

KIMIA® 66(W100)

MATERIAL NAME: PA66

COLOR: WHITE

CODE: W100

MATERIAL DESCRIPTION: Kimia® W100 is a general purpose un-reinforced, white color regenerated high viscosity Polyamide 66 resins for injection molding.

No.	PROPERTIES		METHOD	UNIT	VALUE
GENERAL					
1	ASH CONTENT		ISO 3451	%	-
2	RELATIVE DENSITY		ISO 1183	g/cm ³	1.13
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	-
4	MOISTURE CONTENT		ISO 62	%	0.35
MECHANICAL					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	68.6
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	22.4
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	7172.9
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	5.00
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	246.3
		50N			175.8
BEHAVIOR IN FIRE					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	220.8
		66psi			218.6
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>
70	70	70	70	70 °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			