

## Technical Data Sheet

### Arsamide HI 25086

**Product Type:** High Impact polyamide for injection molding.

**Product Description:** Arsamide HI-I 25086 is polyamide 6 with good mechanical properties, High Impact, dimensional stability, stiffness, good heat and chemical resistance. This compound is used in appliance industry, automotive applications, electrical goods, housewares and other utility products. This grade is designed to be processed in conventional injection molding techniques.

Property	Test Method	Test Condition	Value	Unit
<b>General Properties</b>				
Material	High Impact Polyamide6			
Process Method	Injection			
Color	Black			
<b>Physical Properties</b>				
Density	ASTM D 792	(23 °C)	1.06	g/cm <sup>3</sup>
Ash/Filler/ TD Content	ASTM D 5630	(600 °C)	0	%
Mold Shrinkage	ASTM D 955	24 Hr	-	%
Melt Flow Index	ASTM D 1238	-	-	gr/10min
<b>Mechanical Properties</b>				
Tensile Strength at Break	ASTM D 638	(5 mm/min)	46	MPa
Tensile Strength Yield	ASTM D 638	(5 mm/min )	44	MPa
Tensile strain at Break	ASTM D 638	(5 mm/min )	88	%
Tensile strain at Yield	ASTM D 638	(5 mm/min )	7	%
Izod Impact Strength	ASTM D 256	Notched at 23°C	77	KJ/m <sup>2</sup>

- All mentioned information in this technical data sheet present current knowledge and experience of Arsam. Naturally, these data do not guarantee certain values since may vary on customers processing conditions, so they are provided for reference purposes only and should not be used alone to create specification limits and design basis.

**Processing Conditions:**

- Recommended Zone Setting are as follows: (230-250) °C
- Mold Surface Temperature: (50-80 ) °C
- Pre-drying is necessary for materials and dryer operation at 80 °C is recommended. Drying time 2-4 hour is generally sufficient