



## Grade: PA6-1000N Black

Molding Grade PA 6

### Typical Material Properties

| Physical                              | Nominal Values | ASTM Test |
|---------------------------------------|----------------|-----------|
| Specific Gravity                      | 1.14           | D792      |
| <b>Mechanical</b>                     |                |           |
| Tensile Strength @ Yield              | 10,500 psi     | D638      |
| Flexural Modulus                      | 410,000 psi    | D790      |
| <b>Impact</b>                         |                |           |
| Notched Izod Impact (73 °F, 0.125 in) | 1.0 ft-lb/in   | D256      |
| <b>Thermal</b>                        |                |           |
| Melting Temperature                   | 424 °F         | D3418     |

### Recommended Processing Guidelines

|                               | Nominal Values       |
|-------------------------------|----------------------|
| Drying Time and Temperature   | 2-6 hrs at 176-185°F |
| Suggested Max Moisture        | <0.20%               |
| Rear Temperature              | 428 – 464 °F         |
| Middle Temperature            | 464 – 491 °F         |
| Front Temperature             | 464 – 500 °F         |
| Nozzle Temperature            | 464 – 491 °F         |
| Processing (Melt) Temperature | 440 – 530 °F         |
| Mold Temperature              | 150 – 220 °F         |