

GRADE: PA6-1000N BLACK

Molding Grade PA 6

Typical Material Properties

Physical	Nominal Values	ASTM Test
Specific Gravity	1.14	D792
Mechanical		
Tensile Strength @ Yield	10,500 psi	D638
Flexural Modulus	410,000 psi	D790
Impact		
Notched Izod Impact (73 °F, 0.125 in)	1.0 ft-lb/in	D256
Thermal		
Melting Temperature	424 °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.*

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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.