

NYLENE 406F

PA6

Polymeric Resources Corporation

Mechanical properties	Value	Unit	Test Standard
ASTM Data			
Tensile Strength	75.2	MPa	ASTM D 638
Flexural Modulus	2758	MPa	ASTM D 790
Izod Impact notched, 1/8 in	42.7	J/m	ASTM D 256

Thermal properties	Value	Unit	Test Standard
ASTM Data			
DTUL @ 66 psi	182	°C	ASTM D 648
DTUL @ 264 psi	71.1	°C	ASTM D 648
Melting Temperature	216	°C	ASTM D 3418

Other properties	Value	Unit	Test Standard
Density	1130	kg/m ³	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
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**Processing**

Injection Molding

Certifications

Food contact, Food approval FDA 21 CFR, Food approval NSF 51

Applications

General Purpose, Packaging

Regional Availability

North America