

## GRADE: PA6-0050G NATURAL

Molding Grade PA 6 w/ 50% glass reinforcement

### Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.45	D792
<b>Mechanical</b>		
Tensile Strength @ Yield	28,000 psi	D638
Flexural Modulus	2,000,000 psi	D790
Flexural Strength @ Yield	35,000 psi	D790
Elongation @ Break	3.0 %	
<b>Impact</b>		
Izod Impact (73 °F, 0.125 in)	22.0 ft-lb/in	D256
<b>Thermal</b>		
DTUL @ 264 psi-unannealed (0.125 in)	405 °F	D648
Melting Temperature	400 °F	D3418

The information provided above is based upon typical values and are intended only as guides. Star Plastics, LLC, assumes no obligation or liability for any advice furnished or for any results obtained with respect to this information. *No guarantees or warranties are expressed or implied.*

\*Orion® is a registered trademark of Star Plastics, LLC, its subsidiaries or affiliates.

### Recommended Processing Guidelines

	Nominal Values
Drying Time and Temperature	2-6 hrs at 176-185°F
Suggested Max Moisture	<0.20%
Rear Temperature	428 – 464 °F
Middle Temperature	464 – 491 °F
Front Temperature	464 – 500 °F
Nozzle Temperature	464 – 491 °F
Processing (Melt) Temperature	440 – 530 °F
Mold Temperature	150 – 220 °F

The conditions listed above are only guidelines. You may want to adjust conditions to meet your requirements.