



Kimia Baspar Golpa

PA6MF20

PA6+Mineral Filler

General Information

● **Characteristic:** Injection grade, Medium Impact, good strength, chemical and abrasion resistance., Dimension Stability, Medium Rigidity, Medium Temperature Resistance

Physical Property

Property	Test method	Test condition	Unit	Nominal Values
Mechanical Property				
Notched Izod impact	ASTM D256	23°C,3.2mm	KJ/m2	8
Rock well hardness	ASTM D-785	R-Scal	R-Scal	75
Tensile Strength at yield	ASTM D638	23°c , 50 mm/min	Mpa	60
Elongation at break			%	10
Flexural modulus	ASTM D790	23°c 10mm/min	Mpa	2850
Flexural strength			Mpa	70
Flammability				
Flammability	UL94	⅜ inch (3.2 mm)	HB (<76mm/min)	HB
Thermal Property				
HDT(Heat Deflection Temp)	ASTM D648	unannealed1.8MPa	°C	90
Polymer property				
Melting Point	DSC Method		°C	220
Density	ASTMD792	23°c	g/cm3	1.25
Mold shrinkage	ASTM D955	100*100*3.2 mm	%	1.0~1.3
Water Absorption	ASTM D570	23°c,water,24h	%	1.7
Electrical				
Dielectric Strength	ASTM D149		Kv/mm	20
Volume Resistivity	ASTM D257		Ω.cm	10 ¹³ ~10 ¹⁵
Dielectric Constant	ASTM D150		10°HZ	4

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)			
Processing parameters		unit	value
Drying Temperature		°C	90~110
Drying Time		hrs	2~4
Moisture content		%	<0.1
Melt Temprature		°C	220
Cylinder Tempratre	Reare	°C	220~230
	Middle	°C	220~230
	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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