

PA6 and Modified Compounding

Grade	ASTM Method	Unit	SN504	SN501G15	SN501G30	SN501G30-F	SN501G40AH	SN501G50AH	SN501M30	SN502-NH	SN502	SN502G30
Material			ST-PA6	PA6/GF15	PA6/GF30	PA6/GF30	PA6/GF40	PA6/GF50	PA6/MF30	FR-PA6	FR-PA6	FR-PA6/GF30
			Ultra Impact	Standard	Standard	Impact Improved	L.W.A	L.W.A	Standard	N.H.	Standard	Standard
Specific Gravity	D792		1.08	1.22	1.35	1.34	1.43	1.54	1.35	1.22	1.28	1.59
Mold Shrinkage	D955	%	1.0~1.5	0.3~0.6	0.2~0.6	0.2~0.6	0.2~0.4	0.1~0.3	0.9~1.4	1.2~1.6	1.2~1.6	0.2~0.6
Tensile Strength	D638	kgf/cm ²	500	1200	1700	1600	1650	1850	850	620	700	1700
Elongation	D638	%	50	4	4	4	5	5	14	10	4	3
Flexural Strength	D790	kgf/cm ²	650	1700	2350	2200	2400	2500	1600	780	900	2400
Flexural Modulus	D790	kgf/cm ²	15000	50000	95000	80000	100000	120000	41000	27000	30000	100000
Izod Impact	D256	kgf-cm/cm	90	6	11	17	12	15	6	6	5	11
H.D.T.	D648	°C	65	200	200	200	210	210	110	70	80	200
Flammability	UL94		HB	HB	HB	HB	HB	HB	HB	V0	V0	V0

Drying Temp.		°C	120	120	120	120	120	120	120	120	120	120
Drying Time		HR	3	4	4	4	4	4	4	3	4	4
Melt Temp.		°C	240~270	240~270	240~270	240~270	240~270	250~280	260~290	230~250	230~250	240~270
Mold Temp.		°C	60	80	80	80	100	100	80	60	60	80