

NYLENE® 4120 HS

PA66

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.014	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	46.2	MPa	ASTM D 638
Flexural Modulus	1703	MPa	ASTM D 790
Izod Impact notched, 1/8 in	801	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	63.9	°C	ASTM D 648
Melting Temperature	252	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	1080	kg/m ³	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

Regional Availability

North America

Special Characteristics

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