ENRICH POLYMERS

Technical data sheet

SKB Industries

ENAMIDE 11030BK01

PA6-GF Compound

Product Description

Polyamide 6-Glass Fibre Reinforced, 30%

Product Application

Automotive: Plug & Socket, Switch Parts, Handle, and Grab Handle

Electrical & Electronic: MCB, RCCB, Rotor Switch, Relay, Inverter Parts and Terminal Block

General

Material Status	Commercial: Active
Filler/Reinforcement	Glass Fibre reinforcement, 30%
Forms	Pellets
Additive	Mold Release
Appearance/Colour	Black
Processing Method	Injection molding

Physical & Rheological Properties	Specification	Unit	Test Method
Melt Flow Index	8-12	G/10min	ASTM-D1238
Density	1.33-1.39	G/cc	ASTM-D792
Shrinkage	0.4-0.6	%	ASTM-D955
Filler Content	28-32	%	ASTM-D5630

Mechanical Properties	Specification	Unit	Test Method
Tensile Strength @ Yield	1200-1300	Kg/cm2	ASTM-D638
Elongation @ Break	5-9	%	ASTM-D638
Flexural Strength	1600-1800	Kg/cm2	ASTM-D790
Flexural Modulus	6500-7500	Mpa	ASTM-D790
Notch Izod Impact Strength(23°©)	6-10	Kg cm/cm	ASTM -D256

Thermal	Specification	Unit	Test Method
Heat Deflection Temperature 0.45Mpa Unannealed 1.8Mpa Unannealed	200-210	°©	ASTM-D648

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Drying Conditions

General Processing Condition –Injection moulding dry Material Polyamide moisture during temperature should not be more than 90 to 120°© two to three hours for material exposed to the atmosphere. Moisture content after drying should be <0.02% avoid sudden cooling of dry pellet.

Injection molding Temperature(°©)

Feed zone	Transition zone	Metering zone	Nozzle	Mold
210°© - 220°©	220°© - 230°©	230°© - 240°©	240°© - 250°©	60°© - 80°©

Physical form and Packaging/Storage

ENRICH POLYMERS ENAMIDE is supplied in pellet form. It should be pre-dried as per guideline mentioned above prior to molding. Standard packing size is 25kg. In order to prevent moisture pick up and contamination supplied packaging should be kept closed and undamaged.

Material Safety

ENRICH POLYMERS ENAMIDE is thermally stable up to 140°© and does not give rise to hazardous material due to degradation or evolution of gases and vapors. ENRICH POLYMERS ENAMIDE decomposes above 350°©and gives carbon dioxide and water on charring.

For more information on safety, refer individual material MSDS. Available on request.

Note

All information supplied in this publication is based on our current knowledge and experience. The data provided fall within the normal range of material properties and relate only to the specific material designed. The data provided should not be used to establish specification limits or used alone as the basis of design. ENRICH POLYMERS assumes no liability and makes no warranties of any kind expressed or implied, whatsoever in respect of application, processing or use made of aforementioned information or product.