



SUMIKASUPER E6006L

		Method	Unit	E6006L
Color				Natural, Black
Filler		-		Glass fiber
Glass fiber type		-		Chopped
Filler content		-	%	30
Physical property				
Specific gravity		ASTM D792		1.61
Mold shrinkage	MD	Sumitomo Original*1	%	0.19
	TD		%	0.74
Mechanical property				
Tensile	strength	ASTM D638	MPa	164
	elongation		%	5.0
	strength	ISO 527	MPa	118
	modulus		GPa	13.8
	elongation		%	1.6
Flexural	strength	ASTM D790	MPa	153
	modules		GPa	11.3
	strength	ISO 178	MPa	184
	modulus		GPa	13.7
Izod impact strength		D256	J/m	137
Non-notched		ISO 180	J/m	317
Charpy impact strength		ISO 179	J/m	41
Non-notched				
Rockwell strength			R scale	103
Thermal property				
TDUL		ASTM D648	deg C	284
1.82MPa for ASTM/1.80MPa for ISO		ISO 75	deg C	290
Solder resistance		Sumitomo Original*2	deg C	300
Liner expansion coefficient	MD	Sumitomo Original*3	×10 ⁻⁵ /deg C	2.0
	TD			8.9
Dielectric property				
Dielectric constant		ASTM D150	1MHz	3.7
			1GHz	3.2
Dielectric tangent			1MHz	0.034
			1GHz	0.005
Dielectric breakdown voltage		Short time method	kV/mm	26
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	115
Flammability				
Flame retardency		UL 94		V-0 at 0.3mmt

<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 3mm was used to determine mold shrinkages.

*2: The highest temperature at which dumbbell shaped test pieces of 1.2mm 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
	Front	deg C
	Middle	deg C
	Rear	deg C
Suitable resin temperature		deg C
		350
Tool (Mold) temperature		deg C
		40 to 160
Injection velocity		-
		Middle to High
Injection pressure		MPa
		80 to 160
Holding pressure		MPa
		20 to 40
Back pressure		MPa
		1 to 5
Screw rotation		rpm
		50 to 100