

KIMIALON® 6(B345G)

MATERIAL NAME: PA6

COLOR: BLACK

CODE: B345G

MATERIAL DESCRIPTION: Kimialon® B345G is a 45% glass fiber reinforced, black color Polyamide 6 resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
GENERAL					
1	ASH CONTENT		ISO 3451	%	45.00
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.48
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.27
MECHANICAL					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	131.4
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	5.8
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	10533.2
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	7.81
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	37.13
THERMAL					
10	HARDNESS		ISO 868	Shore D	77
11	MFI		ASTM/D1238	g/10min	---
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	219.9
		50N			174.1
BEHAVIOR IN FIRE					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	184.5
		66psi			90.1
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>
70	70	70	80	70 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		240 °C	240 °C	240 °C	250 °C
					250 °C