



Kimia Baspar Golpa

PA6HIM115

High Impact Polyamide

General Information

● **Characteristic:** Injection grade, High Impact, good strength, Good stiffness and toughness, chemical and abrasion resistance., Weather Resistance, High scratch resistance

● **Application:** Interior parts – door handle part.

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/m ²	20
Rock well hardness	ASTM D-785	R-Scal	R-Scal	76
Tensile Strength at yield	ASTM D638	23°C, 50 mm/min	Mpa	55
Elongation at break			%	>60
Flexural modulus	ASTM D790	23°C 10mm/min	Mpa	1300
Flexural strength			Mpa	36

Flammability

Flammability	UL94	⅜ inch (3.2 mm)	HB (<76mm/min)	HB
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Thermal Property

HDT(Heat Deflection Temp)	ASTM D648	unannealed 0.46MPa	°C	165
HDT(Heat Deflection Temp)	ASTM D648	unannealed 1.8MPa	°C	62

Polymer property

Melting Point	DSC Method		°C	215
Density	ASTMD792	23°C	g/cm ³	1.1
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	12~1.7
Water Absorption	ASTM D570	23°C, water, 24h	%	2.7

Electrical

Dielectric Strength	ASTM D149		Kv/mm	32
Volume Resistivity	ASTM D257		Ω.cm	3*10 ¹³
Dielectric Constant	ASTM D150		10 ⁶ HZ	3.1

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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Processing guid (Injection molding condition)
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Processing parameters	unit	value
Drying Temperature	°C	90~110
Drying Time	hrs	2~4
Moisture content	%	<0.1
Melt Temperature	°C	220
Cylinder Tempratre	Reare	°C 220~230
	Middle	°C 220~220
	Front	°C 220~230
Nozzel Temperature	°C	230~240
Mold Temperature	°C	60~80
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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