



PA6		Injection molding		
Good mechanical properties balance				
Specific Gravity	ISO 1183	23	g/cm ³	1.14
Tensile Strength	ISO 527	50mm/min	MPa	75
Tensile Modulus	ISO 527	1mm/min	MPa	2700
Elongation at Break	ISO 527	50mm/min	%	10
Flexural Strength	ISO 178	2mm/min	MPa	105
Flexural Modulus	ISO 178	2mm/min	MPa	2300
Unnotched Charpy Impact Strength	ISO 179-1	23	kJ/m ²	NB
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m ²	6
Heat deflection temperature	ISO 75	0.45MPa		160
		1.80MPa		55
Melt Temperature	ISO 11357	DSC		220
Mold Shrinkage	internal test method	48 hours after tool	%	1.0-1.5
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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