PA6 | KEPAMID 1300CRH | Mold release grade

- KEPAMID 1300CRH is an unfilled, lubricated, and fast-cycled PA6 grade.
- It is suitable for automotive, electrical & electronics, and consumer parts requiring a quick cycle time.

Physical properties	Test Standard	Unit	Value
Filler contents	ISO 1172	%	-
Specific gravity	ISO 1183	-	1.13
Water absorption(23 ℃, 50 %RH)	ISO 62	%	1.5~1.9

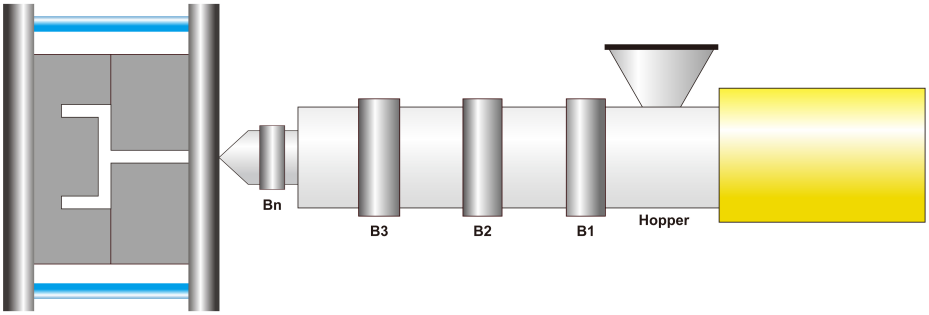
Mechanical properties	Test Standard	Unit	Value
Tensile stress	ISO 527	MPa	80
Elongation at break	ISO 527	%	20
Tensile modulus	ISO 527	MPa	2450
Flexural strength	ISO 178	MPa	115
Flexural modulus	ISO 178	MPa	2850
Charpy impact strength(Notched) @ 23℃	ISO 179/1eA	kJ/m^2	4.5
Charpy impact strength(Notched) @ -30℃	ISO 179/1eA	kJ/m^2	3.0
Rockwell Hardness(R-Scale)	ISO 2039	-	120

Thermal properties	Test Standard	Unit	Value
Melting point(10 ℃/min)	ISO 11357	℃	220
Heat deflection temperature(0.45 MPa)	ISO 75	℃	185
Heat deflection temperature(1.8 MPa)	ISO 75	℃	60
Flammability(t = 0.8 mm)	UL 94	Class	HB

Electrical properties	Test Standard	Unit	Value
Permittivity(1 MHz)	IEC 60250	-	3.4
Volume resistivity	IEC 60093	Ω/ cm	10^{15}

Revision No : 1 (2015-02-13)

Injection molding condition



Pre-drying (Suggested max. moisture : 0.05%)

It is recommend to dry material at 80℃(176℉) for 4 h ~ 6 h at dehumidified dryer.
It is recommend to dry material at 90℃(194℉) for 6 h ~ 8 h at dryer.

Temperature

Mold temperature : 70 ℃ ~ 90 ℃(158 ℉ ~ 194 ℉)
Barrel temperature : 230 ℃ ~ 240 ℃(446 ℉ ~ 464 ℉)

Mold	Bn(Nozzle)	B3(Metering)	B2(Compression)	B1(Feeding)	Hopper
70 ~ 90 ℃	240 ℃	240 ℃	240 ℃	230 ℃	60 ~ 80 ℃
158 ~ 194 ℉	464 ℉	464 ℉	464 ℉	446 ℉	140 ~ 176 ℉

Plastification

Screw speed : 80 ~ 120 rpm
Back pressure : 5 ~ 10 kgf/cm^2

Disclaimer