

Sunny® PA6 HF230

Polyamide 6

Guangdong Shunde Shunyan New Material Co., Ltd.

Message:

EP halogen-free flame reinforced Polyamide 6

General Information			
Filler / Reinforcement	Glass Fiber,30% Filler by Weight		
Features	Flame Retardant		
	Halogen Free		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			
-- ¹	1.49	g/cm ³	ASTM D792
23°C	1.49	g/cm ³	ISO 1183
Molding Shrinkage			
Flow : 23°C	0.20 to 0.40	%	ASTM D955
23°C	0.20 to 0.40	%	ISO 294-4
Water Absorption			
Equilibrium, 23°C	1.0	%	ASTM D570
Equilibrium, 23°C, 50% RH	1.0	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength			
-- ²	120	MPa	ASTM D638
--	120	MPa	ISO 527-2/5
Tensile Elongation			
Break ³	3.8	%	ASTM D638
Break	4.0	%	ISO 527-2/5
Flexural Modulus			
50.0 mm Span	7270	MPa	ASTM D790
50.0 mm Span	7500	MPa	ISO 178
Flexural Strength			
50.0 mm Span	174	MPa	ASTM D790
-- ⁴	180	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact			
23°C	75	J/m	ASTM D256
23°C	7.0	kJ/m ²	ISO 180/1A

Flammability	Nominal Value	Test Method
Flame Rating		UL 94
1.60 mm	V-0	
3.20 mm	V-0	
Injection	Nominal Value	Unit
Drying Temperature	110 to 120	°C
Drying Time	3.0 to 4.0	hr
Rear Temperature	250	°C
Middle Temperature	240	°C
Front Temperature	240	°C
Processing (Melt) Temp	250	°C
Mold Temperature	90.0	°C
Injection Rate	Moderate-Fast	
NOTE		
1.	23°C	
2.	5.0 mm/min	
3.	5.0 mm/min	
4.	50 mm span	

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