TECHNYL® 1015CR

Product Data Sheet - August 2009

Description

Polyamide 6, unfilled, standard for fast injection cycles, for injection moulding

Applications

TECHNYL® 1015CR has high fluidity and a good mould release. It is particularly suitable for the production of technical mouldings with fast injection cycles.

This grade is used for

- Fastener, Clip, Gear, Bobbin

This product is available in Natural 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 shet " Injection moulding ".

Safety

Please refer to the Material Safety Data Sheet for TECHNYL® 1015CR.

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RHODIA POLYAMIDE
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TECHNYL® 1015CR

* 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/㎤	1.14	-
Mold shrinkage (longitudinal)	RHODIA-EP	%	1.3~1.7	-
Mold shrinkage (transverse)	RHODIA-EP	%	1.5~2.0	-
Mechanical				
Tensile strength at yield	ASTM D638	MPa	90	-
Elongation at break	ASTM D638	%	30	-
Flexural stress at break	ASTM D790	MPa	120	-
Flexural modulus	ASTM D790	MPa	3050	-
Izod notched impact strength	ASTM D256	J/m	85	-
Rockwell hardness	ASTM D786	R-Scale	115	-
Flammable				
UL94 Flammability	ISO 1210 / UL 94	-	HB	-
Glow wire ignition temperature (thickness = 0,8)	IEC 60695-2-13	℃	675	
Thermal				
Melt Temperature	ISO 11357	℃	222	-
Heat Deflection Temperature 1.82 MPa	ASTM D648	℃	180	-
Heat Deflection Temperature 0.45 MPa	ASTM D648	℃	60	-
Coef. linear explanation, 23~85℃	ISO 11359	E-5/℃	7	
Electrical				
Dielectric strength	IEC60243	kV/mm	-	18
Dissipation factor 1MHz	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	-
Specifical				

Identification code > PA6 <

* d.a.m = Dry As Moulded.
** Cond. = conditioned according ISO 1110.

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