



**Product Data Sheet &
General Processing Conditions**

**RTP PA6 L BLK
Nylon 6 (PA)
Value Product
Lubricated
Heat Stabilized**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE	English	SI Metric	ASTM TEST
Specific Gravity	1.13	1.13	D 792
Molding Shrinkage 1/8 in (3.2 mm) section	0.0100 - 0.0200 in/in	1.00 - 2.00 %	D 955

MECHANICAL

Impact Strength, Izod notched 1/8 in (3.2 mm) section	0.8 ft-lbs/in	43 J/m	D 256
unnotched 1/8 in (3.2 mm) section	No Break	No Break	D 4812
Tensile Strength	9500 psi	66 MPa	D 638
Tensile Elongation	> 10.0 %	> 10.0 %	D 638
Tensile Modulus	0.45 x 10 ⁶ psi	3103 MPa	D 638
Flexural Strength	14000 psi	97 MPa	D 790
Flexural Modulus	0.40 x 10 ⁶ psi	2758 MPa	D 790

THERMAL

Deflection Temperature @ 264 psi (1820 kPa)	160 °F	71 °C	D 648
Ignition Resistance* Flammability**	V-2 @ 1/32 in	V-2 @ 0.8 mm	D 3801

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

	English	SI Metric
Injection Pressure	10000 - 15000 psi	69 - 103 MPa
Melt Temperature	470 - 535 °F	243 - 279 °C
Mold Temperature	130 - 200 °F	54 - 93 °C
Drying	2 hrs @ 180 °F	2 hrs @ 82 °C
Moisture Content	0.20 %	0.20 %
Dew Point	0 °F	-18 °C

PROCESSING NOTES

Desiccant Type Dryer Required.

20 Feb 2006 NPB

complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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