



CP06-N0003

Polyamide 6

High Flow, General Purpose

5401 N Hwy 41 / Suite 1000 Evansville, IN 47711 • Phone: 812.426.1350 • FAX: 888.855.3671 • www.cpptech.com

Physical	Method	Typical Value	Units
Specific Gravity	ASTM D792	1.13	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.012	in/in

Impact

Notched Izod Impact (.125 in) 73°F	ASTM D256	1.0	ft-lbs/in
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Mechanical

Tensile Strength @ Yield	ASTM D638	11,200	psi
Tensile Elongation @ Break	ASTM D638	60	%
Flexural Strength	ASTM D790	15,200	psi
Flexural Modulus	ASTM D790	400,000	psi

Thermal

Deflection Temperature Under Load .250 in, 66 psi	ASTM D648	350	°F
.250 in, 264 psi	ASTM D648	150	°F

Information provided is based on typical values from reliable procedures. Values are based on natural or black materials unless otherwise noted. No guarantees or warranties of any kind are expressed or implied. Users are responsible for determining the suitability of the product for their intended application.

Recommended Processing Parameters

Drying Temperature	180°F
Drying Time	3.0 - 4.0 Hours
Suggested Maximum Moisture Content	0.15%
Rear Temperature	470 - 510 °F
Middle Temperature	480 - 520 °F
Front Temperature	490 - 530°F
Nozzle Temperature	490 - 530°F
Processing (Melt) Temperature	460 - 530°F
Mold Temperature	150 - 180°F

CPPT recommended processing parameters are meant to serve as guidelines only and are not intended to be used for specification purposes. Conditions should be adjusted to optimize material performance with the equipment part design and tooling.