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 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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PA6MIG120**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 230~240
	Middle	°C 230~240
	Front	°C 230~240
Nozzel Temperature	°C	240~250
Mold Temperature	°C	70~90
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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