

RTP 2899 X 106530 N

Thermoplastic Polyolefin Elastomer

RTP Company

Message:

Nylon 6 Overmolding - UV Stabilized

General Information			
Additive	UV stabilizer		
Uses	overmolding		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.970	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.6 - 1.8	%	ASTM D955
Moisture Content		%	
Peel strength-Nylon 6 ¹	4.4	kN/m	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	50		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
50% strain, 3.18mm ²	1.17	MPa	ASTM D412
100% strain, 3.18mm ³	1.59	MPa	ASTM D412
300% strain, 3.18mm ⁴	3.03	MPa	ASTM D412
Tensile Strength ⁵ (Break, 3.20 mm)	3.45	MPa	ASTM D412
Tensile Elongation ⁶ (Break)	500	%	ASTM D412
Tear Strength ⁷	15.8	kN/m	ASTM D624
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 3.0	hr	
Processing (Melt) Temp	216 - 249	°C	
Mold Temperature	48.9 - 65.6	°C	
Injection Pressure	27.6 - 55.2	MPa	
Injection instructions			
Desiccant Type Dryer Required.			
NOTE			
1.	90°, 20 in/min, RTP 55, Interface Failure		
2.	C mold, 510mm/min		
3.	Mouth die C, 510mm/min		
4.	C mold, 510mm/min		

5.	C mold, 500 mm/min
6.	Mouth die C, 500 mm/min
7.	C mould

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