

## KIMIA<sup>®</sup> 6(N300)

MATERIAL NAME: PA6

COLOR: NATURAL

CODE: N300

MATERIAL DESCRIPTION: Kimia<sup>®</sup> N300 is a general purpose un-reinforced, lubricated, natural color regenerated Polyamide 6 resin for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
<b>GENERAL</b>					
1	ASH CONTENT		ISO 3451	%	---
2	RELATIVE DENSITY		ISO 1183	g/cm <sup>3</sup>	1.11
3	VISCOSITY NUMBER		ISO 307	Cm <sup>3</sup> /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.23
<b>MECHANICAL</b>					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	64.6
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	82.6
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	6506.1
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m <sup>2</sup>	8.44
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m <sup>2</sup>	N.B
<b>THERMAL</b>					
10	HARDNESS		ISO 868	Shore D	71
11	MFI		ASTM/D1238	g/10min	---
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	211.3
		50N			168.9
<b>BEHAVIOR IN FIRE</b>					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	224.8
		66psi			86.9
14	Flammability	Class	UL94	-	---
<b>INJECTION PROCESS PARAMETERS</b>					
<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>
70	70	70	70	70 °C	2h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		225 °C	225 °C	230 °C	235 °C
				1	235 °C