

**NYLENE® 5225**

PA6-GF25

Polymeric Resources Corporation

| <b>Mechanical properties</b> | <b>Value</b> | <b>Unit</b> | <b>Test Standard</b> |
|------------------------------|--------------|-------------|----------------------|
| <b>ASTM Data</b>             |              |             |                      |
| Tensile Modulus              | <b>5578</b>  | MPa         | ASTM D 638           |
| Tensile Strength             | <b>104</b>   | MPa         | ASTM D 638           |
| Flexural Modulus             | <b>5047</b>  | MPa         | ASTM D 790           |
| Izod Impact notched, 1/8 in  | <b>48</b>    | J/m         | ASTM D 256           |

| <b>Thermal properties</b> | <b>Value</b> | <b>Unit</b> | <b>Test Standard</b> |
|---------------------------|--------------|-------------|----------------------|
| <b>ASTM Data</b>          |              |             |                      |
| Melting Temperature       | <b>216</b>   | °C          | ASTM D 3418          |

| <b>Other properties</b> | <b>Value</b> | <b>Unit</b>       | <b>Test Standard</b> |
|-------------------------|--------------|-------------------|----------------------|
| Density                 | <b>1310</b>  | kg/m <sup>3</sup> | ASTM D 792           |

| <b>Processing Recommendation Injection Molding</b> | <b>Value</b>     | <b>Unit</b> | <b>Test Standard</b> |
|--|------------------|-------------|----------------------|
| Pre-drying - Temperature                           | <b>66 - 82</b>   | °C          | -                    |
| Pre-drying - Time                                  | <b>2 - 4</b>     | h           | -                    |
| Processing humidity                                | <b>≤0.2</b>      | %           | -                    |
| Melt temperature                                   | <b>288 - 302</b> | °C          | -                    |
| Mold temperature                                   | <b>49 - 93</b>   | °C          | -                    |
| Zone 1   | <b>249 - 277</b> | °C          | -                    |
| Zone 2   | <b>260 - 288</b> | °C          | -                    |
| Zone 3   | <b>271 - 299</b> | °C          | -                    |
| Nozzle temperature                                 | <b>271 - 299</b> | °C          | -                    |
| Injection pressure                                 | <b>8 - 18</b>    | MPa         | -                    |
| Back pressure                                      | <b>0 - 50</b>    | MPa         | -                    |
| Holding pressure                                   | <b>6 - 15</b>    | MPa         | -                    |
| Maximum residence time                             | <b>6</b>         | min         | -                    |

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America