

DOMAMID® 6IK1 302 BK

(DOMAMID A1-501-I1-B)

Polyamide 6, low temperature impact modified, for injection moulding, black

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TYPICAL PROPERTIES	CONDITION	STANDARD	UNIT	VALUE
PRODUCT IDENTIFICATION				
ISO 1043 abbreviation		ISO 1043		PA6-I
PHYSICAL				
Density		ISO 1183	[g/cm ³]	1,1
Mold shrinkage parallel	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,70 - 1,90
Mold shrinkage transverse	72 hrs, 23°C, 50% RH	ISO 2577	[%]	1,65 - 1,85
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]	2600
Tensile stress at break	50 mm/min	ISO 527	[MPa]	45
Tensile strain at break	50 mm/min	ISO 527	[%]	≥ 15
Tensile stress at yield	50 mm/min	ISO 527	[MPa]	60
Flexural modulus	5 mm/min	ISO 178	[MPa]	2200
Flexural strength	5 mm/min	ISO 178	[MPa]	70
Charpy unnotched	+23 °C	ISO 179/1eU	[kJ/m ²]	N
Charpy notched	+23 °C	ISO 179/1eA	[kJ/m ²]	7,5
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.

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