

Description

Polyamide 6, Unfilled, lubricated, for injection molding.

Applications

TECHNYL® 1011R is used in all sectors of industry, offering an excellent flow ability.

This grade is used for

- Fastener, Clip, Gear, Bobbin, Hand mixer cover

This product is available in NAT color.

Processing

The material is supplied in airtight bags, ready for use. In the case that the virgin material has absorbed moisture, it must be dried to a final moisture content less than 0.2% with a dehumidified air drying equipment at approx. 80°C

Recommended moulding conditions :

| | | |
|------------------------|--------------------|-------------|
| -Barrel temperatures : | - feed zone | 230 - 235°C |
| | - compression zone | 235 - 245°C |
| | - front zone | 245 - 250°C |
| -Mould temperatures | | 60 - 80°C |

For more detailed information, please refer to the technical sheet " Injection moulding ".

Safety

Please refer to the Material Safety Data Sheet for TECHNYL® 1011R

TECHNYL[®] 1011R

* The values of properties are for natural color grade.

| Characteristics | Tets method | Unit | Test result | |
|--|------------------|---------|-------------|---------|
| | | | d.a.m*. | Cond.** |
| Physical | | | | |
| Water absorption, 24h in water at 23°C | ISO 62 | % | 1.30 | - |
| Density | ISO 1183 | g/cm³ | 1.14 | - |
| Mold shrinkage (longitudinal) | RHODIA-EP | % | 1.1~1.5 | - |
| Mold shrinkage (transverse) | RHODIA-EP | % | 1.2~1.5 | - |
| Mechanical | | | | |
| Tensile strength at yield | ASTM D638 | MPa | 80 | - |
| Elongation at break | ASTM D638 | % | 45 | - |
| Flexural stress at break | ASTM D790 | MPa | 115 | - |
| Flexural modulus | ASTM D790 | MPa | 2950 | - |
| Izod notched impact strength | ASTM D256 | J/m | 85 | - |
| Rockwell hardness | ASTM D786 | R-Scale | 115 | - |
| Flammable | | | | |
| UL94 Flammability | ISO 1210 / UL 94 | - | HB | - |
| Thermal | | | | |
| Melt Temperature | ISO 11357 | °C | 222 | - |
| Heat Deflection Temperature 1.82 MPa | ASTM D648 | °C | 180 | - |
| Heat Deflection Temperature 0.45 MPa | ASTM D648 | °C | 60 | - |
| Electrical | | | | |
| Dielectric strength | IEC60243 | kV/mm | 3.40 | 3.90 |
| Dissipation factor | IEC60250 | - | 0.02 | 0.10 |
| Volume resistivity | IEC60093 | Ohm.cm | 10E14 | 10E10 |
| Surface resistivity | IEC60093 | Ohm | 10E12 | 10E10 |
| Comparative tracking index sol. A | IEC60112 | Volt | 600 | - |
| Specific | | | | |
| Identification code > PA6 < | | | | |

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Users are responsible for ensuring compliance with local legislation and for obtaining the necessary certifications and authorizations. Users are requested to check that they are in possession of the latest version of this document, and Rhodia is at their disposal to supply any additional information.

* d.a.m = Dry As Moulded.

** Cond. = conditioned according ISO 1110.



RHODIA POLYAMIDE

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