

# Rhelon X1500-00

Polyamide 6  
RheTech, Inc.

Message:

Rhelon X1500-00 is a Polyamide 6 (Nylon 6) product. It can be processed by injection molding and is available in North America.

| General Information               |                   |                   |             |
|-----------------------------------|-------------------|-------------------|-------------|
| Appearance                        | Natural Color     |                   |             |
| Processing Method                 | Injection Molding |                   |             |
| Physical                          | Nominal Value     | Unit              | Test Method |
| Specific Gravity                  | 1.15              | g/cm <sup>3</sup> | ASTM D792   |
| Molding Shrinkage - Flow          | 1.4 to 1.8        | %                 | ASTM D955   |
| Mechanical                        | Nominal Value     | Unit              | Test Method |
| Tensile Strength                  | 55.7              | MPa               | ASTM D638   |
| Tensile Elongation                |                   |                   | ASTM D638   |
| Yield                             | 4.0               | %                 |             |
| Break                             | 13                | %                 |             |
| Flexural Modulus                  | 2450              | MPa               | ASTM D790   |
| Flexural Strength                 | 75.8              | MPa               | ASTM D790   |
| Impact                            | Nominal Value     | Unit              | Test Method |
| Notched Izod Impact (23°C)        | 35                | 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                  | 218 to 235        | °C                |             |
| Middle Temperature                | 229 to 252        | °C                |             |
| Front Temperature                 | 241 to 260        | °C                |             |
| Nozzle Temperature                | 241 to 266        | °C                |             |
| Processing (Melt) Temp            | 241 to 266        | °C                |             |

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