



|                                                                  |                      |                                      |        |         |
|------------------------------------------------------------------|----------------------|--------------------------------------|--------|---------|
|                                                                  |                      |                                      |        |         |
| ·15% ,25% 6<br>15% glass fiber reinforced 25% mineral filled PA6 |                      | · Injection molding                  |        |         |
| · Excellent heat stability                                       |                      | · Good mechanical properties balance |        |         |
|                                                                  |                      |                                      |        |         |
|                                                                  |                      |                                      |        |         |
|                                                                  |                      |                                      |        |         |
| Specific Gravity                                                 | ISO 1183             | 23                                   | g/cm³  | 1.48    |
| Ash                                                              | ISO 3451             | 600 ,30min                           | %      | 40      |
|                                                                  |                      |                                      |        |         |
| Tensile Strength                                                 | ISO 527              | 5mm/min                              | MPa    | 120     |
| Elongation at break                                              | ISO 527              | 5mm/min                              | MPa    | 2.5     |
| Tensile Modulus                                                  | ISO 527              | 1mm/min                              | MPa    | 8000    |
| Flexural Strength                                                | ISO 178              | 2mm/min                              | MPa    | 170     |
| Flexural Modulus                                                 | ISO 178              | 2mm/min                              | MPa    | 7000    |
| Char θ 2                                                         | ISO 75               | 23                                   | kJ/m²  | 5       |
| Charpy Unnotched Impact Strength                                 | ISO 179-1eU          | 23                                   | kJ/m²  | 50      |
|                                                                  |                      |                                      |        |         |
|                                                                  |                      |                                      |        | 190     |
|                                                                  |                      |                                      |        | 220     |
|                                                                  |                      |                                      |        |         |
| Mold Shrinkage                                                   | internal test method | flow direction                       | %      | 0.1-0.4 |
|                                                                  |                      | cross flow direction                 |        | 0.5-0.8 |
| Flammability                                                     | ISO 3795             | —                                    | mm/min | 15      |

The data above is typical value for reference, not guarantee value. The data will vary with tool design such as gate type , gate location, gate number, injection molding process and part thickness. The data will vary with different color as well. Prior to use the material, please consult with Sunway polymer.

|                    |          |                |
|--------------------|----------|----------------|
|                    |          |                |
| Melt Temperature   |          | 240-270        |
| Barrel Temperature | , Rear   | 240--250       |
|                    | , Center | 255--265       |
|                    | , Front  | 260--270       |
| Mold Temperature   |          | 60-90          |
| Pre-Dry needed     |          | 110-120 , 4-8h |

The above process condition is only for reference. The actual process should be adjusted according to different type of machine, mold design and product design.

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