CP06-N0017

Polyamide 6

High Flow, Heat Stabilized, Nucleated

CrossPoint Polymer Technologies

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Physical	Method	Typical Value	Units
Specific Gravity	ASTM D792	1.13	
Mold Shrink, Linear Flow (.125 in)	ASTM D955	0.009	in/in
Impact			
Notched Izod Impact (.125 in)			
73°F	ASTM D256	0.8	ft-lbs/in
Mechanical			
Tensile Strength @ Yield	ASTM D638	12,500	psi
Tensile Elongation @ Break	ASTM D638	10	%
Flexural Strength	ASTM D790	15,500	psi
Flexural Modulus	ASTM D790	440,000	psi
Thermal			
Deflection Temperature Under Load			
.250 in, 66 psi	ASTM D648	370	°F
.250 in, 264 psi	ASTM D648	165	°F

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.