



A~Star Plastics Pte Ltd

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Company & GST Registration #: 201504765Z

Technical Data Sheet

Material Type: POLYAMIDE 66 COMPOUNDED RESIN

Grade: PA66-CP09IJ-HBIZ05

Colour: Black

Application: For General Purpose Injection Molding

Physical	Value	Unit	Test Method
Density	1.13 - 1.14	g/cm ³	ASTM D792
Mechanical	Value	Unit	Test Method
Tensile Strength at yield	70 ± 2	MPa	ASTM D638
Tensile Elongation at break	> 10	%	ASTM D638
Izod Impact, notched, 23°C	5 ± 1	kgf.cm/cm	ASTM D256
Thermal	Value	Unit	Test Method
Heat Deflection Temperature at 0.45 Mpa	180 - 190	°C	ASTM D648
Heat Deflection Temperature at 1.82 Mpa	60 - 70	°C	ASTM D648

Processing Condition

Temperature	Value	Unit
Melt Temperature	280 - 310	°C
Rear Barrel Temperature	280 - 295	°C
Middle Barrel Temperature	290 - 310	°C
Front Barrel Temperature	290 - 310	°C
Nozzle Temperature	280 - 290	°C
Mould Temperature	50 - 70	°C
Drying Temperature	80 - 90	°C
Drying Time	4	hour

The information should only be used as a reference guide.

A~Star Plastics Pte Ltd makes no warranties of the product for any particular use or purpose.

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