

NYLENE® 4114-25 GF HRV

PA66-GF25

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.0175	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Modulus	6205	MPa	ASTM D 638
Tensile Strength	117	MPa	ASTM D 638
Flexural Modulus	6378	MPa	ASTM D 790
Flexural Strength	160	MPa	ASTM D 790
Izod Impact notched, 1/8 in	123	J/m	ASTM D 256
Thermal properties			
ASTM Data			
DTUL @ 264 psi	230	°C	ASTM D 648
Melting Temperature	257	°C	ASTM D 3418
Thermal Conductivity, solid state	0.0442	W/(m K)	ASTM C 177
Other properties			
Density	1130	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	65 - 82	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	287 - 316	°C	-
Mold temperature	49 - 93	°C	-
Zone 1	260 - 293	°C	-
Zone 2	277 - 299	°C	-
Zone 3	282 - 310	°C	-
Nozzle temperature	279 - 307	°C	-
Injection pressure	5 - 15	MPa	-
Back pressure	0 - 50	MPa	-
Holding pressure	4 - 12	MPa	-
Maximum residence time	6	min	-

Characteristics**Processing**

Injection Molding, Pipe/Tube Extrusion, Profile Extrusion, Other Extrusion

Regional Availability

North America

Features

Thermal Stability