

Rhelon X1000-00

Polyamide 6

RheTech, Inc.

Message:

Rhelon X1000-00 is a Polyamide 6 (Nylon 6) product. It can be processed by injection molding and is available in North America.

General Information			
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.13	g/cm ³	ASTM D792
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	
Processing (Melt) Temp	241 to 266	°C	

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