

Kingfa PA6-T25

Polyamide 6

Kingfa

Message:

Kingfa PA6-T25 is a polyamide 6 (nylon 6) material, which contains 25% mineral fillers. This product is available in North America or Asia Pacific region.
The processing method is injection molding.
The main features of Kingfa PA6-T25 are:
flame retardant/rated flame
anti-warping
Typical application areas include:
electrical appliances
Tools
Automotive Industry
Sporting goods

General Information			
Filler / Reinforcement	Mineral filler, 25% filler by weight		
Features	Bending resistance		
Uses	Electrical appliances		
	Power/other tools		
	Application in Automobile Field		
	Sporting goods		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.32	g/cm ³	ASTM D792
Molding Shrinkage - Flow (23°C)	0.90 - 1.3	%	ASTM D955
Water Absorption (23°C, 24 hr)	0.60	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	117		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	80.0	MPa	ASTM D638
Tensile Elongation ² (Break)	10	%	ASTM D638
Flexural Modulus ³	4700	MPa	ASTM D790
Flexural Strength ⁴	120	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	65	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, unannealed, 6.40mm	212	°C	ASTM D648
1.8 MPa, unannealed, 6.40mm	165	°C	ASTM D648
Electrical	Nominal Value	Unit	Test Method

Volume Resistivity	1.0E+16	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	HB		UL 94
3.00 mm	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	90.0 - 110	°C	
Drying Time	4.0 - 6.0	hr	
Rear Temperature	225 - 245	°C	
Middle Temperature	250 - 270	°C	
Front Temperature	260 - 280	°C	
Processing (Melt) Temp	255 - 285	°C	
Mold Temperature	50.0 - 70.0	°C	
Injection Rate	Moderate-Fast		
Injection instructions			
Processing Temperature Limit: 300°C			
NOTE			
1.	10 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		

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