

VENYL ST228 - 7935

Polyamide 6

AD majoris

Message:

VENYL ST228 - 7935 is a 25% mineral filled polyamide 6 impact modified intended for Injection moulding.

APPLICATIONS

VENYL ST228 - 7935 has been developed especially for very demanding applications in automotive industry and electrical parts.

VENYL ST228 - 7935 is available in both natural (VENYL ST228) and black (VENYL ST228-8229) but other colours can be provided on request.

General Information			
Filler / Reinforcement	Mineral,25% Filler by Weight		
Additive	Impact Modifier		
Features	Impact Modified		
	Recyclable Material		
Uses	Automotive Applications		
	Electrical Parts		
Appearance	Black		
	Colors Available		
	Natural Color		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.30	g/cm ³	ISO 1183
Molding Shrinkage	0.70 to 1.1	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	1.9	%	
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	4000	MPa	ISO 527-2
Tensile Stress (Break)	52.0	MPa	ISO 527-2
Tensile Strain (Break)	8.0	%	ISO 527-2
Flexural Modulus	3200	MPa	ISO 178
Flexural Stress	86.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	7.0	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength	85	kJ/m ²	ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	185	°C	ISO 75-2/B

1.8 MPa, Unannealed	165	°C	ISO 75-2/A
Melting Temperature (DSC)	220	°C	ISO 3146
Electrical	Nominal Value	Unit	Test Method
Surface Resistivity	1.0E+13	ohms	DIN 53482
Volume Resistivity	1.0E+14	ohms·cm	DIN 53482
Comparative Tracking Index (Solution A)	600	V	IEC 60112
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.60 mm)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0	hr	
Rear Temperature	255 to 270	°C	
Middle Temperature	245 to 260	°C	
Front Temperature	245 to 260	°C	
Nozzle Temperature	240 to 265	°C	
Mold Temperature	60.0 to 100	°C	
Injection Pressure	60.0 to 90.0	MPa	
Injection Rate	Fast		
Holding Pressure	50.0 to 70.0	MPa	
Screw L/D Ratio	15.0:1.0 to 20.0:1.0		

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