

NYLENE® 4114 BK SP DSD

PA66

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Melt Flow Index, MFI	4.8	g/10min	ASTM D 1238
Mechanical properties			
ASTM Data			
Tensile Strength	45.2	MPa	ASTM D 638
Flexural Modulus	1655	MPa	ASTM D 790
Izod Impact notched, 1/8 in	849	J/m	ASTM D 256
Thermal properties			
ASTM Data			
DTUL @ 264 psi	60	°C	ASTM D 648
Melting Temperature	250	°C	ASTM D 3418
Other properties			
Density	1100	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	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

Delivery form

Black

Special Characteristics

High impact or impact modified

Applications

Automotive, General Purpose

Regional Availability

North America