

KIMIALON[®] 6(B535G)

MATERIAL NAME: PA6 **COLOR: Black** **CODE: B535G**

MATERIAL DESCRIPTION: Kimialon[®] **B535G** is a 35% glass fiber reinforced, heat stabilized, regenerated Polyamide 6 resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
PHYSICAL PROPERTIES					
1	ASH CONTENT		ISO 3451	%	35
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.41
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.21
MECHANICAL PROPERTIES					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	154
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	9.5
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	10700.0
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	13
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	63
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	77
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	222
		50N			214
FLAMMABILITY					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	208
		66psi			220
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	90	80	100	80 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		- °C	215 °C	220 °C	225 °C
					1
					230 °C