



**Product Data Sheet &
General Processing Conditions**

**RTP PA6 HI BLK
Nylon 6 (PA)
Impact Modified
Heat Stabilized
Value Product**

PROPERTIES & AVERAGE VALUES OF INJECTION MOLDED SPECIMENS

PERMANENCE		STANDARD
Density	1.10 g/cm ³	ISO 1183
Shrinkage, 4 mm Thickness Flow direction	1.00 - 2.00 %	ISO 294-4
MECHANICAL		
Impact Strength, Izod Notched, 4 mm thickness	16 kJ/m ²	ISO 180/1A
Unnotched, 4 mm thickness	60 kJ/m ²	ISO 180/1U
Tensile Strength	50 MPa	ISO 527
Tensile Elongation	> 10.0 %	ISO 527
Tensile Modulus	2500 MPa	ISO 527
Flexural Strength	80 MPa	ISO 178
Flexural Modulus	2200 MPa	ISO 178
THERMAL		
Ignition Resistance* Flammability**	HB @ 1.5 mm	ISO 1210

PROPERTY NOTES

Data herein is typical and not to be construed as specifications.

Unless otherwise specified, all data listed is for natural or black colored materials. Pigments can affect properties.

* This rating is not intended to reflect hazards of this or any other material under actual fire conditions.

** Values per RTP Company testing.

GENERAL PROCESSING FOR INJECTION MOLDING

Injection Pressure	70 - 105 MPa
Injection Pressure	680 - 1030 bar
Melt Temperature	245 - 280 °C
Mold Temperature	55 - 95 °C
Drying	2 hrs @ 80 °C
Moisture Content	0.20 %
Dew Point	-25 °C

PROCESSING NOTES

Desiccant Type Dryer Required.

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This information is intended to be used only as a guideline for designers and processors of modified thermoplastics. Because design and processing is complex, a set solution will not solve all problems. Observation on a "trial and error" basis may be required to achieve desired results.

Data are obtained from specimens molded under carefully controlled conditions from representative samples of the compound described herein. Properties may be materially affected by molding techniques applied and by the size and shape of the item molded. No assurance can be implied that all molded articles will have the same properties as those listed.

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