

Nylene® 2408 HSSP BK

TECHNICAL DATASHEET

TDS Ref # 76 Reviewed: 2/13/2018

DESCRIPTION

• Nylene 2408 HSSP BK is a modified nylon 6 with very good physical properties and excellent extrusion characteristics to support extrusion of very complex profiles. Especially useful for convoluted tubing.

PROPERTIES	TEST METHOD	UNIT	VALUE
PHYSICAL PROPERTIES			
Density	ISO 1183	g/cm ³	1.07
MECHANICAL PROPERTIES			
Elongation @ Break	ISO 527	(%)	125
Flexural Modulus	D790	kg/cm ²	1080
Notched Izod @ 23°C	ISO 180	kJ/m ²	26
Tensile Strength	ISO 527	MPa	40
THERMAL PROPERTIES			
DTUL @ 1800 kPa	ISO 75	°C	42
Melt Point	ISO 11357	°C (°F)	246

NOTES

• Testing conducted on dry-as-molded specimens at 73°F

PROCESSING CONSIDERATIONS: EXTRUSION IMPACT MODIFIED

Zone °F (°C)	Feed	450-470 (232-243)	Residence Time: Screw should not be left idle for more than 3-4 minutes with melt in the barrel. Excess residence will be visible as black carbon specs in the melt.
	Transition	470-500 (243-260)	Regrind Level: Typically, up to 25% is recommended but higher levels are possible with little or no effect on flow and finish.
	Metering	490-530 (254-277)	Drying Temperature: Although Nylene resins are packaged and delivered in a low moisture state, it is good material handling practice to use a hopper dryer to maintain dryness. Should pre-drying be necessary, use settings of 180 °F (82.2°C) air at dew point of -40 at a rate of 1 cu. ft. / hour per pound of resin and a residence time of 2-4 hours.
	Die	490-530 (254-277)	
	Melt Temp.	490-530 (254-277)	Cooling and Sizing: While both air and water can be used as the cooling medium, air is preferred. The use of air allows additional time for sizing and reduces residual stress. This aids in reducing warpage, especially in profiles with varying wall sections. If water is used, heat the first section to above 100 °F (38°C) to reduce quenching and residual stress.
Line Rate	2 ½" extruder	1.5 - 1.9 pph/rpm	
	3 ½" extruder	3.5 - 4.5 pph/rpm	Die Design: Draw down of 30% is typical for all dimensions except wall thickness.
	4 ½" extruder	6.5 - 7.5 pph/rpm	Land length: should be around 10x wall thickness.

CHARACTERISTICS

Resin Type: Nylon 6
Product Characteristics:
Impact Modified, Flex Modified,
Copolymer

EXTRUSION PROCESSING

Tubing & Profile

AUTOMOTIVE SPECIFICATION

- M2170
- ASTM D4066-01a PA0283

DISCLAIMER

The data set forth herein has been carefully compiled by Nylene in our laboratories. Values shown are typical properties and not specifications. Since processing variables will affect properties, the reproducibility of our data in a customer's testing facility is not guaranteed. There is no warranty of any kind, either expressed or implied, applicable to the use of this information, and the user assumes all risk and liability in connection therewith.



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