

## UBE NYLON 6434T1

### Technical Product Information: Monofilament properties

UBE NYLON 6434T1 (TERPALEX®) is a high viscosity modified Polyamide 6/6.6/12 terpolymer for monofilament application, suitable for small and large diameter size where superior line and knot tenacity are requested. This material has the following features:

- Outstanding processability and low melting point
- Superior line strength and tenacity
- Outstanding optical properties

Basic Properties <sup>(1)</sup>	Method	Unit	Value
<b>Polymer</b>	-	-	PA6/6.6/12
<b>Melting Point</b>	ISO 11357	°C	188
<b>Relative Viscosity (96% H<sub>2</sub>SO<sub>4</sub>)</b>	JIS K6810	-	4,05
<b>Density</b>	DIN 53479	g/cm <sup>3</sup>	1,14

Mechanical Properties <sup>(2)</sup>		Unit	Value
<b>Mechanical properties of monofilament d = 0,3mm</b>			
<b>Draw ratio (G3/G1)</b>		<b>4,5</b>	<b>5,0</b>
<b>Line</b>	Strength	g/d	5,0 - 6,0
	Tenacity	kg	3,0 - 4,0
	Elongation	%	60 - 70
<b>Tensile modulus</b>	g/d	10 - 14	12 - 16
<b>Knot</b>	Strength	g/d	5,0 - 6,0
	Tenacity	kg	3,5 - 4,5
	Elongation	%	60 - 70
<b>Mechanical properties of monofilament d = 2,0mm</b>			
<b>Draw ratio (G3/G1)</b>		<b>4,5</b>	<b>5,0</b>
<b>Line</b>	Strength	g/d	3,5 - 4,5
	Tenacity	kg	130 - 150
	Elongation	%	45 - 55
<b>Tensile modulus</b>	g/d	14 - 18	16 - 20
<b>Knot</b>	Strength	g/d	2,0 - 3,0
	Tenacity	kg	80 - 100
	Elongation	%	30 - 40



(1) Measured on base resin  
(2) All tests carried out on monofilaments produced with a 35mm screw  
Extrusion temperatures between 240-275°C  
Quench bath temperature: 15°C  
Drawing temperature: 1<sup>st</sup> = 95°C (hot water); 2<sup>nd</sup> = 180°C; Heat set = 180°C  
Relaxation ratio (G4/G3) = 1; Line speed (G4) = 28 m·min<sup>-1</sup>  
Sample conditioning and testing conditions: T = 23°C, RH = 50%

## Processing conditions

		Extruder				Adaptor	Die
		Hopper	Zone 1	Zone 2	Zone 3	Zone 4	
Temperature (°C)	40 - 120	180 - 200	200 - 220	210 - 230	220 - 240	230 - 250	230 - 250
		Quenching bath		1 <sup>st</sup> drawing	2 <sup>nd</sup> drawing	Heat setting	
Temperature (°C)	8 - 15		90 - 100		160 - 180	160 - 180	

## Drying conditions

UBE NYLON is supplied dry (moisture content < 0,1%) and packed in high barrier films. However, as polyamide is a hygroscopic material, the user should take a special care of the possible moisture absorption once the bag or liner box has been opened. In case of moisture absorption, the material should be dried with dehumidified air at 80°C for more than 4 hours.

## Storage

Well-sealed packages could be stored in cool and dry conditions over long periods of time. Protect the packages from heat and direct sunlight to prevent possible damages.

