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Engineering Plastics Polyamide 6

Technical Data

Mapex AN0520SB

Mapex AN0520 SB PA6 is a 25 % glass fiber reinforced product for injection moulding in black colour

Characteristics

- 1) excellent gloss
- 2) excellent electrical properties
- 3) excellent temperature resistance,
- 4) excellent mechanical and chemical property
- 5) excellent weatherability
- 6) excellent wear property
- 7) excellent mouldability
- 8) high resistance against fuels, oils, fats and many solvents

Injection Moulding Conditions

Cylinder temperatures	: 240-270 °C
Nozzle temperature	: 240-250 °C
Mould temperature	: 30-100 °C, suitable temperature 40-60 °C
Injection rate	: middle – fast
Screw speed	: 60-120 U./min, to be chosen in such a way that plasticising is just within cooling time
Pressure	Injection pressure : 500-1200 bar
	Holding pressure : 300-800 bar
	Back pressure : 0-3 bar
Mould shrinkage	Mould shrinkage 1.6 mm thickness horizon is 0,2 to 0,3 % under the test method ASTM D 955.

Packaging

25 kg Paper Bags or 800 kg Big Bags



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Material handling

Product must be dried before use 4hrs at 90 °C. Moisture pick-up from ambient air should be avoided. Keep hopper properly closed.

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Property	Value	Unit	Test Method ISO / ASTM
Melt Index (250 °C, 2,16 kg)		g / 10 min.	D 1238
Density	1,36	'g / cm ³	1183 / D 792
Melting point	220	°C	DSC
Coeff. of linear thermal expansion		10 ⁻⁵ cm/cm°K	ASTM D696
Heat deflection temperature under load			
--- 1,8 M Pa	215	°C	75-2 A / D 648
--- 0,45 M Pa		°C	75 – 2 B /
Moisture absorption (24 h)		%	62 / D570
Flammability UL 94 3,2 mm thickness	HB	-	1210 / UL 94
Tensile strength	131	M Pa	ISO 527- 2
Tensile elongation	2,5	%	ISO 527-2
Flexural strength	186	M Pa	ISO 178
Flexural Modulus	7586	M Pa	ISO 178
Izod impact strength – notched ¼”	69	kg cm/ cm	ISO 180/1
Hardness Rockwell	-	M	ASTM D785
Dielectric strength 2mm thickness		KV/ mm	243 / D 149
Volume resistivity		Ω- cm	IEC 167
Surface resistivity		Ω	IEC 93
Dielectric constant		60Hz	ASTM D150



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Dielectric loss factor	60Hz	ASTM D150
Arc resistance	SEC	ASTM D495

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