

KIMIA[®] PA6(N200)

MATERIAL NAME: PA6

COLOR: NATURAL

CODE: N200

MATERIAL DESCRIPTION: Kimia[®] N200 is a general purpose un-reinforced, lubricated, natural color prime Polyamide 6 resin for injection molding.

| No. | PROPERTIES | | METHOD | UNIT | VALUE |
|-------------------------------------|------------------------------------|------------------|-----------------------|---------------------|-------------|
| PHYSICAL PROPERTIES | | | | | |
| 1 | ASH CONTENT | | ISO 3451 | % | 0.00 |
| 2 | RELATIVE DENSITY | | ISO 1183 | g/cm ³ | 1.13 |
| 3 | VISCOSITY NUMBER | | ISO 307 | Cm ³ /gr | --- |
| 4 | MOISTURE CONTENT | | ISO 62 | % | 0.22 |
| MECHANICAL PROPERTIES | | | | | |
| 5 | TENSIL STRENGTH AT BREAK (5mm/min) | | ASTM/D638 | MPa | 68 |
| 6 | ELONGATION AT BREAK (5mm/min) | | ASTM/D638 | % | 73.2 |
| 7 | TENSIL MODULUS (5mm/min) | | ASTM/D638 | MPa | 3173.7 |
| 8 | NOTCHED IMPACT STRENGTH-IZOD | | ISO 180 | Kj/m ² | 6.8 |
| 9 | UN NOTCHED IMPACT STRENGTH-IZOD | | ISO 180 | Kj/m ² | N.B |
| THERMAL PROPERTIES | | | | | |
| 10 | HARDNESS | | ISO 868 | Shore D | 73 |
| 11 | MFI | | ASTM/D1238 | g/10min | --- |
| 12 | VICAT(50° C/h) | 10N | ASTM/D1238 | ° C | 227 |
| | | 50N | | | 194 |
| FLAMMABILITY | | | | | |
| 13 | HDT (120° C/h) | 264psi | ASTM/D648 | ° C | 70 |
| | | 66psi | | | 190 |
| 14 | Flammability | Class | UL94 | - | HB |
| 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 | 80 | 70 | 90 | 80 °C | 1h |
| <i>Mold Releasing</i> | | <i>Zone</i> | | | |
| <i>Good</i> | | 5 | 4 | 3 | 2 |
| | | - °C | 210 °C | 215 °C | 220 °C |