

KIMIALON[®] 6(B330G)

MATERIAL NAME: PA6

COLOR: BLACK

CODE: B330G

MATERIAL DESCRIPTION: Kimialon[®] B330G is a 30% glass fiber reinforced, black Polyamide 6 resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
GENERAL					
1	ASH CONTENT		ISO 3451	%	30.00
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.31
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.21
MECHANICAL					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	79.3
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	6.7
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	7899.1
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	7.19
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	50
THERMAL					
10	HARDNESS		ISO 868	Shore D	74
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	211.9
		50N			160.2
BEHAVIOR IN FIRE					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	174.3
		66psi			89.2
14	Flammability	Class	UL94	-	-
INJECTION PROCESS PARAMETERS					
<i>Loading</i>		<i>Injection</i>		<i>Degassing</i>	
<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Temperature</i>	<i>Time</i>
60	60	65	65	70 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		230 °C	230 °C	230 °C	240 °C
				2	1
				240 °C	240 °C