



·30% 6 30% mineral filled PA6	· Injection molding
· Excellent heat stability	· Good mechanical properties balance

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Specific Gravity	ISO 1183	23	g/cm ³	1.36
Ash	ISO 3451	800 ,30min	%	30

Tensile Strength	ISO 527	5mm/min	MPa	78
Elongation at break	ISO 527	5mm/min	MPa	3
Tensile Modulus	ISO 527	1mm/min	MPa	5000
Flexural Strength	ISO 178	2mm/min	MPa	120
Flexural Modulus	ISO 178	2mm/min	MPa	4200
Charpy Notched Impact Strength	ISO 179-1eA	23	kJ/m ²	4
Charpy Unnotched Impact Strength	ISO 179-1eU	23	kJ/m ²	50

Heat Deflection Temp	ISO 75	0.45MPa		190
		1.8MPa		75
Melting Point	ISO 11357	DSC		220

Mold Shrinkage	internal test method	48 hours after tool	%	0.5-0.8
Flammability	ISO 3795	—	mm/min	30

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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