

Rhelon X1000L-00

Polyamide 6

RheTech, Inc.

Message:

Rhelon X1000L-00 is a Polyamide 6 (Nylon 6) product. It can be processed by injection molding and is available in North America. Primary characteristic: lubricated.

General Information			
Additive	Lubricant		
Features	Lubricated		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
Melt Mass-Flow Rate (MFR) (235°C/1.0 kg)	7.3	g/10 min	ASTM D1238
Molding Shrinkage - Flow	1.4 to 1.8	%	ASTM D955
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	79.3	MPa	ASTM D638
Tensile Elongation			ASTM D638
Yield	5.0	%	
Break	50	%	
Flexural Modulus	2860	MPa	ASTM D790
Flexural Strength	103	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	53	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			ASTM D648
0.45 MPa, Unannealed	185	°C	
1.8 MPa, Unannealed	92.2	°C	
Peak Melting Temperature	216	°C	ASTM D789
CLTE - Flow	6.2E-6	cm/cm/°C	ASTM D696
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Suggested Max Moisture	0.20	%	
Suggested Max Regrind	25	%	
Rear Temperature	255 to 265	°C	
Middle Temperature	265 to 270	°C	
Front Temperature	270 to 275	°C	
Nozzle Temperature	275 to 280	°C	

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