

NYLENE® 4114 HS BK ISO

PA66

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ISO Data			
Melt flow index, MFI	5	g/10min	ISO 1133
Mechanical properties			
ISO Data			
Tensile Modulus	1870	MPa	ISO 527
Tensile Strength	48	MPa	ISO 527
Strain at break	50	%	ISO 527
Flexural modulus, 23°C	1660	MPa	ISO 178
Thermal properties			
ISO Data			
Melting temperature, 10°C/min	256	°C	ISO 11357-1/-3
Other properties			
Density	1090	kg/m ³	ISO 1183
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

Applications

Automotive, General Purpose

Delivery form

Black

Regional Availability

North America

Special Characteristics

High impact or impact modified, Heat stabilized or stable to heat