

DOMAMID[®] 6IK1 302 NC

Polyamide 6, low temperature impact modified, for injection moulding, natural color

19.09.2016

TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-I
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,10
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,60 - 1,80
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]	165
MECHANICAL				
Tensile modulus	1 mm/min	ISO 527	[MPa]	2700
Tensile stress at break	50 mm/min	ISO 527	[MPa]	50
Tensile strain at break	50 mm/min	ISO 527	[%]	≥ 20
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	65
Flexural modulus	5 mm/min	ISO 178	[MPa]	2200
Flexural strength	5 mm/min	ISO 178	[MPa]	75
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	N
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	10
THERMAL				
Melting point		ISO 11357-1	[°C]	221

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

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.

The information provided in this documentation corresponds to our technical knowledge at the date of its publication and do not constitute a specification. This information may be subject to revision at our discretion. Domo cannot anticipate all conditions under which this information and our products of other manufactures in combination with our products may be used. Domo accepts no responsibility for results obtained by the application of this information or for the safety and suitability of our products alone or in combination with other products. Users are advised to make their own tests to determine the safety and suitability of each product or product combination for their own purposes. Unless otherwise agreed in writing, Domo sells the product without warranties. Buyers and users assume all responsibility and liability for loss or damage arising from handling and use of our products, whether used alone or in combination with other products. Unless specifically indicated, the grades mentioned are not suitable for applications in the pharmaceutical/medical sector.