

KOPA[®] KN111

Injection Molding, PA6, Medium viscosity, General Purpose

Application

General

Properties	Measurement condition	Test Method	Unit	Typical value
Physical				
Density		ASTM D792	-	1.14
Shrinkage		ASTM D955	%	0.9~1.5
Water Absorption	23℃, H ₂ O, 24hr	ASTM D570	%	1.8
Mechanical				
Tensile Strength at Break (3.2mm)	50 mm/min	ASTM D638	MPa	80
Elongation at Break (3.2mm)	50 mm/min	ASTM D638	%	45
Flexural Strength (3.2mm)	5 mm/min	ASTM D790	MPa	125
Flexural Modulus (3.2mm)	5 mm/min	ASTM D790	MPa	2950
Izod Impact Strength (6.4mm)		ASTM D256		
(Notched)	23 ℃		J/m	65
Rockwell Hardness	R scale	ASTM D785	-	120
Thermal				
Melting Point	20 ℃/min	ASTM D1525	℃	225
Heat Deflection Temperature	1.8 MPa	ASTM D648	℃	65
Flammability (0.8mm)		UL94	Class	HB

※ 1Mpa = 10.197162 Kgf/cm², 1J/m = 0.10197 Kgf·cm/cm, (Test specimen Thickness)



Processing Guide (Injection Molding)

Drying Temperature(℃)	80 ~ 90 (Dehumidifying Dryer)			
Drying Time(hr)	3~5			
Processing Moisture Contents(%)	≤ 0.1			
Cylinder Temperature(℃)	Nozzle	Front	Middle	Rear
	240~260	240~260	230~250	220~240
Mold Temperature(℃)	60~100			

