

DOMAMID® 6MV 303 NC

(DOMAMID A1-203-N)

Polyamide 6, high viscosity, injection moulding grade, natural color

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,13
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,40 - 1,60
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,40 - 1,60
RHEOLOGICAL				
Melt Volume Rate (MVR)	275 °C - 5,0 kg	ISO 1133	[cm ³ /10 min]	45
Viscosity number	96% H2SO4	ISO 307	[ml/g]	190
MECHANICAL				
				dam / cond.*
Tensile modulus	1 mm/min	ISO 527	[MPa]	2800 / 1700
Tensile stress at break	50 mm/min	ISO 527	[MPa]	50 / 65
Tensile strain at break	50 mm/min	ISO 527	[%]	no / no
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	80 / 20
Tensile strain at yield	50 mm/min	ISO 527	[%]	4 / 4,5
Flexural modulus	5 mm/min	ISO 178	[MPa]	2500 / 950
Flexural strength	5 mm/min	ISO 178	[MPa]	90 / 30
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	N
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	7
THERMAL				
Melting point		ISO 11357-1	[°C]	221
Heat Deflection Temperature (HDT-A)	1,80 MPa	ISO 75	[°C]	65
ELECTRICAL				
Volume resistivity		IEC 60093	[Ω·cm]	1E+15
Surface resistivity		IEC 60093	[Ω]	1E+14

Test run at 23°C if not differently specified, DAM state (dry as moulded).

*: conditioned according to ISO 1110

PROCESSING CONDITIONS:

Drying temperature/time	: 75-85°C / 2-4h (with dew point of dried air < -30 °C)
Recommended melt temperature	: 240-280 °C
Recommended mould temperature	: 60-80 °C

These parameters are typical of the product but should be related to the type of machinery used and to the type of moulded part.

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