

ECOMID® NKX-1001 (PRELIMINARY)

NKX-1001 is an 20% impact modified PA6 for injection molding applications.

Product information

Part Marking Code	PA6	ISO 11469
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Rheological properties

Moulding shrinkage range, parallel	1.8 %	ISO 294-4, 2577
Moulding shrinkage range, normal	1.9 %	ISO 294-4, 2577

Typical mechanical properties

	dry/cond.		
Tensile Modulus	1986/-	MPa	ISO 527-1/-2
Yield stress, 50mm/min	48/-	MPa	ISO 527-1/-2
Yield strain, 50mm/min	4/-	%	ISO 527-1/-2
Stress at break, 50mm/min	40/-	MPa	ISO 527-1/-2
Flexural Modulus	1790/-	MPa	ISO 178
Flexural Stress at 3.5%	57	MPa	ISO 178
Charpy impact strength, 23°C	N/-	kJ/m ²	ISO 179/1eU
Charpy notched impact strength, 23°C	80/-	kJ/m ²	ISO 179/1eA

Thermal properties

Temp. of deflection under load, 1.8 MPa	50 °C	ISO 75-1/-2
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Other properties

Density	1060 kg/m ³	ISO 1183
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Injection

Drying Temperature	82 °C
Drying Time, Dehumidified Dryer	2 - 4 h
Processing Moisture Content	0.2 %
Max. mould temperature	27 - 82 °C

Additional information

Injection molding	Typical Profile
	Melt Temperature 240-266 degC (464-511 degF)
	Mold Temperature 65-110 degC (149-230 degF)
	Fill Rate
	Medium fill rates are recommended.

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Processing Texts

Injection molding

Typical Profile

Melt Temperature 240-266 degC (464-511 degF)

Mold Temperature 65-110 degC (149-230 degF)

Fill Rate

Medium fill rates are recommended.

Injection molding Preprocessing

Product needs to be dried before processing. A dehumidifying or desiccant dryer operating at 80 degC (176 degF) is recommended. The drying time will depend on the moisture level, we advise drying for 4-12h.

Please refer to SDS for safe material handling.
