Kimia Forooz Inc. Co.
Manufacturer of Engineering Plastics

KIMIA® 6(W300)

MATERIAL NAME: PA6 **COLOR: WHITE** **CODE: W300**

MATERIAL DESCRIPTION: Kimia® **W300** is a general purpose, un-reinforced, white color regenerated Polyamide 6 resin injection molding.

No.	PROPERITES		METHOD	UNIT	VALUE
	GENERAL				
1	ASH CONTENT		ISO 3451	%	0.00
2	RELATIVE DENSITY		ISO 1183	g/cm^3	1.12
3	VISCOSITY NUMBER		ISO 307	Cm^3/gr	---
4	MOISTURE CONTENT		ISO 62	%	0.27
	MECHANICAL				
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	61.1
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	107.9
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	6800
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m^2	8.12
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	211.3
		50N			168.9
	BEHAVIOR IN FIRE				
13	HDT (120° C/h)	264psi	ASTM/D648	° C	224.8
		66psi			86.9
14	Flammability	Class	UL94	-	---

INJECTION PROCESS PARAMETERS

Loading		*Injection*		*Degassing*	
Speed	*Pressure (Bar)*	*Speed*	*Pressure (Bar)*	*Temperature*	*Time*
70	*70*	*70*	*70*	*70 ˚C*	*2h*

Mold Releasing	*Zone*				
Good	*5*	*4*	*3*	*2*	*1*
	225 ˚C	*225 ˚C*	*230 ˚C*	*235 ˚C*	*235 ˚C*