

Nylene® PAC690-130HSL

TECHNICAL DATASHEET

TDS Ref # 955 Reviewed: 8/10/2017

DESCRIPTION

- Nylene PAC690-130HSL is a high viscosity, heat stabilized, extrusion grade, nylon 6/66 copolymer with a special lubrication package to enhance antiblock properties.
- Optimum processing conditions should permit for a melt temperature of approximately 500°F at the die.

PROPERTIES	TEST METHOD	UNIT	VALUE
PHYSICAL PROPERTIES			
Relative Viscosity	ISO 307	Sulfuric Acid	3.9
	D789	Formic Acid	130
Specific Gravity	D792	n/a	1.11
MECHANICAL PROPERTIES			
Elongation	D638	%	250
Flexural Modulus	D790	psi (MPa)	319,000 (2,200)
Notched Izod	D256	J/m (ft. Lb./ in.)	60 (1.1)
Tensile Strength	D638	psi (MPa)	9,425 (65)
THERMAL PROPERTIES			
Melt Point	D3418	°F (°C)	374 (190)

NOTES

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

PROCESSING CONSIDERATIONS: EXTRUSION HIGH VISCOSITY

Zone °F (°C)	Feed	500-530 (260-277)	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	520-560 (271-293)	Regrind Level: Typically, up to 25% is recommended but higher levels are possible with little or no effect on flow and finish.
	Metering	550-575 (288-302)	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	550-575 (288-302)	
	Melt Temp.	550-575 (288-302)	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 6/6/6
 Product Characteristics:
 Copolymer, Lubricated, Heat Stabilized,
 High RV

EXTRUSION PROCESSING

Film

FEATURES

- Good Abrasion Resistance
- High Strength

MARKETS USED

- Packaging Industry
- Lawn and Garden
- Extrusion

APPLICATIONS

- Fishing Line
- Monofilament
- Netting
- Sewing Thread
- Trimmer Line
- Weaving Thread

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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