NYLENE® 134

PA66 — Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	**0.013**	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	**89.6**	MPa	ASTM D 638
Elongation at Break	**30**	%	ASTM D 638
Flexural Modulus	**3254**	MPa	ASTM D 790
Izod Impact notched, 1/8 in	**42.7**	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	**235**	°C	ASTM D 648
DTUL @ 264 psi	**85**	°C	ASTM D 648
Melting Temperature	**254**	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	**1140**	kg/m³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	**65 - 82**	°C	-
Pre-drying - Time	**2 - 4**	h	-
Processing humidity	**≤0.2**	%	-
Melt temperature	**282 - 304**	°C	-
Mold temperature	**49 - 93**	°C	-
Zone 1	**260 - 282**	°C	-
Zone 2	**271 - 293**	°C	-
Zone 3	**282 - 304**	°C	-
Nozzle temperature	**279 - 301**	°C	-
Injection pressure	**7 - 15**	MPa	-
Back pressure	**0 - 50**	MPa	-
Holding pressure	**5 - 12**	MPa	-
Maximum residence time	**6**	min	-

Characteristics

Processing
Injection Molding

Additives
Release agent

Special Characteristics
High impact or impact modified

Features
Fatigue Resistance, Nucleated

Chemical Resistance
Grease Resistance, Oil Resistance

Applications
Automotive, General Purpose

Regional Availability
North America