

AIE PA6 50G6F

Polyamide 6
Asia International Enterprise (Hong Kong) Limited

Message:

AIE PA6 50G6F is a polyamide 6 (nylon 6) material, which contains a filler of 30% 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 50G6F are:

- flame retardant/rated flame
- Flame Retardant
- Hard
- Good dimensional stability

General Information			
Filler / Reinforcement	Glass fabric reinforcement, 30% filler by weight		
Features	Good dimensional stability		
	Rigidity, high		
	Flame retardancy		
Forms	Particle		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Density	1.63	g/cm ³	ISO 1183
Molding Shrinkage	0.30 - 0.60	%	Internal method
Water Absorption (23°C, 24 hr)	1.6	%	ISO 62
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	150	MPa	ISO 527-2
Tensile Strain (Break)	2.6	%	ISO 527-2
Flexural Modulus	8100	MPa	ISO 178
Flexural Stress	260	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
Electrical	Nominal Value	Unit	Test Method
Comparative Tracking Index (CTI)	PLC 2		UL 746
Flammability	Nominal Value	Unit	Test Method
Flame Rating (1.50 mm)	V-0		UL 94
Glow Wire Ignition Temperature (1.60 mm)	960	°C	IEC 60695-2-13
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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