

Isocor™ 653

Polyamide 6

Shakespeare Monofilaments and Specialty Polymers

Message:

Isocor™ 653 multi-polymer is a linear polyamide with unique solubility characteristics and physical properties. Isocor™ 653 is easily processed and has a wide range of applications due to its physical properties, chemical resistance, and lower melt temperatures.

Typical applications for Isocor™ 653 include:

- film extrusion
- pigment carriers
- specialty adhesives

General Information	
Features	Good chemical resistance
Uses	Films
	Adhesive
Forms	Particle
Processing Method	Film extrusion
	Injection molding

Physical	Dry	Conditioned	Unit	Test Method
Specific Gravity	1.08	--	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.18 mm)	1.5	--	%	ASTM D955
Water Absorption (24 hr)	3.5	--	%	ASTM D570
Hardness	Dry	Conditioned	Unit	Test Method
Durometer Hardness (Shore D)	73	65		ASTM D2240
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Strength	24.8	18.6	MPa	ASTM D638
Tensile Elongation (Break)	350	350	%	ASTM D638
Flexural Modulus	621	207	MPa	ASTM D790
Impact	Dry	Conditioned	Unit	Test Method
Notched Izod Impact				ASTM D256
-40°C	43	27	J/m	ASTM D256
23°C	160 J/m	No Break		ASTM D256
Thermal	Dry	Conditioned	Unit	Test Method
Melting Temperature	154	--	°C	DSC
Injection	Dry	Unit		
Dew Point	< -17.8		°C	
Suggested Max Moisture	0.20		%	
Hopper Temperature	60.0		°C	

Rear Temperature	143 - 154	°C
Middle Temperature	149 - 160	°C
Front Temperature	154 - 166	°C
Nozzle Temperature	143 - 154	°C
Processing (Melt) Temp	143 - 154	°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.	218	°C
Cylinder Zone 2 Temp.	246	°C
Cylinder Zone 3 Temp.	246	°C
Cylinder Zone 4 Temp.	246	°C
Die Temperature	229	°C
Extrusion instructions		

Flange: 445°F (229°C) Air Dew Point (max): 0°F (-18°C) Neck: 445°F (229°C) Head: 445°F (229°C) Pump: 445°F (229°C)

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