



SUMIKASUPER E4006L

		Method	Unit	E4006L
Color				Natural, Black
Filler		-		Glass fiber
Glass fiber type		-		Chopped
Filler content		-	%	30
Physical property				
Specific gravity		ASTM D792		1.60
Mold shrinkage	MD	Sumitomo Original*1	%	0.11
	TD		%	0.78
Mechanical property				
Tensile	strength	ASTM D638	MPa	182
	elongation		%	5.6
	strength	ISO 527	MPa	115
	modulus		GPa	13.7
Flexural	elongation		%	2.3
	strength	ASTM D790	MPa	155
	modulus		GPa	11.9
	strength	ISO 178	MPa	196
modulus			GPa	14.9
Izod impact strength		D256	J/m	461
Non-notched		ISO 180	J/m	323
Charpy impact strength		ISO 179	KJ/m ²	47
Non-notched			KJ/m ²	-
Rockwell strength			R scale	91
Thermal property				
TDUL		ASTM D648	deg C	324
1.82MPa for ASTM/1.80MPa for ISO		ISO 75	deg C	328
Solder resistance		Sumitomo Original*2	deg C	335
Liner expansion coefficient	MD	Sumitomo Original*3	×10 ⁻⁵ /deg C	0.2
	TD			8.1
Electrical property				
Dielectric constant		ASTM D150	1MHz	3.7
			1GHz	-
Dielectric tangent			1MHz	0.035
			1GHz	-
Dielectric breakdown voltage		Short time method	kV/mm	43
Specific volume resistance		ASTM D257	Ωm	10 ¹³
Specific surface resistance			Ω	10 ¹⁶
Arc resistance		ASTM D495	sec.	130
Tracking resistance		IEC method	V	185
Flammability				
Flame retardancy		UL 94		V-0 at 0.3mmt
Limited Oxygen Index		JIS K 7201		44

<Note>

All the data above are just for reference, not intended for any guarantee on the product.

*1: The tool of 64mm X 64mm X 3mmt was used to determine mold shrinkages.

*2: The highest temperature at which dumbbell shaped test pieces of 1.2mmt does not deform after immersing in a solder bath for 60 seconds.

*3: The center part of the test piece for tensile property was used.

Standard molding conditions			
Pre-drying		deg C for hours	About 130 deg C for 4 to 24 hours
Cylinder temperature	Nozzle	deg C	370 to 390
	Front	deg C	370 to 390
	Middle	deg C	350 to 370
	Rear	deg C	330 to 350
Suitable resin temperature		deg C	380
Tool (Mold) temperature		deg C	40 to 160
Injection velocity		-	Middle to High
Injection pressure		MPa	120 to 160
Holding pressure		MPa	40 to 60
Back pressure		MPa	1 to 5
Screw rotation		rpm	50 to 100