

Kingfa PA6-ROW

Polyamide 6

Kingfa

Message:

Kingfa PA6-ROW is a Polyamide 6 (Nylon 6) material. It is available in Asia Pacific or North America for injection molding.

Important attributes of Kingfa PA6-ROW are:

Flame Rated

Flame Retardant

Heat Resistant

Typical applications include:

Electrical/Electronic Applications

Appliances

Engineering/Industrial Parts

Household Applications

General Information			
Additive	Flame Retardant		
Features	Flame Retardant		
	Good Electrical Properties		
	High Heat Resistance		
	Non-Blooming		
Uses	Appliance Components		
	Bobbins		
	Connectors		
	Electrical/Electronic Applications		
	Household Goods		
	Plugs		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.15	g/cm ³	ASTM D792
Molding Shrinkage			ASTM D955
Flow : 23°C	1.2	%	
Across Flow : 23°C	1.5	%	
Water Absorption (23°C, 24 hr)	1.9	%	ASTM D570
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	119		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength ¹	75.0	MPa	ASTM D638
Tensile Elongation ² (Break)	8.0	%	ASTM D638
Flexural Modulus ³	3000	MPa	ASTM D790
Flexural Strength ⁴	105	MPa	ASTM D790

Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C, 3.20 mm)	45	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	205	°C	
1.8 MPa, Unannealed	85.0	°C	
Electrical	Nominal Value	Unit	Test Method
Volume Resistivity	1.0E+14	ohms·cm	ASTM D257
Flammability	Nominal Value	Unit	Test Method
Flame Rating			UL 94
1.50 mm	V-0		
3.00 mm	V-0		
Injection	Nominal Value	Unit	
Drying Temperature	90.0 to 110	°C	
Drying Time	4.0 to 6.0	hr	
Rear Temperature	205 to 225	°C	
Middle Temperature	225 to 240	°C	
Front Temperature	235 to 255	°C	
Processing (Melt) Temp	220 to 245	°C	
Mold Temperature	30.0 to 60.0	°C	
Injection Rate	Slow-Moderate		
NOTE			
1.	50 mm/min		
2.	50 mm/min		
3.	2.0 mm/min		
4.	2.0 mm/min		

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