

KIMIALON[®] PA6 (N204R)

MATERIAL NAME: PA6

COLOR: NATURAL

CODE: N204R

MATERIAL DESCRIPTION: Kimialon[®] PA6 (N204R) is a low impact resistance, 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	1.10
3	VISCOSITY NUMBER		ISO 307	Cm ³ /gr	---
4	MOISTURE CONTENT		ISO 62	%	0.25
MECHANICAL PROPERTIES					
5	TENSIL STRENGTH AT BREAK (5mm/min)		ASTM/D638	MPa	65
6	ELONGATION AT BREAK (5mm/min)		ASTM/D638	%	280
7	TENSIL MODULUS (5mm/min)		ASTM/D638	MPa	2700
8	NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	12.0
9	UN NOTCHED IMPACT STRENGTH-IZOD		ISO 180	Kj/m ²	N.B
THERMAL PROPERTIES					
10	HARDNESS		ISO 868	Shore D	72
11	MFI		ASTM/D1238	g/10min	-
12	VICAT(50° C/h)	10N	ASTM/D1238	° C	219
		50N			187
FLAMMABILITY					
13	HDT (120° C/h)	264psi	ASTM/D648	° C	62
		66psi			183
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>
60	80	80	80	80 °C	0.5h
<i>Mold Releasing</i>		<i>Zone</i>			
<i>Good</i>		5	4	3	2
		- °C	210 °C	215 °C	220 °C
					1
					225 °C