



**Grade: PA6-2000 Natural**

Molding Grade PA 6 in Natural Only

**Typical Material Properties**

Physical	Nominal Values	ASTM Test
Specific Gravity	1.14	D792
<b>Mechanical</b>		
Tensile Strength @ Yield	11,000 psi	D638
Flexural Modulus	400,000 psi	D790
<b>Impact</b>		
Notched Izod Impact (73 °F, 0.125 in)	0.9 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