

KIMIALON[®] 6(B310R)

MATERIAL NAME: PA6

COLOR: BLACK

CODE: B310R

MATERIAL DESCRIPTION: Kimialon[®] B310R is a lubricated, impact modified, black color Polyamide 6 resin.

No.	PROPERTIES		METHOD	UNIT	VALUE
GENERAL					
1	ASH CONTENT		ISO 3451	%	0.09
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.09
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.21
MECHANICAL					
5	TENSIL STRENGTH AT BREAK (50mm/min)		ASTM/D638	MPa	46.7
6	ELONGATION AT BREAK (50mm/min)		ASTM/D638	%	44.3
7	TENSIL MODULUS (50mm/min)		ASTM/D638	MPa	9365.6
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	50.31
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	N.B
THERMAL					
10	HARDNESS		ISO 868	Shore D	68
11	MFI		ASTM/D1238	g/10min	---
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	211.4
		50N			147.1
BEHAVIOR IN FIRE					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	198.5
		66psi			87.3
14	Flammability	Class	UL94	-	---
INJECTION PROCESS PARAMETERS					
<i>Loading</i>		<i>Injection</i>		<i>Degassing</i>	
<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Speed</i>	<i>Pressure (Bar)</i>	<i>Temperature</i>	<i>Time</i>
60	60	70	70	80 °C	1h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		235 °C	235 °C	240 °C	245 °C