

**Product Texts**

Nypel 6235G BK1 is a 35% glass reinforced injection molding grade of PA6. Based on recycled polyamide feedstocks, Nypel 6235G BK1 offers a balance of mechanical properties with excellent flow and surface appearance.

Nypel 6235G BK1 is recommended for lawn and power equipment housings, structural furniture components such as seat frames, and automotive and industrial applications.

Processing/Physical Characteristics	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melt volume-flow rate, MVR	76 / *	cm <sup>3</sup> /10min	ISO 1133
Temperature	275 / *	°C	-
Load	5 / *	kg	-

[C]: CAMPUS

Mechanical properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Tensile Modulus	10999 / 7854	MPa	ISO 527
<sup>[C]</sup> Stress at break	172 / 116	MPa	ISO 527
<sup>[C]</sup> Strain at break	3.2 / 6.2	%	ISO 527
<sup>[C]</sup> Charpy impact strength, +23°C	90 / 104	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy impact strength, -30°C	77 / 75	kJ/m <sup>2</sup>	ISO 179/1eU
<sup>[C]</sup> Charpy notched impact strength, +23°C	17 / 20	kJ/m <sup>2</sup>	ISO 179/1eA
<sup>[C]</sup> Charpy notched impact strength, -30°C	14 / 14	kJ/m <sup>2</sup>	ISO 179/1eA

[C]: CAMPUS

Thermal properties	dry / cond	Unit	Test Standard
<b>ISO Data</b>			
<sup>[C]</sup> Melting temperature, 10°C/min	218 / *	°C	ISO 11357-1/-3
<sup>[C]</sup> Temp. of deflection under load, 1.80 MPa	207 / *	°C	ISO 75-1/-2
<sup>[C]</sup> Temp. of deflection under load, 0.45 MPa	217 / *	°C	ISO 75-1/-2

[C]: CAMPUS

Other properties	dry / cond	Unit	Test Standard
<sup>[C]</sup> Water absorption	1.25 / *	%	Sim. to ISO 62
<sup>[C]</sup> Humidity absorption	5.1 / *	%	Sim. to ISO 62
<sup>[C]</sup> Density	1380 / -	kg/m <sup>3</sup>	ISO 1183

[C]: CAMPUS

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	80	°C	-
Pre-drying - Time	4	h	-
Melt temperature	270 - 290	°C	-
Mold temperature	80 - 90	°C	-

**Characteristics****Processing**

Injection Molding

**Applications**

Automotive

**Delivery form**

Black

**Regional Availability**

North America

**Certifications**

Recycled Resin Content

**Other text information**

**Injection molding**

PREPROCESSING

Pre/Post-processing, Pre-drying, Temperature: 80 °C

Pre/Post-processing, Pre-drying, Time: 4 h

PROCESSING

injection molding, Melt temperature, range: 270 - 290 °C

injection molding, Mold temperature, range: 80 - 90 °C