

Isocor™ CU145SI

Polyamide 66/6 Copolymer

Shakespeare Monofilaments and Specialty Polymers

Message:

Isocor™ CU145SI is a high viscosity, plasticized, PA-6/66 copolymer resin. This resin is specifically suited for applications requiring excellent abrasion resistance while maintaining a balance of properties including chemical resistance and flexibility. This resin can be processed using conventional techniques.

Typical applications for CU145SI include:

grass trimmer line

cable jacketing

General Information	
Additive	Plasticizer
Features	Copolymer
	Plasticized
	Good flexibility
	Good wear resistance
	Good chemical resistance
	General
Uses	Viscosity, High
	Lawn and Garden Equipment
	Cable sheath
	General
Forms	Particle
Processing Method	Extrusion
	Injection molding

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.11	--	g/cm ³	ASTM D792
Water Absorption (24 hr)	0.49	--	%	ASTM D570
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	1930	1490	MPa	ASTM D638
Tensile Strength	38.6	40.7	MPa	ASTM D638
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact	100	110	J/m	ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature	194	--	°C	DSC
Injection	Dry	Unit		
Dew Point	< -17.8		°C	
Suggested Max Moisture	0.20		%	

Hopper Temperature	79.4	°C
Rear Temperature	221 - 243	°C
Middle Temperature	227 - 260	°C
Front Temperature	238 - 271	°C
Nozzle Temperature	238 - 271	°C
Processing (Melt) Temp	238 - 271	°C
Mold Temperature	10.0 - 93.3	°C
Injection Pressure	3.45 - 13.8	MPa
Injection Rate	Fast	
Back Pressure	0.689	MPa
Extrusion	Dry	Unit
Suggested Max Moisture	0.10	%
Hopper Temperature	79.4	°C
Cylinder Zone 1 Temp.	271	°C
Cylinder Zone 2 Temp.	277	°C
Cylinder Zone 3 Temp.	277	°C
Cylinder Zone 4 Temp.	277	°C
Die Temperature	243	°C
Extrusion instructions		

Flange: 500°F (260°C) Air Dew Point (max): 0°F (-18°C) Neck: 490°F (254°C) Head: 490°F (254°C) Pump: 490°F (254°C) L/D Ratio: 24 to 30:1 Compression Ratio: 3.5:1 Polymer @ Die: 450°F (232°C) Screw Pressure: 2000 psi

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