

KIMIA[®] 66(N100)

MATERIAL NAME: PA66

COLOR: NATURAL

CODE: N100

MATERIAL DESCRIPTION: Kimia[®] N100 is a general purpose un-reinforced, natural color regenerated Polyamide 66 resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
GENERAL					
1	ASH CONTENT		ISO 3451	%	---
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.10
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.23
MECHANICAL					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	75.4
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	20.4
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	7722.8
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	5.31
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	N.B
THERMAL					
10	HARDNESS		ISO 868	Shore D	72
11	MFI		ASTM/D1238	g/10min	---
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	256.8
		50N			165.8
BEHAVIOR IN FIRE					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	224.9
		66psi			214.6
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>
80	80	65	65	80 °C	2h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		260 °C	260 °C	260 °C	270 °C
					1
					270 °C