

Novamid® 1011CH5-KR

Polyamide 6

DSM Engineering Plastics

Message:

Novamid® 1011CH5-KR is a Polyamide 6 (Nylon 6) material. It is available in Asia Pacific for injection molding. Primary attribute of Novamid® 1011CH5-KR: Low Viscosity.

General Information			
Features	Low Viscosity		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm ³	ISO 1183
Molding Shrinkage			ISO 294-4
Across Flow	1.4	%	
Flow	1.4	%	
Water Absorption (Equilibrium, 23°C, 50% RH)	2.8	%	ISO 62
Viscosity Number	125	cm ³ /g	ISO 307
Mechanical	Nominal Value	Unit	Test Method
Tensile Modulus	2700	MPa	ISO 527-2
Tensile Stress (Yield)	77.0	MPa	ISO 527-2
Nominal Tensile Strain at Break	> 50	%	ISO 527-2
Flexural Modulus	2900	MPa	ISO 178
Flexural Stress	113	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength (23°C)	4.8	kJ/m ²	ISO 179
Charpy Unnotched Impact Strength (23°C)	No Break		ISO 179
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	153	°C	ISO 75-2/B
1.8 MPa, Unannealed	69.0	°C	ISO 75-2/A
Melting Temperature ¹	220	°C	ISO 11357-3
Injection	Nominal Value	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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Recommended distributors for this material

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