



Kimia Baspar Golpa

PA6FR600**PA6+Flame Retardant**

General Information

● **Characteristic:** Injection grade, Medium Impact, Flame Retardant, Good Mold Release

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
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Mechanical Property

Notched Izod impact	ASTM D256	23°C, 3.2mm	KJ/m2	6
Rock well hardness	ASTM D-785	R-Scal	R-Scal	78
Tensile Strength at yield	ASTM D638	23°C, 50 mm/min	Mpa	60
Elongation at break			%	12
Flexural modulus	ASTM D790	23°C 10mm/min	Mpa	2200
Flexural strength			Mpa	92

Flammability

Flammability	UL94	¼ inch (3.2 mm)	V-0 (<76mm/min)	V-0
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Thermal Property

HDT(Heat Deflection Temp)	ASTM D648	unannealed 0.46MPa	°C	190
HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	85

Polymer property

Melting Point	DSC Method		°C	220
Density	ASTMD792	23°C	g/cm3	1.3
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1/5~1.5
Water Absorption	ASTM D570	23°C, water, 24h	%	1.2

Electrical

Dielectric Strength	ASTM D149		Kv/mm	25
Volume Resistivity	ASTM D257		Ω.cm	10 ¹³ ~10 ¹⁵
Dielectric Constant	ASTM D150		10 ⁶ HZ	3.1

1-typical values are not our specification and not be used for part or tool design.

2-all properties ,except Melt Flow Index are measured on injection molded specimens and after 48 hour storage at 23°C and in RH of 50%..

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PA6FR300	PA6+Flame Retardant
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Processing guid (Injection molding condition)
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Processing parameters	unit	value
Drying Temprature	°C	70~80
Drying Time	hrs	2~4
Moisture content	%	<0.1
Melt Temprature	°C	220
Cylinder Tempratre	Reare	°C 210~220
	Middle	°C 210~220
	Front	°C 210~220
Nozzel Temprature	°C	220~230
Mold Temprature	°C	70~80
Injection Pressure	kg/cm2	60~150
Screw Speed	rpm	30~60

Note):Some modifications may be required depending on the specific molding equipment and part configuration.

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