



QR-9066

Nylon 6/6

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Appearance	<u>General Description</u> Natural/Black Color Custom Colors Available
Features Filler/Additive	N/A N/A

<u>Property</u>	<u>Method</u>	<u>Value</u>	<u>Unit</u>
<i>-Physical</i>			
Specific Gravity	ASTM D792	1.13	
Melting Point		513	°F
<i>-Mechanical</i>			
Flexural Modulus	ASTM D790	396,000	psi
Notched Izod Impact, 73°F	ASTM D256	1.0	ft.lbs/in
Tensile Strength @ Break	ASTM D638	11,200	psi
Tensile Elongation @ Break	ASTM D638	40	%
<i>-Thermal</i>			
Deflection Temp @ 264 psi	ASTM D648	160	°F

These test results are based on reliable procedures. Due to variable conditions and methods of processing, no guarantees or warranties are expressed or implied including the implied warranty of merchantability and fitness for particular use. The above information is not to be construed as a license or a recommendation to infringe on any patents.

-Injection Molding

Drying Conditions

Min 2 hours – Max 4 hours	140	°F
Cylinder		
Rear	500-550	°F
Middle	500-550	°F
Front	520-550	°F
Nozzle	530-580	°F
Mold		
Maximum	200	°F
Minimum	150	°F
Processing Temp	530-580	°F
Maximum Moisture Content	0.2	%

ISO9001:2000 Registered



The guidelines listed above are based on specimens at various thicknesses typical in manufacturing. These values are not intended to be used for specification purposes. These are recommended starting parameters. The equipment part design and tooling will influence final process parameters. The percent recycle is dependent on part design, wall thickness, process, and final performance requests.