

AIE PA6 50G3

Polyamide 6

Asia International Enterprise (Hong Kong) Limited

Message:

AIE PA6 50G3 is a polyamide 6 (nylon 6) material, which contains a filler of 15% glass fabric reinforcement. This product is available in North America, Africa and the Middle East, Latin America, Europe or Asia Pacific. The processing method is injection molding.

The main features of AIE PA6 50G3 are:

- flame retardant/rated flame
- high liquidity

General Information			
Filler / Reinforcement	Glass fabric reinforcement, 15% filler by weight		
Features	High liquidity		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.25	g/cm ³	ISO 1183
Molding Shrinkage	0.40 - 0.80	%	Internal method
Water Absorption (23°C, 24 hr)	1.7	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	110	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	7100	MPa	ISO 178
Flexural Stress	170	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	18	kJ/m ²	ISO 180
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, not annealed	220	°C	ISO 75-2/B
1.8 MPa, not annealed	205	°C	ISO 75-2/A
Melting Temperature (DSC)	225	°C	ISO 3146
Flammability	Nominal Value	Test Method	
Flame Rating	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	80.0 - 100	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	245 - 260	°C	
Middle Temperature	240 - 250	°C	
Front Temperature	230 - 250	°C	
Nozzle Temperature	250 - 260	°C	
Mold Temperature	50.0 - 110	°C	

Injection Pressure	30.0 - 80.0	MPa
Holding Pressure	40.0 - 50.0	MPa
Back Pressure	5.00 - 10.0	MPa
Screw Speed	40 - 70	rpm

Injection instructions

Cylinder Temperature 4: 230 to 245°C

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Recommended distributors for this material

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