



PA66		Injection molding		
Good mechanical properties balance				
Specific Gravity	ISO 1183	23	g/cm ³	1.14
Tensile Strength	ISO 527	50mm/min	MPa	75/50
Tensile Modulus	ISO 527	1mm/min	MPa	—
Elongation	ISO 527	50mm/min	%	15/40
Flexural Strength	ISO 178	2mm/min	MPa	—
Flexural Modulus	ISO 178	2mm/min	MPa	—
Unnotched Charpy Impact Strength	ISO 179-1	23	kJ/m ²	NB/NB
Notched Charpy Impact Strength	ISO 179-1/1eA	23	kJ/m ²	6/15
Heat deflection temperature	ISO 75	0.45MPa		—
		1.80MPa		72
Melting temperature	ISO 11357	DSC		260
Mold Shrinkage	internal test method	flow direction	%	0.70-0.90
		cross flow direction	%	1.20-1.40
Flammability	ISO 3795	—	mm/min	36

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		260-290
Barrel Temperature	, Rear	260--270
	, Center	270--280
	, Front	280--290
Mold Temperature		70-80
Pre-Dry needed		100-110 , 4-6h

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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