

TECHNICAL DATASHEET

TRAMID[®] 4110GNH35

PA6

PROPERTY	UNIT	ASTM METHOD	TYPICAL DATA
PHYSICAL			
MECHANICAL			
Tensile Strength at yield	kg _f /cm ²	D638	1,450
Tensile Elongation at break	%	D638	> 1.5
Flexural Strength at yield	kg _f /cm ²	D790	1,950
Flexural Modulus	kg _f /cm ²	D790	89,500
Izod Impact Strength, notched, 23°C (1/8")	kg _f ·cm/cm	D256	9.5
THERMAL			
HDT, 18.6 kg _f /cm ²	°C	D648	207
ELECTRICAL			
OTHERS			
UL-94 Flammability ((1.5mm))	-	(UL 94)	VO
Mold Shrinkage	%		0.3~0.6

※ The figures listed in this table are typical values obtained under the standard test methods and may not be applicable for products that are under different application condition.

PROCESSING GUIDE

TRAMID® 4110GNH35 GRADE

PA6

- General processing conditions for TRAMID4110GNH35 are shown below. Drying prior to processing is essential to ensure desired appearance and property performance.

SPECIFICATION	UNIT	CONDITIONS
Drying Temperature	℃	80-120
Drying Time	hr	5~7
Melt Temperature	℃	240-260
Nozzle Temperature	℃	280-290
Front Temperature	℃	260-280
Middle Temperature	℃	240-260
Rear Temperature	℃	220-240
Mold Temperature	℃	60-80
Back Pressure	MPa	<70
Screw Speed	rpm	<60
Injection Pressure	MPa	<70
Injection Speed	%	<50
Hold Pressure	MPa	<50
Injection Cushion	mm	3-6

Global Network

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