



Technical Datasheet

Ver. 2018

<b>Material Type</b> PA6	<b>Grade Name</b> D121
--------------------------	------------------------

- Features
- Good Flow
  - Good Processability
  - Excellent Comprehensive Properties

Material Standard

Availability North America/Asia-Pacific

Process Method Injection Molding

Appearance Colors Optional

Applications Automotive Interior and Exteriors

General Properties

No.	Properties	Methods	Units	Values	Test Conditions
1	Density	ISO 1183-1	g/cm <sup>3</sup>	1.13	
2	Tensile Strength at Max Load	ISO 527-2	MPa	75	50mm/min
3	Tensile Modulus	ISO 527-2	MPa	3000	1mm/min
4	Elongation at Yield	ISO 527-2	%	4	50mm/min
5	Flexural Modulus	ISO 178	MPa	2600	2mm/min
6	Flexural Strength	ISO 178	MPa	95	2mm/min
7	Notched Impact Strength	ISO 179-1	kJ/m <sup>2</sup>	4.5	23°C
8	Notched Impact Strength	ISO 179-1	kJ/m <sup>2</sup>	3	-30°C
9	Heat Deflection Temp.	ISO 75-2	°C	65	1.8MPa,120°C/h
10	Melt Temp.	ISO 3146	°C	220	

Processing Conditions

- Drying Cond. • 80-120°C \* 4-6h Moisture Control • <0.1
- Injection Temp. • 230-250 °C(F), 245-275 °C(M), 210-235 °C(B)
- Injection Speed • Low to Medium
- Injection Pressure • 40-110 MPa
- Back Pressure • 0-5 MPa
- Mold Temp. • 50-100 °C

Note : The technical data above are authentic and reliable for reference. These value cannot be defined as the minimal performance value.