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| Product Information | SN6400BM₁ |  Sam Polymer Bonyan |
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Product Description

SN6400BM₁ is a general purpose injection molding black PA6.

| Property | Test Method (ASTM) | Test Condition | Value | Unit |
|-----------------------------------|--------------------|----------------------------|-------------|-------------------|
| PHYSICAL | | | | |
| Density | D792 | 23°C | 1.23 | g/cm ³ |
| Mold Shrinkage | D955 | In Flow, (2 mm, 60 MPa) | 0.35 | % |
| | | Cross Flow, (2 mm, 60 MPa) | 0.9 | % |
| MECHANICAL | | | | |
| Tensile Strength, Yield | D638 | 23°C | 44 | MPa |
| Tensile Elongation, Yield | D638 | 23°C | 4.7 | % |
| Flexural Strength | D790 | 23°C | 70 | MPa |
| Flexural Modulus | D790 | 23°C | 2700 | MPa |
| Izod Impact Strength | D256 | notched, 23°C | 6.3 | KJ/m ² |
| THERMAL | | | | |
| Melting Point | D3418 | - | 220 | °C |
| Vicat Softening Temperature | D1525 | 50 N, heating rate 50 °C/h | 195 | °C |
| Heat Deflection Temperature (HDT) | D648 | 0.45 Mpa | 185 | °C |
| | | 1.80 Mpa | 75 | °C |

Processing Guidelines

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| Predrying | Drying Time: 2-6 h | Drying Temperature: 80-100 °C |
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|--------------------------|---------------------------|-----------------------|-----------------|--------------------------|
| Injection Molding | Cylinder Temperature (°C) | Mold Temperature (°C) | Injection Speed | Injection Pressure (MPa) |
| | 240-260 | 80-100 | Medium | 35-125 |

*All above mentioned data are typical values and not to be construed as real specifications. Users should confirm results by their own tests.