

# Novamid® ES113J

Polyamide 6

DSM Engineering Plastics

## Message:

Novamid® ES113J is a Polyamide 6 (Nylon 6) material. It is available in Asia Pacific for injection molding. Primary attribute of Novamid® ES113J: Low Viscosity.

General Information			
Features	Low Viscosity		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	1.13	g/cm <sup>3</sup>	ISO 1183
Water Absorption (Equilibrium, 23°C, 50% RH)	2.8	%	ISO 62
Viscosity Number	138	cm <sup>3</sup> /g	ISO 307
Thermal	Nominal Value	Unit	Test Method
Melting Temperature <sup>1</sup>	220	°C	ISO 11357-3
Injection	Nominal Value	Unit	
Drying Temperature	80.0	°C	
Drying Time	4.0 to 8.0	hr	
Rear Temperature	230 to 235	°C	
Middle Temperature	235 to 250	°C	
Front Temperature	240 to 260	°C	
Nozzle Temperature	240 to 270	°C	
Processing (Melt) Temp	240 to 275	°C	
Mold Temperature	50.0 to 80.0	°C	
Injection Rate	Moderate-Fast		
Back Pressure	3.00 to 10.0	MPa	
Screw Compression Ratio	2.5:1.0		
NOTE			
1.	10°C/min		

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## Recommended distributors for this material

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