

KIMIALON[®] PA6.6(B150)

MATERIAL NAME: PA6.6 **COLOR: Black** **CODE: B150G**

MATERIAL DESCRIPTION: Kimialon[®] PA6.6(B150G) is a 50% glass fiber reinforced, Black; regenerated Polyamide 6.6 resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
PHYSICAL PROPERTIES					
1	ASH CONTENT		ISO 3451	%	50
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.56
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.22
MECHANICAL PROPERTIES					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	>185
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	8.5
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	13500
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	12.4
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	58
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	79
11	MFI		ASTM/D1238	g/10min	---
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	>270
		50N			
FLAMMABILITY					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	>260
		66psi			
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	80	95	120	80 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		- °C	260 °C	265 °C	270 °C