

AIE PA6 50G3F

Polyamide 6
Asia International Enterprise (Hong Kong) Limited

Message:

AIE PA6 50G3F 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 50G3F are:

- flame retardant/rated flame
- Flame Retardant
- Heat resistance

General Information			
Filler / Reinforcement	Glass fabric reinforcement, 15% filler by weight		
Features	Heat resistance, high		
	Flame retardancy		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.50	g/cm ³	ISO 1183
Molding Shrinkage	0.40 - 0.80	%	Internal method
Water Absorption (23°C, 24 hr)	1.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	140	MPa	ISO 527-2
Tensile Strain (Break)	3.0	%	ISO 527-2
Flexural Modulus	7000	MPa	ISO 178
Flexural Stress	180	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	207	°C	ISO 75-2/B
1.8 MPa, not annealed	220	°C	ISO 75-2/A
Melting Temperature (DSC)	225	°C	ISO 3146
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm)	V-0	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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