

Nylene® 4214 HS

Polyamide 6
Custom Resins Group

Message:

Nylene® 4214 HS is a Polyamide 6 (Nylon 6) material. It is available in North America for extrusion or injection molding. Important attributes of Nylene® 4214 HS are:

- Heat Resistant
- Good Flexibility
- Heat Stabilizer
- Impact Modified
- Impact Resistant

General Information			
Additive	Heat Stabilizer		
	Impact Modifier		
Features	Good Flexibility		
	Good Thermal Stability		
	Heat Stabilized		
	High Heat Resistance		
	High Impact Resistance		
	Impact Modified		
Forms	Pellets		
Processing Method	Extrusion		
	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.09	g/cm ³	ASTM D792
Molding Shrinkage - Flow	1.4	%	ASTM D955
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength (Break, 23°C)	38.6	MPa	ASTM D638
Tensile Elongation (Break, 23°C)	200	%	ASTM D638
Flexural Modulus (23°C)	1030	MPa	ASTM D790
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact (23°C)	640	J/m	ASTM D256
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load (1.8 MPa, Unannealed)	43.3	°C	ASTM D648
Melting Temperature	216	°C	
Injection	Nominal Value	Unit	
Drying Temperature	65.6 to 82.2	°C	

Drying Time	2.0 to 4.0	hr
Drying Time, Maximum	4.0	hr
Suggested Max Moisture	0.20	%
Suggested Shot Size	25 to 75	%
Suggested Max Regrind	25	%
Rear Temperature	227 to 260	°C
Middle Temperature	238 to 271	°C
Front Temperature	249 to 282	°C
Nozzle Temperature	249 to 282	°C
Processing (Melt) Temp	249 to 282	°C
Mold Temperature	48.9 to 93.3	°C
Injection Pressure	48.3 to 103	MPa
Injection Rate	Fast	
Holding Pressure	34.5 to 82.7	MPa
Back Pressure	0.00 to 0.345	MPa

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Recommended distributors for this material

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