

Nylene® 8100

TECHNICAL DATASHEET

TDS Ref # 160 Reviewed: 10/28/2014

DESCRIPTION

- Nylon 6/12 molding resin with excellent flexibility and lower moisture absorption

| PROPERTIES | TEST METHOD | UNIT | VALUE |
|------------------------------|-------------|--------------------|----------------|
| PHYSICAL PROPERTIES | | | |
| Mold Shrinkage | n/a | in/in | 0.011 |
| Specific Gravity | D792 | n/a | 1.07 |
| MECHANICAL PROPERTIES | | | |
| Elongation | D638 | % | 50 |
| Flexural Modulus | D790 | psi (MPa) | 275,000 (1895) |
| Notched Izod @ 23°C | D256 | ft. lb./ in. (J/m) | 0.6 (32) |
| Tensile Strength | D638 | psi (MPa) | 9,000 (62) |
| THERMAL PROPERTIES | | | |
| DTUL @ 264 psi/1.82 MPa | D648 | °F (°C) | 127 (51) |
| Melt Point | D3418 | °F (°C) | 435 (224) |

NOTES

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

PROCESSING CONSIDERATIONS: SPECIALTY SPECIALTY 6/12

Processing Conditions: Specialty 6/12 Melt Temperature 150-250 °F (65.6-121°C), highly filled grades require >175 °F (80°C) to obtain the best overall surface appearance. Residence Time should not exceed 6 minutes, less with higher melt temps. Shot Size should be between 25-75% of barrel capacity. Fill Rate: fast fill rates are suggested for best surface appearance. Regrind Level typically no more than 25% is recommended, with higher levels possible for unfilled grades depending on the end use requirements. Make certain regrind is properly dried to virgin moisture levels. Drying Temperature 150-180 °F (66-82°C) for 2-4 hours

CHARACTERISTICS

Resin Type: Nylon 6/12
 Product Characteristics:
 Unreinforced, Copolymer

INJECTION MOLDING PROCESSING

Prime Grade

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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