

RTP 2899 X 106530 A

Polyamide 6

RTP Company

Message:

Nylon 6 Overmolding

General Information			
Uses	overmolding		
RoHS Compliance	Contact manufacturer		
Processing Method	Injection molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.980	g/cm ³	ASTM D792
Molding Shrinkage - Flow (3.20 mm)	1.3 - 1.7	%	ASTM D955
Moisture Content		%	
Peel strength-Nylon 6 ¹	3.2	kN/m	
Hardness	Nominal Value	Unit	Test Method
Durometer Hardness (Shore A, 10 sec)	45		ASTM D2240
Elastomers	Nominal Value	Unit	Test Method
Tensile Stress			ASTM D412
50% strain, 3.18mm ²	1.03	MPa	ASTM D412
100% strain, 3.18mm ³	1.38	MPa	ASTM D412
300% strain, 3.18mm ⁴	2.55	MPa	ASTM D412
Tensile Strength ⁵ (Yield, 3.20 mm)	2.76	MPa	ASTM D412
Tensile Elongation ⁶ (Break)	360	%	ASTM D412
Tear Strength ⁷	14.0	kN/m	ASTM D624
Compression Set ⁸			ASTM D395B
23°C, 22 hr	17	%	ASTM D395B
70°C, 22 hr	39	%	ASTM D395B
Flammability	Nominal Value		Test Method
Flame Rating (1.50 mm, ** Values per RTP Company testing.)	HB		UL 94
Injection	Nominal Value	Unit	
Drying Temperature	79.4	°C	
Drying Time	2.0 - 4.0	hr	
Dew Point	-17.8	°C	
Processing (Melt) Temp	249 - 282	°C	
Mold Temperature	37.8 - 71.1	°C	
Injection Pressure	34.5 - 103	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
8.	Type 2

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Recommended distributors for this material

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