

NYLENE 406

PA6

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.012	mm/mm	ASTM D 955
Mechanical properties			
ASTM Data			
Tensile Strength	75.2	MPa	ASTM D 638
Flexural Modulus	2482	MPa	ASTM D 790
Izod Impact notched, 1/8 in	42.7	J/m	ASTM D 256
Thermal properties			
ASTM Data			
UL 94 Flame rating	V-2	-	UL 94
Thickness tested	1.47	mm	-
DTUL @ 66 psi	182	°C	ASTM D 648
DTUL @ 264 psi	60	°C	ASTM D 648
Melting Temperature	220	°C	ASTM D 3418
Other properties			
Density	1130	kg/m ³	ASTM D 792
Processing Recommendation Injection Molding			
Pre-drying - Temperature	66 - 82	°C	-
Pre-drying - Time	2 - 4	h	-
Processing humidity	≤0.2	%	-
Melt temperature	238 - 271	°C	-
Mold temperature	49 - 93	°C	-
Zone 1	221 - 249	°C	-
Zone 2	227 - 260	°C	-
Zone 3	238 - 271	°C	-
Nozzle temperature	238 - 271	°C	-
Injection pressure	4 - 12	MPa	-
Back pressure	0 - 50	MPa	-
Holding pressure	3 - 9	MPa	-
Maximum residence time	6	min	-

Characteristics**Applications**

General Purpose

Regional Availability

North America