

EPONE Engineering Plastics

National innovation fund project enterprise

ISO9001:2008 certificated

ISO/TS16949 certificated

ZGDBSLV PA6B30CBK101

产品定义: PA6+ GF30%

产品特点: 30%玻璃纤维增强尼龙 6, 表面光洁度优异

产品应用: 汽车风扇支架、电动工具外壳及配件等

ZGDBSLV PA6B30CBK101 is a 30% glass-fiber reinforced PA6 for injection molding, it provides prominent surface finish, in addition to providing good mechanical properties.

Product applications: vehicle fan stents, shell of electric tools and other accessory, etc

典型成型条件

typical molding process

干燥 dry	鼓风烘箱(drum wind oven): 100-120℃, 4-6h ; 热风循环(cycling warm air): 100-120℃, 4-6h ; 真空烘箱(vacuum drying oven): 100-120℃, 3-4h
加工温度 processing temperature	入料段(feed section): 215-225℃; 熔融段(compressing section): 250-280℃; 射嘴段(metering section): 250-280℃
背压 back pressure	5-10Mpa
注射压力 injection pressure	70-130Mpa
保压压力 packing pressure	40-90Mpa
模具温度 mold temperature	70-100℃
后处理 post treatment	NA
其它 others	NA

以上数据仅供参考

All the information provided by EPONE only for reference

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产品性能参数

product performance parameters

性能 (properties)	测试标准 (test standard)	单位 (unit)	数据 (test result)
<b>物理性能 (physical properties)</b>			
密度 density	ISO 1183	g/cm <sup>3</sup>	1.38
熔点 melting temperature	ISO 11357	°C	220
<b>吸湿性 absorption of moisture</b>			
23°C冷水中 24 小时 24 hours in 23°C water	ISO 62	%	---
<b>成型收缩率 molding shrinkage</b>			
纵向 normal	ISO 25557/1	%	0.85
横向 parallel	ISO 25557/1	%	0.45
<b>机械性能 (mechanical properties)</b>			
<b>冲击 impact strength</b>			
无缺口冲击强度 non-notched	ISO 179	kJ/M <sup>2</sup>	70
缺口冲击强度 notched	ISO 180	kJ/M <sup>2</sup>	12
<b>拉伸 tensile</b>			
断裂强度 tensile strength	ISO 527-2	MPa	170
断裂伸长率 elongation at break	ISO 527-2	%	12
<b>弯曲 flexural</b>			
断裂强度 flexural strength	ISO 178	MPa	245
弯曲弹性模量 flexural modulus	ISO 178	MPa	8800
<b>硬度 hardness</b>			
洛氏硬度 rockwell hardness	ISO 2039-2	R	120
<b>电气性能 (electrical properties)</b>			
体积电阻率 volume resistivity	IEC 60093	Ω .cm	10 <sup>15</sup>
表面电阻率 surface resistivity	IEC 60093	Ω	10 <sup>13</sup>
介电强度 dielectric strength	IEC 60243	kV/mm	22
<b>燃烧性能 (flammability properties)</b>			
阻燃 flame retardant	UL 94	—	HB

除特别说明外，以上数据均指在环境相对湿度 (RH) =0 及 23°C 条件下测得  
以上数据为典型值，仅供参考，不作质量保证之承诺。

All the data above was measured at 23°C and RH=0 unless otherwise stated, all is typical data , only for reference, not the permit of quality assurance.

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