

NYLENE 323

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	51	MPa	ASTM D 638
Flexural Modulus	651.6	MPa	ASTM D 790
Izod Impact notched, 1/8 in	934	J/m	ASTM D 256
Thermal properties			
ASTM Data			
Melting Temperature	222	°C	ASTM D 3418
Other properties			
Density	1080	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	249 - 282	°C	-
Mold temperature	49 - 93	°C	-
Zone 1	227 - 260	°C	-
Zone 2	238 - 271	°C	-
Zone 3	249 - 282	°C	-
Nozzle temperature	249 - 282	°C	-
Injection pressure	7 - 15	MPa	-
Back pressure	0 - 50	MPa	-
Holding pressure	5 - 12	MPa	-

Characteristics**Processing**

Injection Molding, Pipe/Tube Extrusion, Profile Extrusion

Applications

Automotive

Special Characteristics

High impact or impact modified

Regional Availability

North America