

ARLEN™ A350

PA6T-GF50

Mitsui Chemicals, Inc.

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.002	mm/mm	ASTM D 955
Mold Shrinkage, TD	0.006	mm/mm	ASTM D 955

Mechanical properties	dry / cond	Unit	Test Standard
ASTM Data			
Tensile Strength	300 / 270	MPa	ASTM D 638
Flexural Modulus	17000 / 15000	MPa	ASTM D 790
Flexural Strength	430 / 390	MPa	ASTM D 790
Rockwell Hardness	M 110 /	-	ASTM D 785
Izod Impact notched, 1/8 in	150 / 160	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
UL 94 Flame rating	HB	-	UL 94
Coefficient of Thermal Expansion, MD	18	E-6/K	ASTM D 696
Coefficient of Thermal Expansion, TD	42	E-6/K	ASTM D 696
DTUL @ 264 psi	310	°C	ASTM D 648
Melting Temperature	320	°C	ASTM D 3418
Glass Transition Temperature	125	°C	ASTM E 1356

Electrical properties	dry / cond	Unit	Test Standard
ASTM Data			
Dielectric Strength, Short Time	29 / -	kV/mm	ASTM D 149
Dissipation Factor, 1 MHz	0.018 / -	-	ASTM D 150
Dielectric Constant, 1 MHz	4.5 / -	-	ASTM D 150
Volume Resistivity	>1E15 / -	Ohm*cm	ASTM D 257

Other properties	Value	Unit	Test Standard
Water Absorption, 24hr	0.2	%	ASTM D 570
Density	1630	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	110	°C	-
Pre-drying - Time	2 - 6	h	-
Mold temperature	90 - 140	°C	-
Feed temperature	50 - 90	°C	-
Zone 1	315 - 330	°C	-
Zone 2	320 - 335	°C	-
Zone 3	325 - 340	°C	-
Nozzle temperature	325 - 340	°C	-
Screw speed	150	rpm	-

Characteristics

Processing
Injection Molding

Applications
Automotive

Delivery form
Pellets

Regional Availability
North America, Europe, Asia Pacific