

Novamid® 1013C4

Polyamide 6

DSM Engineering Plastics

Message:

Novamid® 1013C4 is a Polyamide 6 (Nylon 6) material. It is available in Asia Pacific for injection molding.

Important attributes of Novamid® 1013C4 are:

Flame Rated

Low Viscosity

General Information				
Features		Low Viscosity		
Processing Method		Injection Molding		
Physical	Dry	Conditioned	Unit	Test Method
Density	1.13	--	g/cm ³	ISO 1183
Molding Shrinkage				ISO 294-4
Across Flow	1.3	--	%	
Flow	1.2	--	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	2.8	--	%	ISO 62
Viscosity Number	138	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	3100	1000	MPa	ISO 527-2
Tensile Stress (Yield)	83.0	50.0	MPa	ISO 527-2
Tensile Strain (Yield)	5.3	--	%	ISO 527-2
Nominal Tensile Strain at Break	20	--	%	ISO 527-2
Flexural Modulus	3000	990	MPa	ISO 178
Flexural Stress	119	40.0	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.0	31	kJ/m ²	ISO 179/1eA
Charpy Unnotched Impact Strength (23°C)	No Break	No Break		ISO 179/1eU
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				
0.45 MPa, Unannealed	175	--	°C	ISO 75-2/B
1.8 MPa, Unannealed	57.0	--	°C	ISO 75-2/A
Melting Temperature ¹	220	--	°C	ISO 11357-3
CLTE				ISO 11359-2
Flow	6.0E-5	--	cm/cm/°C	
Transverse	6.0E-5	--	cm/cm/°C	
Electrical	Dry	Conditioned	Unit	Test Method

Volume Resistivity	> 1.0E+15	--	ohms·cm	IEC 60093
Electric Strength	26	--	kV/mm	IEC 60243-1
Relative Permittivity (1 MHz)	4.00	--		IEC 60250
Dissipation Factor (1 MHz)	0.022	--		IEC 60250
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Flammability Classification (0.800 mm)	V-2	--		IEC 60695-11-10, -20
Injection	Dry	Unit		
Drying Temperature	80.0		°C	
Drying Time	4.0 to 8.0		hr	
Rear Temperature	230 to 235		°C	
Middle Temperature	235 to 250		°C	
Front Temperature	240 to 260		°C	
Nozzle Temperature	240 to 270		°C	
Processing (Melt) Temp	240 to 275		°C	
Mold Temperature	50.0 to 80.0		°C	
Injection Rate	Moderate-Fast			
Back Pressure	3.00 to 10.0		MPa	
Screw Compression Ratio	2.5:1.0			
NOTE				

1. 10°C/min

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