

NYLENE® 411

PA66

Polymeric Resources Corporation

Processing/Physical Characteristics	Value	Unit	Test Standard
ASTM Data			
Mold Shrinkage, MD	0.012	mm/mm	ASTM D 955

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	53.8	MPa	ASTM D 638
Elongation at Break	45	%	ASTM D 638
Flexural Modulus	2020	MPa	ASTM D 790
Izod Impact notched, 1/8 in	187	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 264 psi	54.4	°C	ASTM D 648
Melting Temperature	254	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	1110	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

Applications

Building Construction

Special Characteristics

High impact or impact modified

Regional Availability

North America